

# **Rekluse Motor Sports**

## **TCS Clutch Baskets**

**CRF 450R/X**

**2002 – 2008**

**CR 250R**

**1992 – 2006**

### **Installation Guide**

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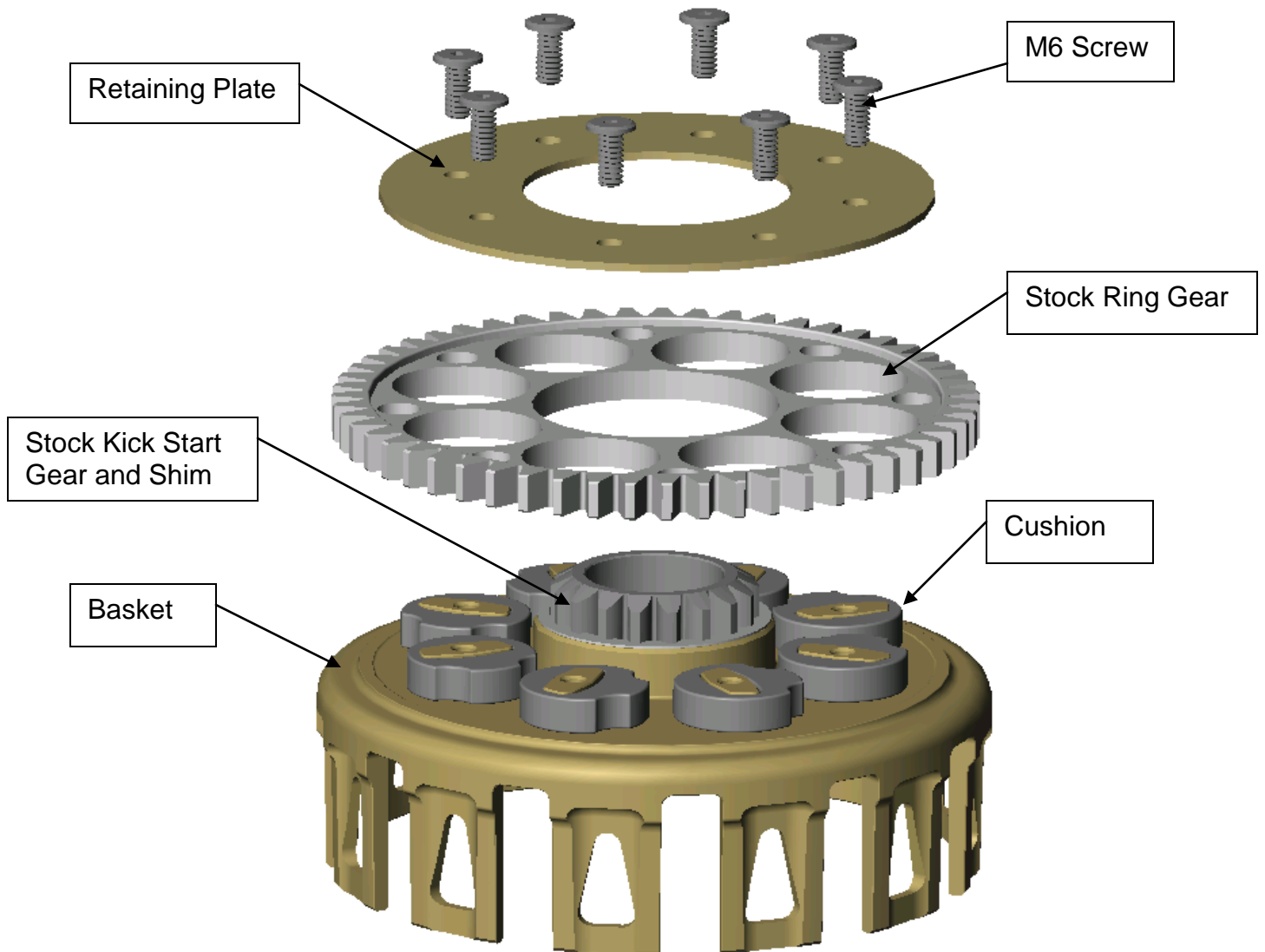
[support@rekluse.com](mailto:support@rekluse.com)

