



# Craig Silvers, **MOTORCYCLE DOCTOR LLC**

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## Wet Shoe Clutch Kit Replacement

HiSun 400,500,550,700,750

1. Remove large oval black plastic belt cover. Inspect for belt particles and recognize the belt top is just barely sticking above the edge of the Secondary clutch.
2. Drain oil and lines if oil is dark. Remove oil filter. Remove 4 leg Primary clutch bearing support, inspect its bearing and seal. Remove both M16 nuts. Only the Primary has a spacer washer.
3. Install (2) M6 long threaded bolts (some 400 are M5) in the center hub of the Secondary clutch to spread the sheaves to remove the belt. Leave bolts in hub.
4. Remove both clutches, back oval plastic cover and primary wet shoe engine cover. Pre-soak Wet Shoe Clutch in MA or MA2 10w40 motor oil for approx. 30 minutes.
5. Inspect inner surface of drum, replace if any wear. Remove engine cover seal to find and remove the Circlip, then slide out drum. Inspect large cover bearing. Clean off gasket surfaces, install new drum/shaft, re-use circlip and new oil seal.
6. Remove 1-Way bearing, M22 nut (unbend lock notch) and Wet Shoe Clutch.
7. Install new Wet Shoe Clutch, M22 Nut at 105 foot/lbs torque (3/4" air impact). Punch in the safety locking nut edge in crank cut out.
8. Slide 1-Way Bearing on wet clutch hub so the Letters/Numbers are pointing out, away from the crank. You should see these markings.
9. Install engine cover with new drum, seal and gasket. After installing the cover and M6 bolts, grab the drum shaft with a glove on and turn ignition key, with spark plug cap off, to make sure the shaft won't turn. This is a test to continue.
10. Inspect all of Primary Clutch, Roller Weights and slider bushings for wear on collar. Remove old grease from outer edge of housing, apply parts lightly with new grease to keep rollers in their ramps and install Cam Plate and Sheet metal cover. Install Sheave Plate, Center Collar Tube and the assembled housing making sure the Cam Plate has the shaft splines coming out, now add the spacer washer and M16 nut. Tighten to 85 ft./lbs. Do not allow the clutch head to move toward the fixed sheave plate.
11. Install 4 leg bearing support, Secondary Clutch with spread bolts still installed and install the belt. Remove the (2) spreader bolts and tighten the M16 to 75 ft./lbs.
12. Install new oil filter and MA2 10w40 oil, 1/2 way up the standard 3" plastic dip stick, just drop in and pull out, no threading in to check. Start engine and rev it up to watch belt go from a 1:3 ratio to a 3:1 ratio. Belt should move smoothly and the belt top is just barely sticking above the edge of the Secondary clutch. That is final test. Install oval cover. Stay in 'Low' below 20 MPH !