



REKLUSE[®]
clutchbasket

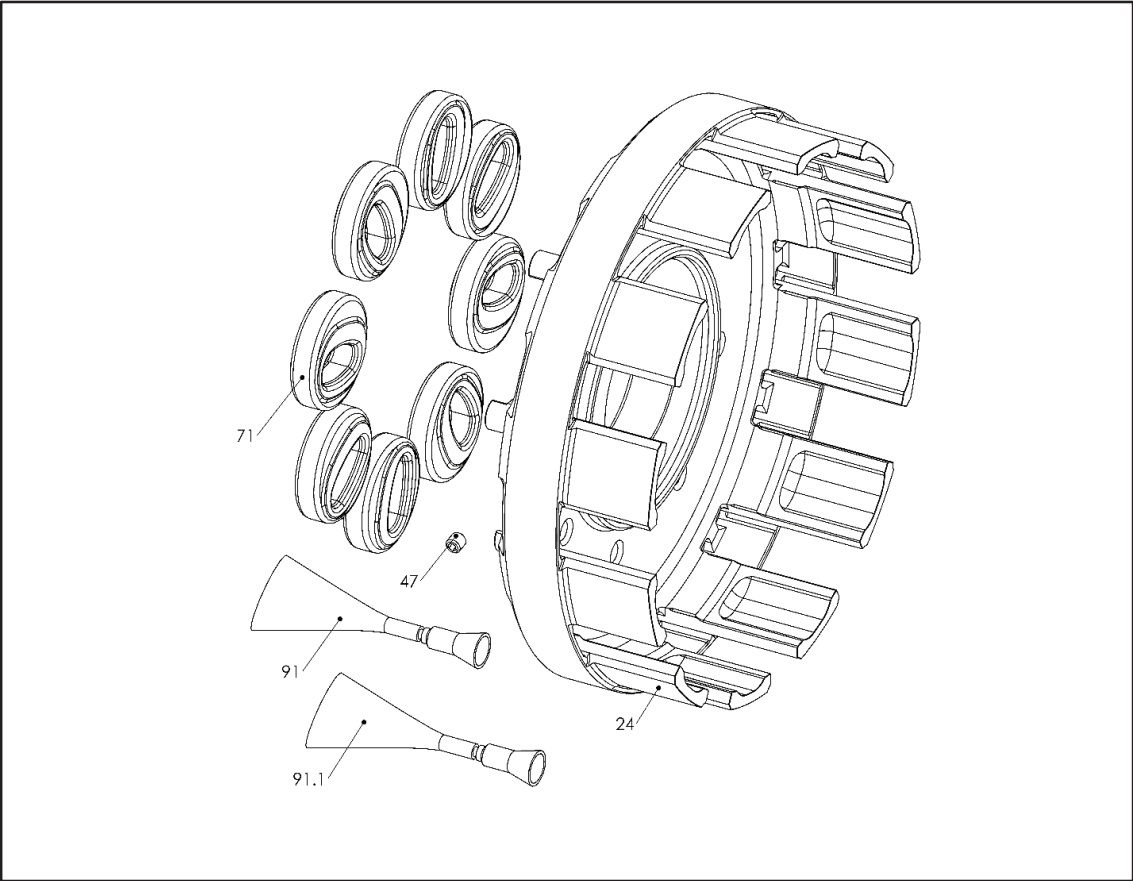
2019 YZ250F

**INSTALLATION
GUIDE**

Doc ID: 195-4107002

Doc Rev: 052919

INCLUDED PARTS

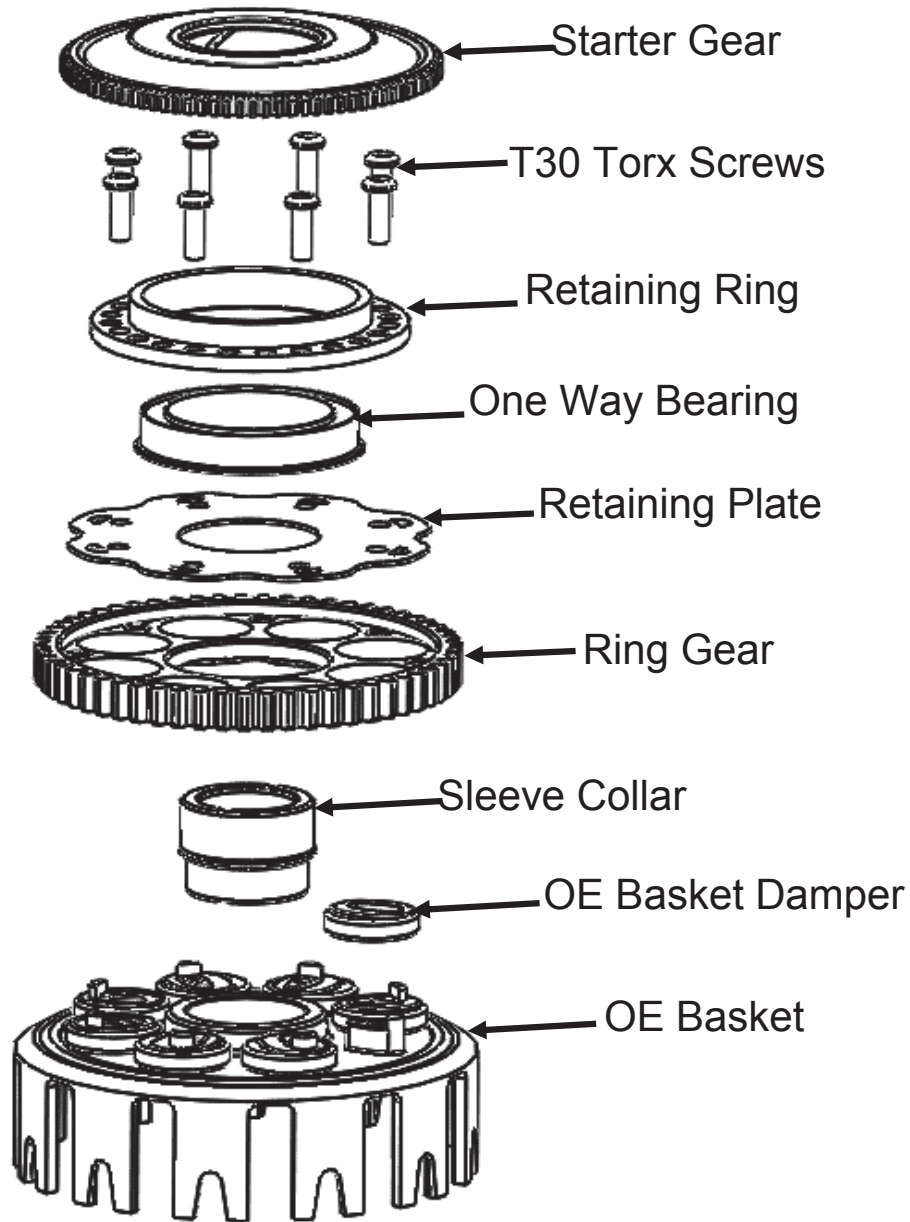


#	Item Type	Part #	Qty
24	CLUTCH BASKET - 19 YZ250F	170-039	1
47	FASTENER - M4 x 0.7 x 5mm cone point set screw	411-145	4
71	BASKET CUSHIONS - Molded Basket Damper - YZ250F	474-116	8
91	ADHESIVE - Loctite 262 (RED) .02 fl oz	491-002	1
91.1	ADHESIVE - Loctite 680 (GREEN) .02 fl oz	491-006	1