## Required Tools To Assemble Basket

1/4-inch Driver

Torque Wrench

### Basket Overview



### Included Parts

TCS Clutch Basket Core	8 – M6 x 1 x 10 Socket Head Screws
Center Drill	M3 Allen Socket
8 – Basket Cushions	

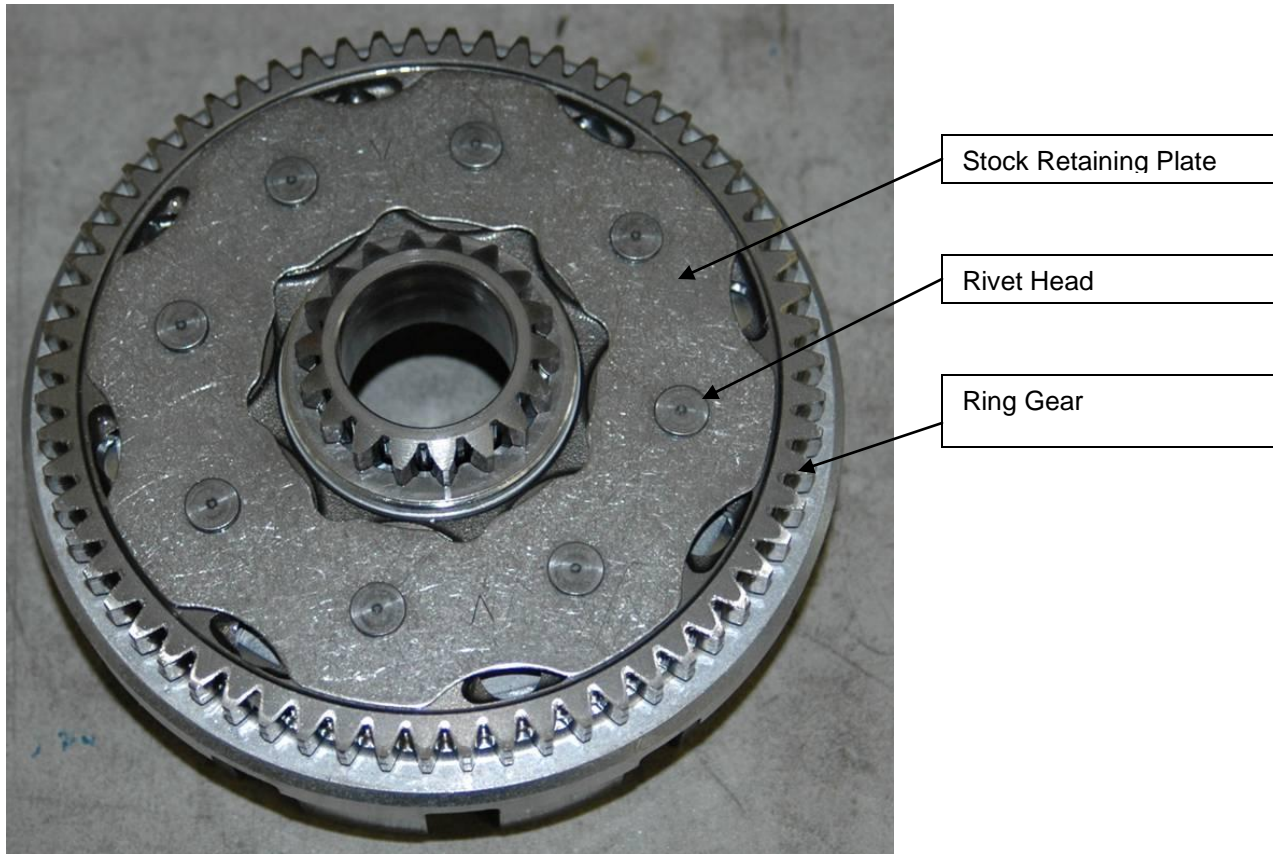
## Bike Preparation and Disassembly

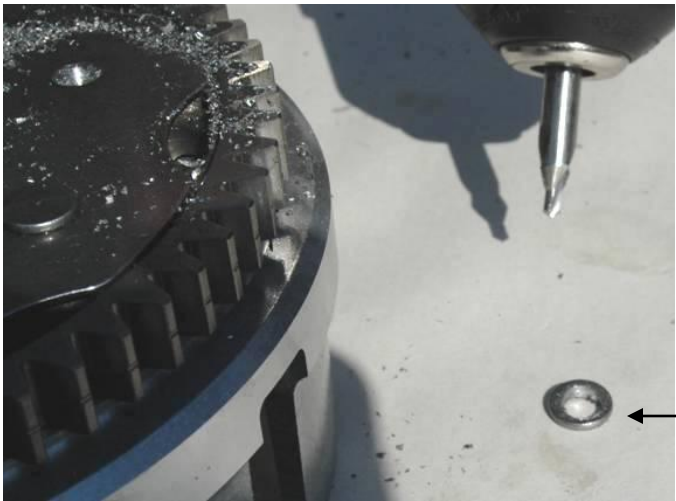
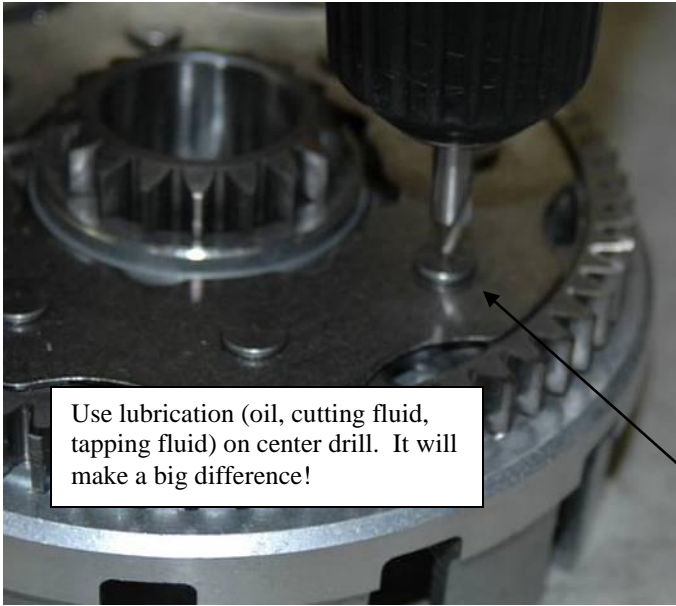
1. Following the procedures in the OEM service manual, remove the existing clutch basket from the engine.

