

<u>1971- 1985 IRONHEAD XLH SPORTSTER</u> #607-30-10871 Scorpion Clutch Assembly Instructions

Refer to Factory Service Manual for:

All Safety Instructions Removal / Installation Instructions Proper Tools and Pullers Torque and Lubrication Specifications

Barnett Tool and Engineering recommends changing primary lubricant after the first 500 miles and every 5,000 miles thereafter.

- 1. To protect against accidental shock or start up, disconnect both battery cables.
- 2. Remove primary drain plug at bottom of primary. Drain into suitable container. (Dispose of oil in proper manner.)
- 3. Remove foot pegs, etc.
- 4. Remove primary cover.
- 5. Reference: service manual for removal of pressure plate, spring and associated components.
- 6. Remove retaining ring using clutch spring compression tool.
- 7. Remove clutch fibers and steel plates.
- 8. Remove main shaft hub nut.
- 9. Using proper puller, remove stock hub from shaft. *Ref to photo #1*.
- 10. Inspect basket and all related components for wear. Check service manual for factory tolerance.
- 11. Install Scorpion hub using new factory lock tabs and stock nut. Reference service manual for tightening procedure and torque specification. *Ref to photo #2*.
- 12. Install springs on hub. Refer to photo #3.
- 13. Push shoulder bolts through spline and backing plate assembly.
- 14. Use red Loctite on all threads.
- 15. Slide spline assembly into basket, lining up shoulder bolts to the center of springs and thread into clutch hub evenly. Bottom bolts, then torque to 5-7 ft. lb. Note: Bolts must be tightened evenly to prevent binding. Using Barnett lock up tool 638-30-80086 will stop the hub from spinning and allow easier torqueing. *Ref to photo 4*.
- 16. Pre-soak friction plates in oil that is going to be used in primary for approximately 10 minutes. Wipe dry with lint free towel prior to installation.



Photo 1



Photo 2

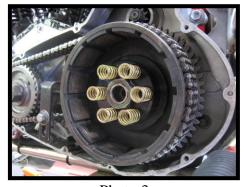


Photo 3



Photo 4

- 17. Starting with friction plate first, steel plate next, following with friction, steel, friction, steel. Ending with steel plate last.
- 18. Next install 301-32-40808 outer drive plate which has friction material on one side (Friction side toward hub).
- 19. Install clutch pressure plate using (6) 10-24 x ¾ FHCS, using red Loctite. Torque to 3-5 ft. lb.
- 20. Install #606-30-10713 throw out bearing.
- 21. Install stock plate retaining ring using clutch spring compression tool. *Ref to photo #5*.
- 22. Check and adjust primary chain as per factory specifications.
- 23. Install primary cover using new gasket.
- 24. Adjust clutch and clutch cable per factory specifications.
- 25. Reinstall primary drain plug.
- 26. Pour proper amount and type of primary lubricant into primary case inspection opening.
- 27. Reinstall foot pegs (etc.).

CLUTCH SPRING PRESSURES

- (6) Six 501-37-06022 springs equals 240 lbs. of spring pressure.
- (6) Six 501-58-06018 springs equals 348 lbs. of spring pressure.
- (6) Six 501-70-06112 springs equals 420 lbs. of spring pressure.



Photo 5



Photo 6