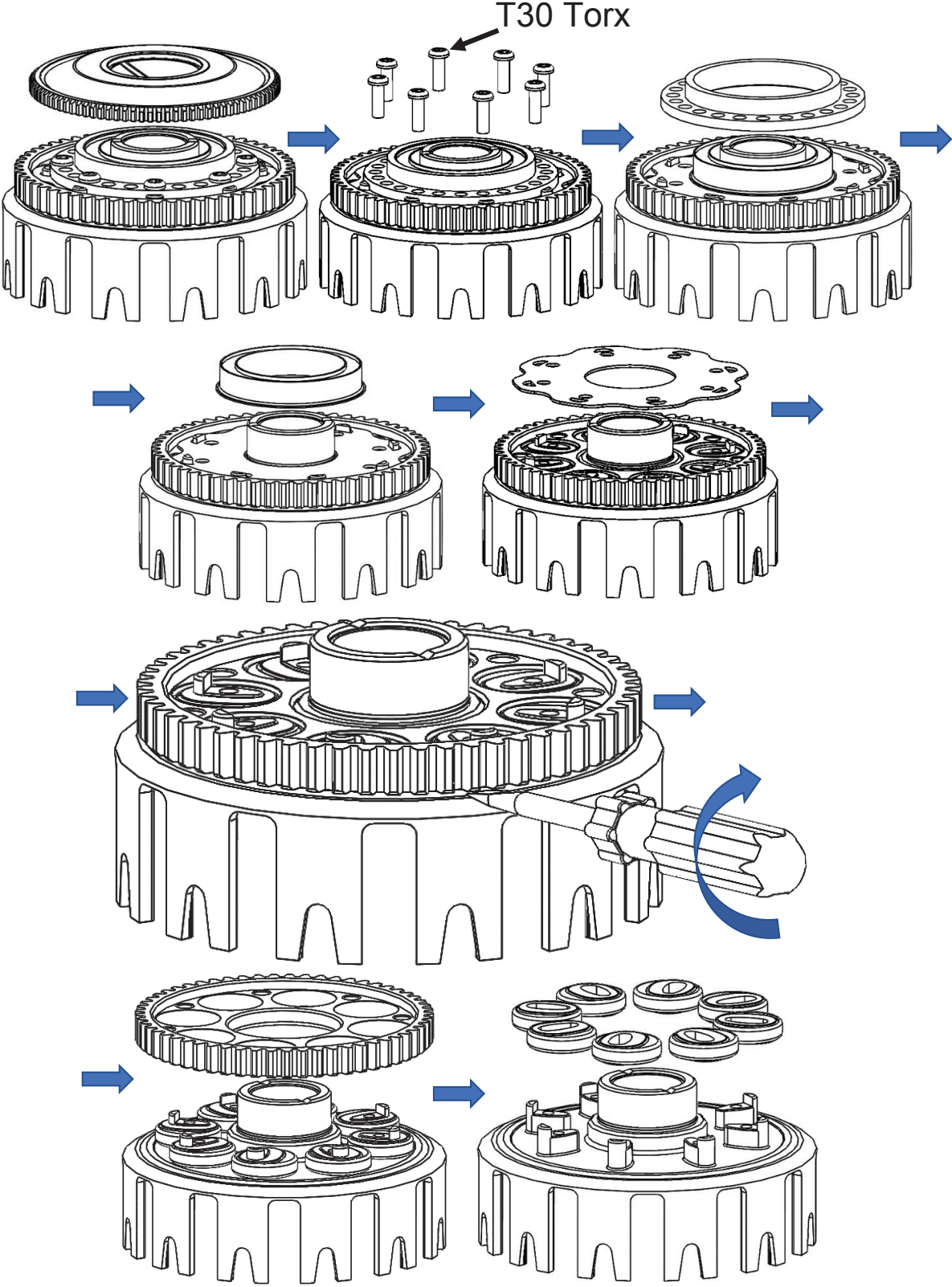
TOOLS NEEDED

- 2mm Allen Wrench
- Freezer
- Oven
- Flathead Screwdriver
- Press
- Rubber Mallet/Deadblow
- 4x4 Wood Block
- T30 Torx