**Note:** It is a good idea to replace the side case cover gasket when re-installing the basket and clutch.

2. Using the included center drill, drill the heads of the rivets off which hold the stock retaining plate and primary ring gear to the OEM aluminum clutch basket. See following pictures.

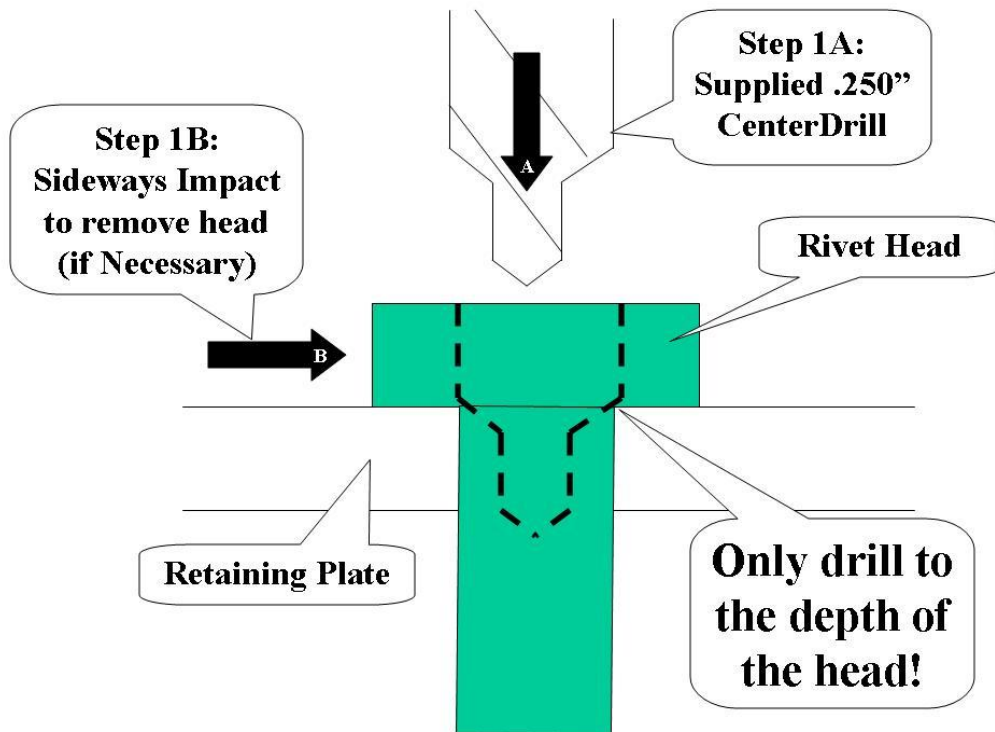
**Warning:** When removing the OEM rivets, do not damage the stock retaining plate or steel ring gear as they will be re-used with your new Rekluse TCS Clutch Basket.





