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## F55610 FBF CR250 Billet Clutch Basket assembly instructions

1. Start by removing the gear selector, and clutch cover



2. Next remove the bolts that hold the springs on.



3. Remove the pressure plate. Be sure to find the bearing and washer that is between the plate and the clutch bearing pusher (CBP).

Pressure Plate Side



4. Remove the clutch plates and clutch bearing pusher. Be sure to check the ball bearing is in the clutch bearing pusher.



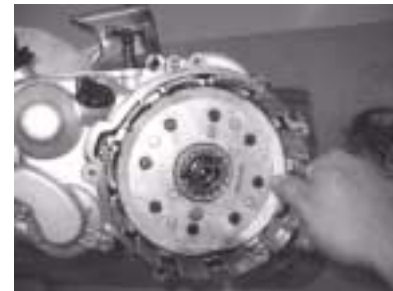
- Using special tool (Part Number 800039524) remove the nut and lock washer that holds the hub on. Then remove the hub.



- Remove the washer that is between the inner hub and basket.



- Remove the old clutch basket. Watch for the bearings that are on the shaft. They have a tendency of coming out with the basket.



- Next center punch the rivets in the old basket for drilling.



- Drill out the rivets with a 6mm or 1/4 inch drill bit.



- Remove the cover on the back side.



11. Now turn over the basket and push the gear out using your thumb.



12. Take the gear and the rubber and clean them free of all debris. Place the rubber on the back side of the new basket.



13. Now place the gear on the rubber. Be sure that the gear sits all the way down on the basket.



14. Place new cover on. Use a dab of red loctite when installing screws.



15. Use a center punch and peen the other end of the screws. This prevents the screws from backing out.



16. Be sure that you start with the washer. Install in the following order; washer, bearing, bearing and finally the new basket.



17. Reinstall the washer between the basket and hub. Next place the hub on the shaft. Install the lock washer and nut. Torque the nut to 32 lb-ft.

Washer



18. Replace the clutch pack into the basket and hub. Install the clutch bearing pusher and be sure that the ball bearing is inside.



19. Reinstall the bearing, washer and, pressure plate.



20. Replace the cover, gear selector and you are finished.