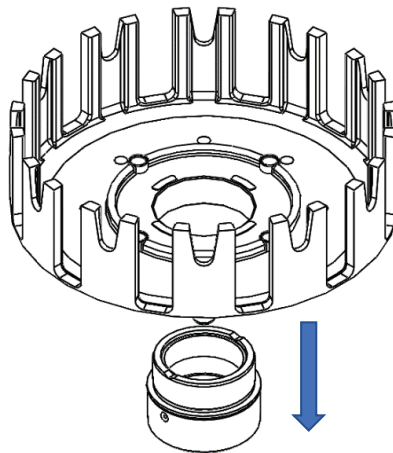
OE BASKET DISASSEMBLY OVERVIEW



1. Disassemble the OE basket assembly



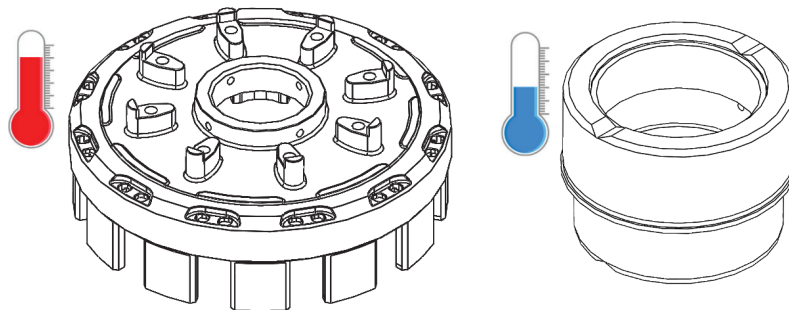
2. Remove the sleeve collar with a press.



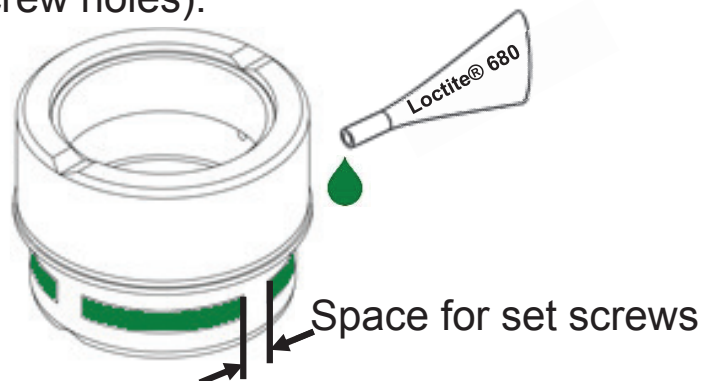
3. Clean both the basket and sleeve collar of oil. Once the parts are clean of oil, put the sleeve collar in the freezer for 20 min.

4. Place the Rekluse basket in a preheated oven at 400°F (200°C) for 15 minutes (**To avoid softening the basket material, DO NOT EXCEED 20 minutes**).

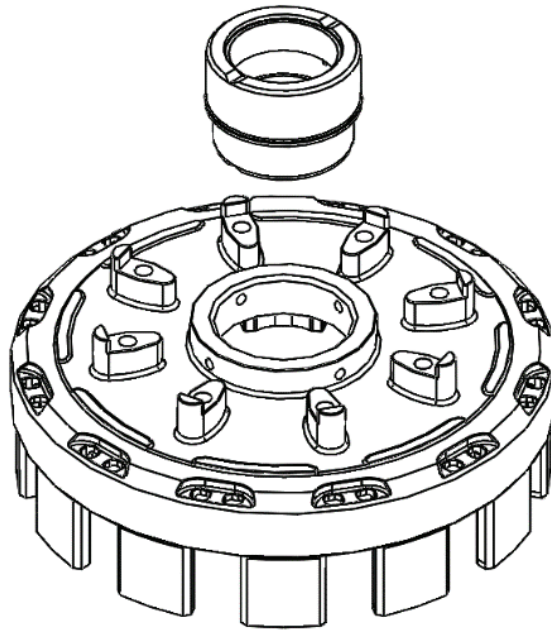
CAUTION: The basket will be HOT! Be sure to wear protective covering on your hands when removing the basket from the oven.



