



## 1996-2004 Suzuki RM250 Billet Clutch Basket

### 1. Remove basket

- Remove the pressure plate and The inner hub
- Remove the basket from the bike

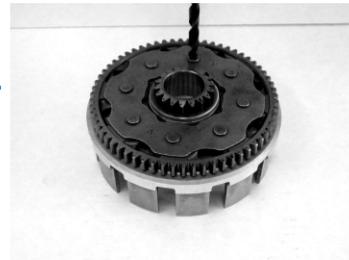


Figure 1

### 2. Remove gear

- Center punch the heads of the rivets on the backside of the basket and drill the head of the rivet off so the retainer plate can come off (Figure 1)
- Or you can grind the heads of the rivets off of the back of the basket to remove the retainer plate (Figure 2)
- Remove the primary drive gear/ kick-starter gear assembly and the stock cushions (Figure 3)
- You will use these on your new Moose basket
- The stock basket and stock retainer plate will not be reused



Figure 2

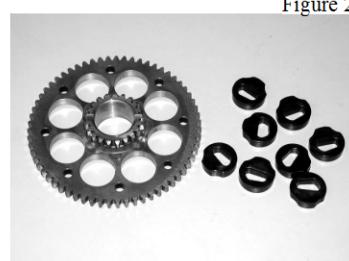


Figure 3

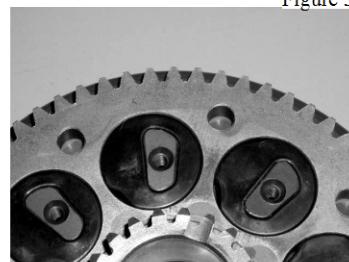


Figure 4



Figure 5

### 3. Install primary drive gear

- Install the stock primary drive gear and the stock cushions onto your new Moose Basket (Figure 4), you are able to use a lubricant such as WD-40 to get the gear to slide on easier



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### 4. Install retainer plate

- Clean the threads in the holes of the basket and the threads on the screws with contact cleaner or another suitable cleaner.
- Apply Red Loctite \* generously to the cleaned screws and to the threads on the basket (Figure 5 and 6)
- Install the new retainer plate with the new 10X24 -5/8" screws and tighten them to 3.3 ft/lbs (Figure 7)
- Using a hammer and punch, peen the screws where they come through the inside of the basket (Figure 8)



Figure 6



Figure 7



Figure 8

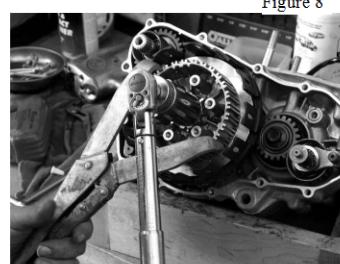


Figure 9

### 5. Re-install basket into bike

- Re-install the basket and the thrust washer
- Re-install the inner hub and tighten the main shaft nut to 47 ft/lbs (Figure 9)
- Re-install the clutch plates, and the pressure plate

**LOCTITE** \* It is crucial that you use RED Loctite. To insure proper bonding of the surfaces you need to clean the threads thoroughly with a contact cleaner, acetone, or another cleaning solution. To make the bond even stronger you should use a Loctite primer. It is important that you use fresh Loctite since it has a shelf life. To ensure a permanent hold you need to put Loctite into the hole and also onto the screw. Keep in mind that you cannot use too much, you want complete coverage with the Loctite.