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Heavy Duty Clutch Springs for Honda XR50 (Set of 4)
 Part # 010-3-04



Care & Cleaning / Warranty

Warranty

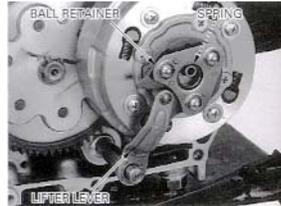
Two Brothers Racing products are intended for closed course competition purposes only, and therefore are sold "as is" without warranty. Two Brothers Racing specifically disclaims any warranties of merchantability or fitness for a particular purpose and disclaims all responsibility for consequential and incidental damages or any other losses arising from the use of these products or parts.

IMPORTANT - PLEASE READ CAREFULLY

We recommend that this performance accessory be installed by a qualified motorcycle technician. If you have any doubts as to your ability to install this performance accessory, please consult with your local motorcycle dealer. Read all instructions first before starting installation. Make sure the motorcycle and exhaust system are completely cool before starting the installation. Also, make sure the bike is secure on the sidestand or ideally a rear service stand during installation. Be sure to save all stock components for possible use later.

Installation Instructions

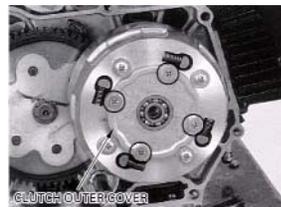
1. Make sure the bike is completely cool before starting the installation.
2. Drain engine oil. Remove footpeg bar. Remove kickstarter. Remove rear brake pedal. Remove the right side cover.
3. Remove the ball retainer and spring. Remove the clutch lifter lever.



Remove the oil through and spring. Remove the clutch lifter cam plate.



4. Remove the four bolts holding the clutch plate. Under this plate is the clutch locknut. Peel back the tab(s) on the lock washer. Remove this nut using either a Honda clutch locknut wrench or the Takegawa clutch locknut wrench (Part # 010-9-01-021, \$26.98 MSRP). A flywheel holder tool may help to remove this part.



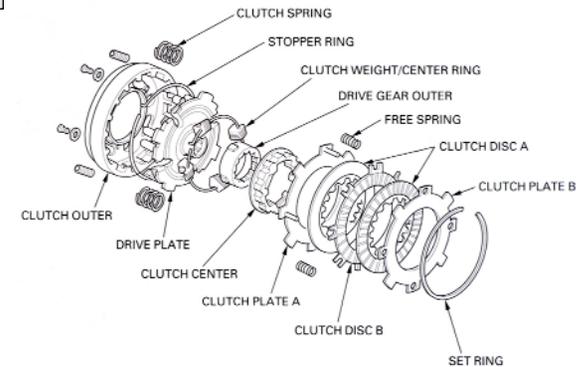
5. Remove the lock washer B, 14mm lock washer and clutch assembly.

6. Remove the following items from the clutch assembly:

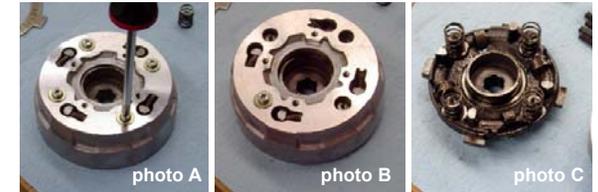


- Clutch Set Ring
- Clutch Plate B
- Clutch Disc A
- Clutch Disc B
- Clutch Disc A
- Free Springs (set of 4)
- Clutch Plate A

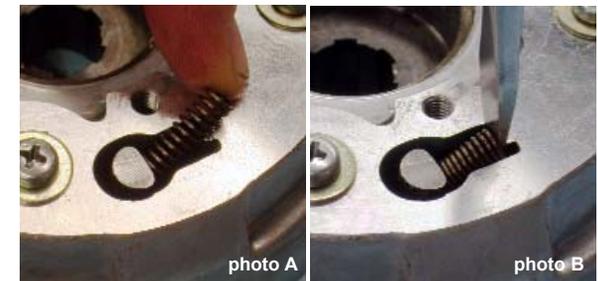
Next remove the clutch center and drive gear outer.