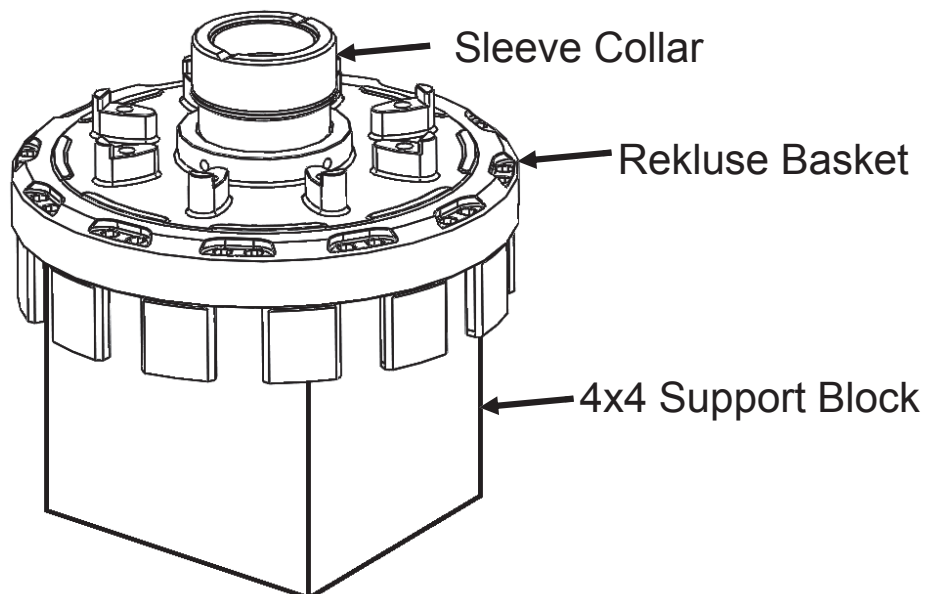
5. Put a small bead of Loctite 680 on the starter gear giving space for the set screw holes (try to prevent Loctite from filling set screw holes).



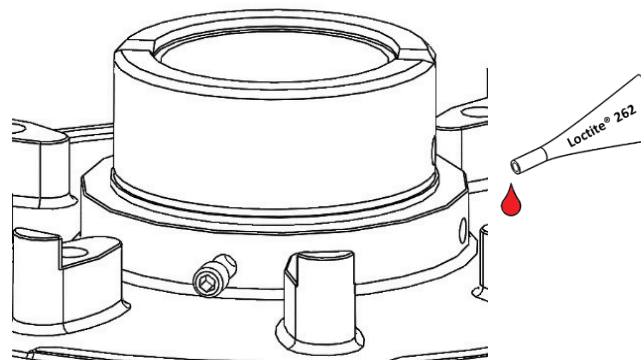
6. Set the basket on a flat surface. Quickly align and press the frozen sleeve collar by hand into the center hole in the basket being careful not to touch the hot basket. Use oven mitts or gloves, if necessary.