The idea is to re-use the stock retaining plate; therefore do not drill the rivet heads any deeper than they are thick. If you're not exactly in the center, that is OK. If this is the case, the rivet head will pop right off with a sideways blow. Use a flat punch and strike it with a hammer.

Usually the rivet head pops off letting you know that you have drilled deep enough.



After drilling off the 8 rivet heads, carefully lift / pry the stock retaining plate off of the basket. See following picture.



4. Using the center drill, drill out the holes in the stock retaining plate so they are large enough for the M6 screws.

Drill the holes out from the back side (not the side with the stamped "V"). This will ensure the holes are in the center. (unaffected by any slight damage that the hole may have received during Step 1) See following picture.

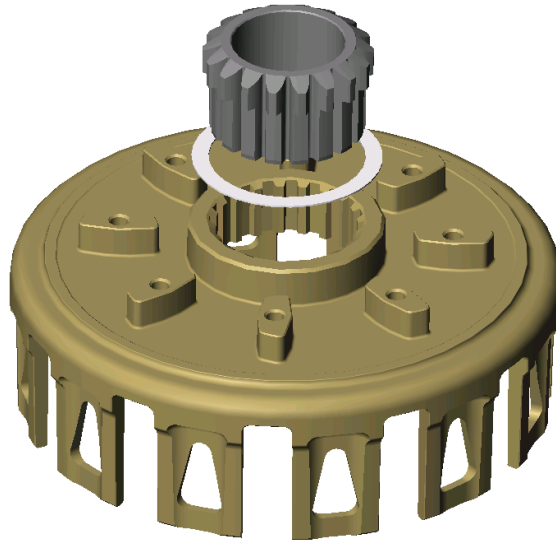


5. Remove all components from the OEM basket, taking note of how everything will be reassembled.
6. Press the kick-starter gear out of the OEM basket.

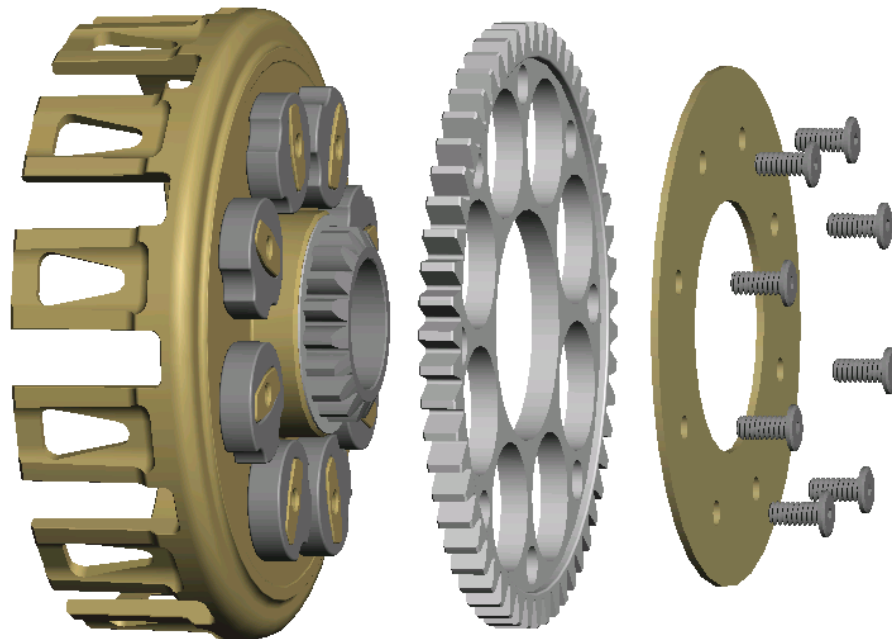
**Warning:** Do not damage the kick-starter gear during disassembly, as it will be used with your new Rekluse TCS Clutch Basket. Keep the washer on the gear because it will be used during assembly.