7. Remove the four phillips head screws and washers (photo A). Please not the once removed the four damper springs will drop down (photo B). Turn clutch assembly over and remove drive plate assembly and clutch springs (photo C).



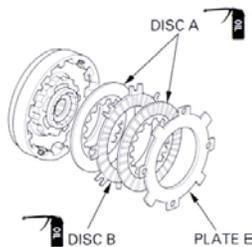
8. Install new heavy duty clutch springs onto drive plate assembly. Reinstall drive plate assembly/heavy duty clutch springs into clutch outer assembly.
9. Reinstall the four phillips head screws and washers. Tighten in a crisscross pattern in 2-3 steps. Torque screws to 4.3 lbs-ft. (6 Nm)
10. Reinstall damper springs (set of 4). Seat springs into spring seating hole, then use a flat head screwdriver to compress the springs and fit them onto the tabs.



11. Reinstall drive gear outer and clutch center.

12. Apply motor oil to disc A & B as shown in the diagram. Reinstall the following items from the clutch assembly:

- Clutch Plate A
- Free Springs (set of 4)
- Clutch Disc A
- Clutch Disc B
- Clutch Disc A
- Clutch Plate B



Install the clutch disc A with its flat surface facing the clutch disc B.

Install the clutch plate B with its chamfered side facing the clutch disc A.

13. Reinstall the clutch set ring with its chamfered side facing the clutch plate B.

14. Reinstall clutch assembly onto primary gear. ***Be sure to fully seat clutch assembly onto primary gear.***

15. Reinstall the 14mm lock washer, lock washer B (with its "OUT-SIDE" mark facing out) and lock nut. Using a flywheel holder torque lock nut to 31 lbs-ft (42 Nm). If the lock nut groove does not align with the lock washer tab further tighten the lock nut until aligned.

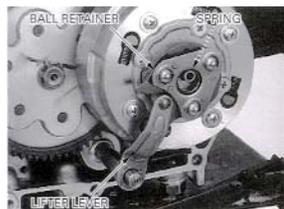
16. Reinstall clutch plate and torque screws to 3.6 lbs-ft (5 Nm).



17. Reinstall the oil through and spring. Reinstall the clutch lifter cam plate.

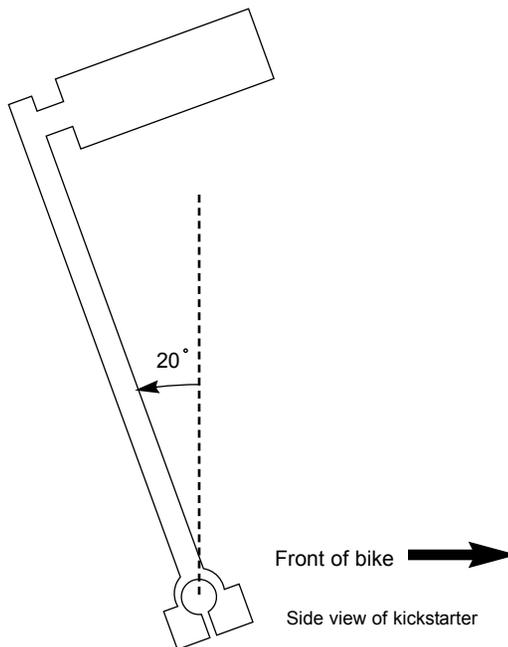


18. Reinstall the ball retainer and spring. Reinstall the clutch lifter lever.



19. Reinstall the following

- Right side cover
- Rear brake pedal (adjust free play)
- Kickstarter (see diagram for proper placement)
- Footpeg bar



20. Refill engine oil (.8 quart)

21. Before you run the bike, double check your work.

22. Start engine and let it idle for 2-3 minutes. Stop engine and inspect for any oil leaks. Double check oil level.