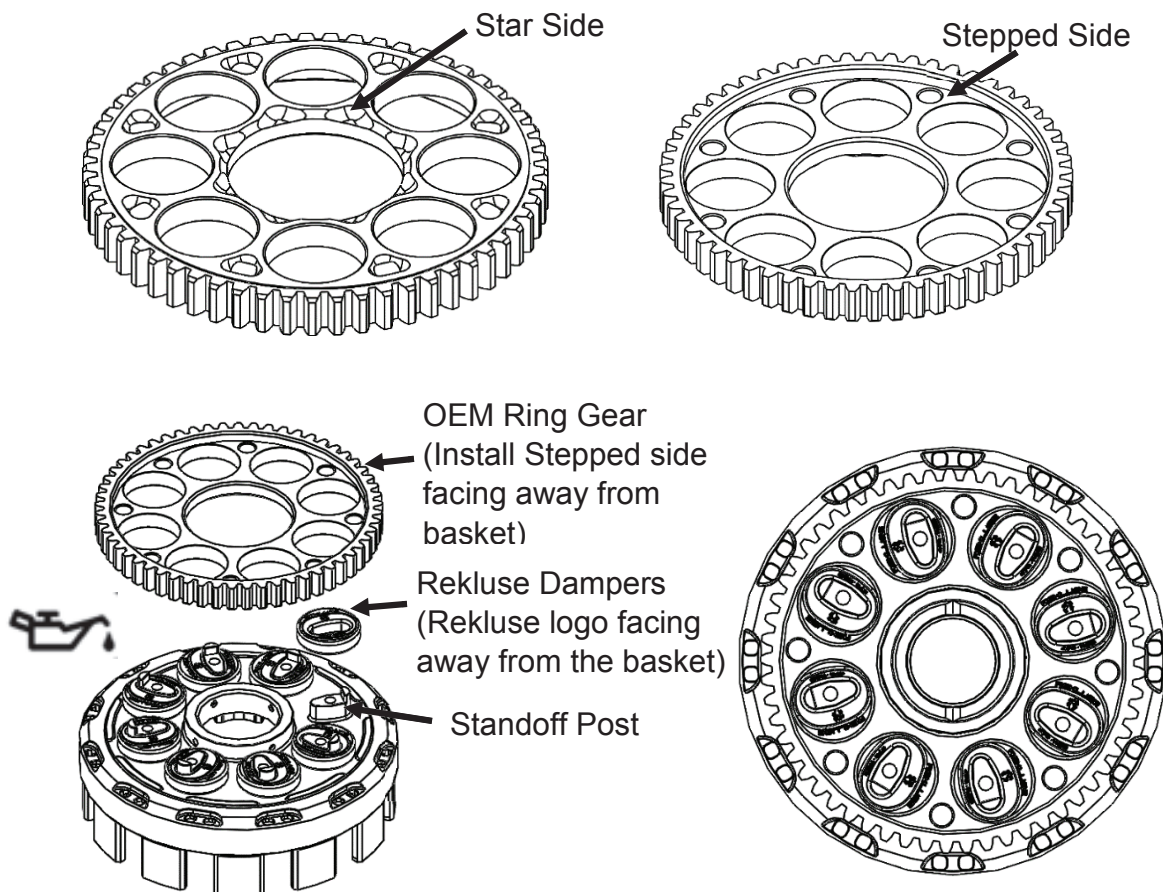
7. If the fit seems too tight, a rubber mallet may be used to tap the sleeve collar in while supporting it (such as supporting the basket using a block of wood). Tapping the sleeve collar in while the tangs are resting on a hard surface may damage the basket.



