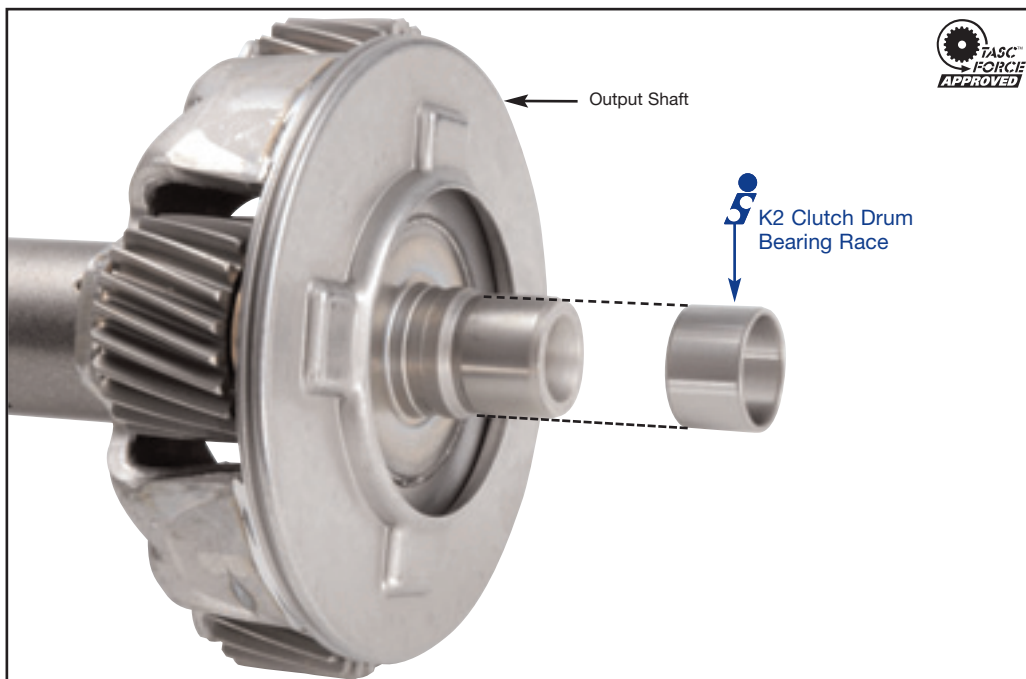


K2 Clutch Drum Bearing Race

68410-05

1 Bearing Race



INSTALLATION / ASSEMBLY STEPS:

1. Hard turn output shaft to specifications shown in Figure 1 on the following page. Shaft tolerances must be maintained to ensure proper operational clearances.
2. Remove any burrs.
3. Check fit of bearing race to shaft.
 - a. For slip fits, Loctite® race to shaft using Loctite® sleeve retainer #609 (or equivalent). Bearing race must butt up against shoulder.
 - b. For interference/press fits, the easiest way to fit the bearing race onto the shaft is by pre-heating the bearing race to 175-200° Fahrenheit in an oven. Lightly lubricate the seating surface of the shaft, using an arbor press and an arbor as shown in Figure 2 on the following page. Bearing race must butt up against shoulder.
4. After installation, check for correct operation of the bearing arrangement.

