

# TECHNICAL BULLETIN

DS7, R5's, RD250, RD350

CLUTCH, Elimination of Slipping

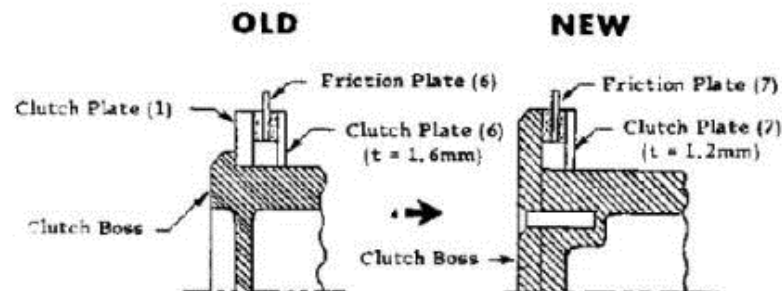
Clutch assemblies on above models have been redesigned to reduce clutch slippage. This change consists of replacing the clutch boss and clutch plates and increasing the number of friction plates from six (6) to seven (7). See table below for both old and new parts list.

REF. NO.	OLD ASSEMBLY PART NUMBERS	NEW ASSEMBLY PART NUMBERS	DESCRIPTION	NEW QTY.	REMARKS
5-2, 5-3*	278-16371-00	360-16371-00	BOSS, clutch	1	New part
5-3, 5-4*	214-16324-00	-----	PLATE, clutch 1	0	Deleted
5-4, 5-5*	168-16367-00	168-16367-00	RING, cushion	7	6 → 7
5-5, 5-6*	168-16321-00	168-16321-00	PLATE, friction	7	6 → 7
5-6, 5-7*	168-16325-00	360-16325-00	PLATE, clutch 2	7	6 → 7

\*RD250, RD350.  
NOTE: See also M/C PNB #363 for additional information.

## INSTALLATION INSTRUCTIONS

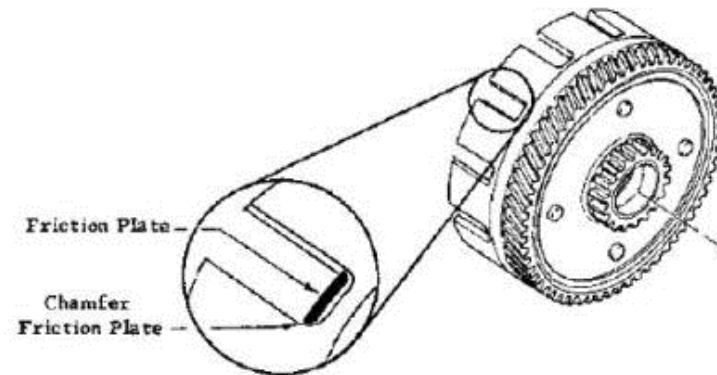
The clutch must be assembled with the first friction plate against clutch boss. See drawings below.



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CLUTCH, Elimination of Slipping (cont.)

When clutch is fully assembled with pressure plate and spring screws installed, check to see if first friction plate is touching clutch hub (Primary Driven Gear Complete). If friction plate is touching, it will be necessary to chamfer edges of friction plate to provide clearance. Do not remove metal from corners of clutch hub. See drawing below.



## AFFECTED MACHINES

The improved clutch assembly is installed on 1973 production units as follows:

RD250: E/N 104791 ~  
RD350: E/N 116081 ~

## WARRANTY INFORMATION

Standard warranty allowance will apply for machines having verified chronic clutch slippage problems during warranty period. Use Job Code #2600 at 1.0 hours.