7. Kick-starter gear installation: To get the gear to drop into the new basket easily, place the basket in the oven at 400° F for 15 minutes.

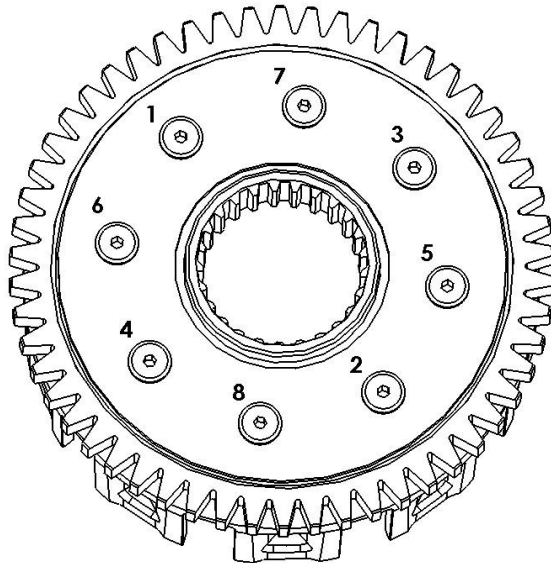
Place the washer on the gear, remove the basket from the oven, and quickly drop the gear into the center hole. Place a weight on the gear to hold it in place as the basket cools completely. **See following picture.**



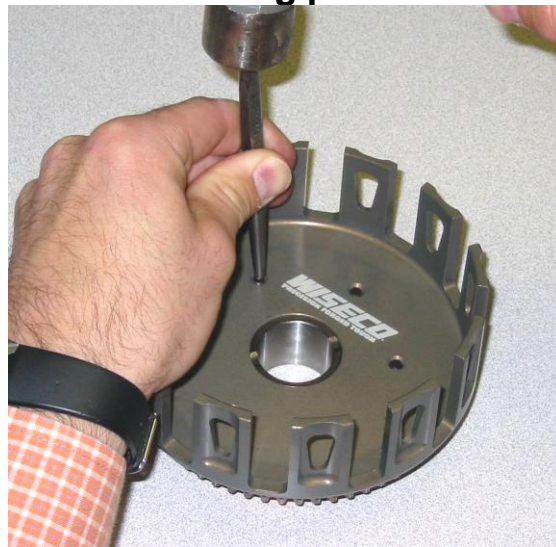
8. Install the New cushions, OEM gear (recessed side out), and stock retaining plate onto the Rekluse TCS Clutch Basket. **See following picture.**



9. Install the new M6 fasteners into the clutch basket assembly. Tighten to 80 in-lbs (6.6 ft-lbs) in a criss-cross pattern to compress the assembly evenly. **See following picture for tightening sequence.**



10. Using a hammer and punch, peen over the ends of the screws where they come through the bottom-inside of the clutch basket. **See following picture.**



11. Install the new clutch basket assembly into the engine following the procedures in the OEM service manual.
12. For z-Start installation, refer to the z-Start Installation Guide that was included with the z-Start Clutch. For re-installing your stock clutch follow the procedures in the OEM service manual.