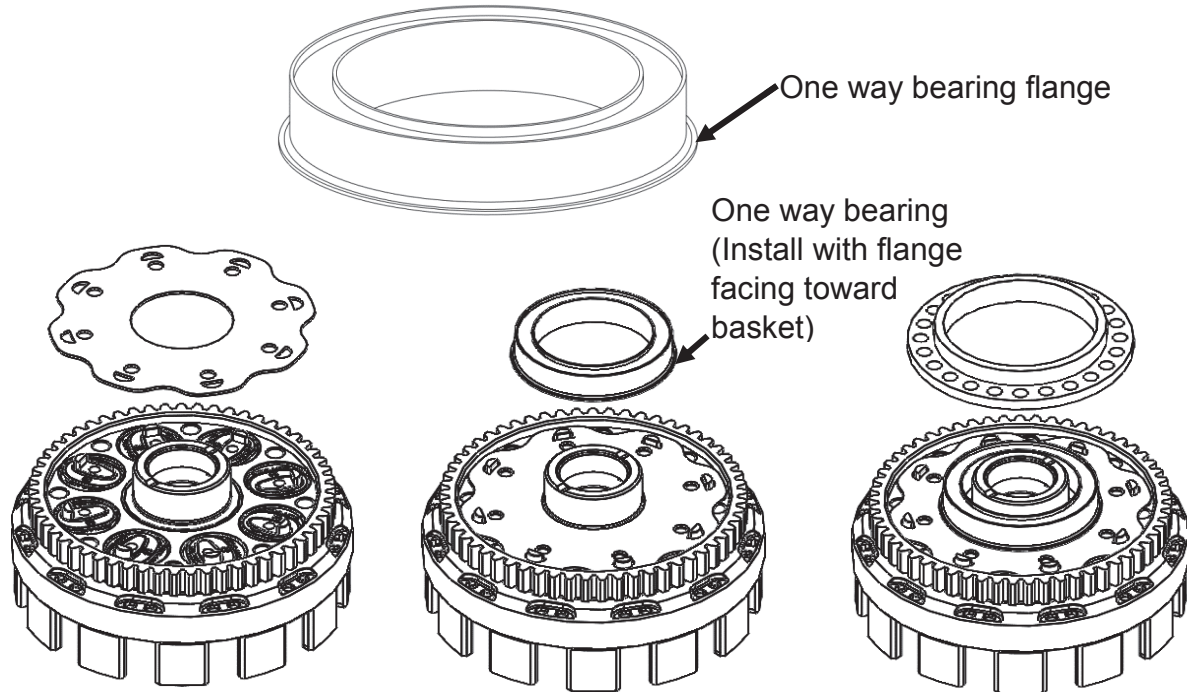
8. Once the basket has cooled, install a set screw. Use some of the included red Loctite® 262 on the threads of the set screw. Snug each set screw and then Torque each set screw to **18 in-lb** (2 N-m) moving in a cross pattern.



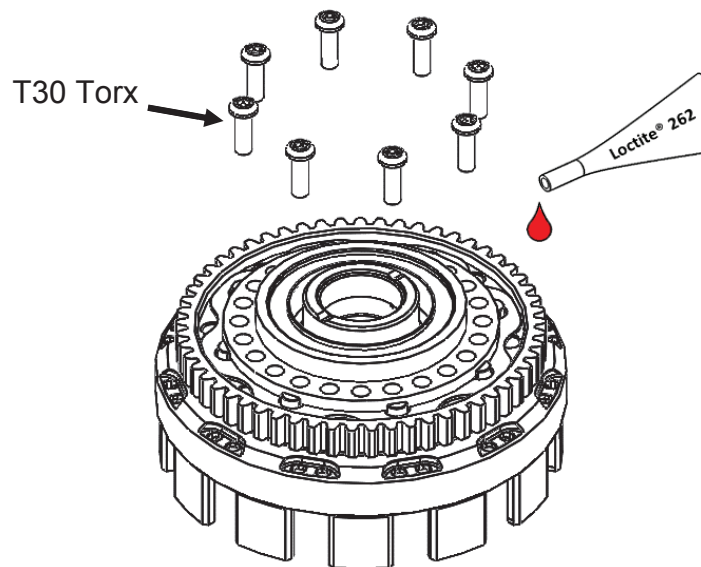
9. Add some engine oil to the cushions and install one per standoff post. Install the OEM Ring Gear with the stepped side facing away from the basket and the star side facing the basket (see image for clarification). The ring gear may fit snugly and will likely require using a soft mallet to tap it on until it seats down against the basket. Follow damper position in following figure.



10. Replace backing plate, one way bearing and retaining ring. Install one way bearing with the flange facing toward the basket.



11. Replace retaining ring bolts with a small amount of the supplied Loctite® 262, start bolts until snug, using a start pattern, torque the bolts to **80 in-lb (9 N-m)**.



NEED ADDITIONAL HELP?

Contact Technical Support for questions related to product installation.

Technical Support hours:

Monday thru Friday: 8:00 a.m. - 5:00 p.m.

Mountain Time zone

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