

HC-X patent pending

Installation instructions for The HC-X™ secondary clutch system for **Yamaha Secondary clutches.**

Provided in this kit are the following items

One wide roller spring cap

One multiradius Helix (patent pending). 38, 42, 46 or 50 degree angle, many multi-angles available 42/34,42/38,46/42,46/34 are popular.

Three 8x1.25x57mm studs

Three Stainless Steel M6x55mm long bolts

Three M6 nylock nuts

Three M6 round or Hex support nuts

- 1) Remove Secondary Clutch from the machine.
- 2) Remove Secondary spring and Helix.
- 3) Remove plastic buttons (use punch from the back side)
- 4) Remove three M8 studs that hold helix in place (use vise grip to loosen, these are lock tighten in place)
- 5) Remove three M6 Phillips headed bolts holding belt deflection plate onto clutch. These bolts are lock tighten in, use vise grip to loosen.

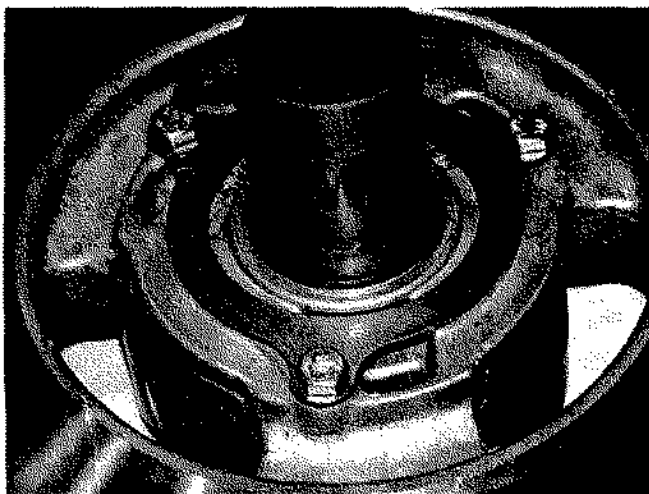


Figure #1

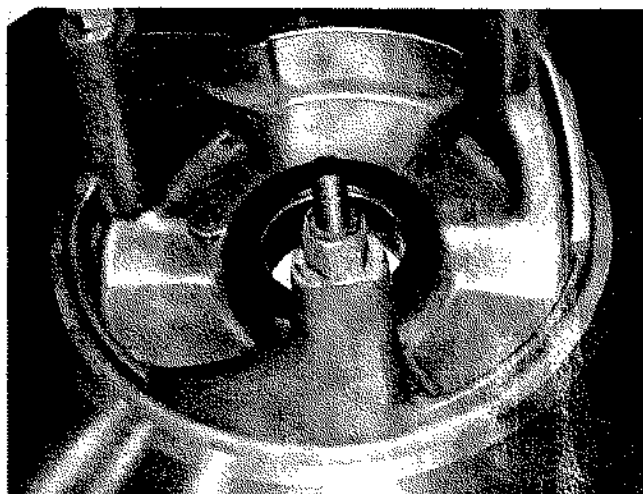


Figure #2

- 6) Install the three M6x55mm bolts securing the belt deflection plate. Use a blue or green lock tight. Torque to 15 ft-lbs. See figure #1.
- 7) Install M8x57mm studs (short end should be sticking out) .Torque the stud to 15 ft-lbs. See figure #2.
- 8) Install the helix by lining up studs with the holes in the helix. **First screw the M6 support nuts on the studs. The nuts should be screwed down 18.4mm from the top of the bolt to the top of the support nut. This will act as a base for the helix so it can not be over**