TECH BULLETINS

TSB - 299

CLUTCHTECH

TSB-299 Clutch Repair Kit Fitment

Please note the following steps as guidance for installing this clutch repair kit.

1. Inspection of components:
   It is important to clean and visually inspect all components such as flywheels that are being re-used. Inspect for any excessive thermal loading, cracks and taper that might render the part not useable.

2. Flywheels:
   It is highly recommended that the flywheel friction surface is re-surfaced on a grinding machine to the original flywheel step as per listed below. If there is significant wear and tear on the flywheel this may cause operational issues with the clutch. Where this is not possible and the flywheel is in good condition, aggressive emery paper should be used to scuff the flywheel friction surface of any old friction material.

Clutch Spec	Flywheel Step mm/inches
184mm/7.25”	2.54mm/0.100”
200mm/8”	2mm/0.080”
230mm/9”	3.81mm/0.150”
230mm/9”	6.1mm/0.240”
230mm/9” Pull Type	19.5mm/0.767”
265mm/10.5”	Flat

3. Clutch Installation:
   - Ensure all friction surfaces are thoroughly cleaned using brake cleaner.
   - Where applicable assess and replace the pilot bearing/bush.
   - Clean and lubricate the spline and hubs on the friction discs.
   - Carefully assess the order of installation of components and markings on the friction discs.
   - When assembling the clutch on the flywheel check the clearance between hubs to ensure there is no interference and a minimum of 0.5mm/0.020” clearance.
   - Carefully tighten down and torque the pressure plate bolts to product specific torque

4. Release Bearing Installation:
   - Check the condition of the release bearing/CSC and replace where necessary.
   - Ensure the CSC where applicable is free of leaks.
   - Ensure that the bearing carrier, fork and pivot ball/cross shaft are free of any significant wear and tear/stress fractures.
   - Ensure that the bellhousing and components are fully cleaned of any dirt dust and contaminants.
   - Re-lubricate the nose cone, bearing carrier, clutch fork and pivot ball/ cross shaft.
   - Check for smooth operation of the release mechanism.

5. Assembly – VERY IMPORTANT:
   - Carefully mount the transmission and hold in place with 2 bellhousing bolts.
   - Mount the slave/clutch line/cable at this point and bleed the system.
   - Shift the transmission into gear and operate the clutch pedal. Check for positive clutch pedal feel.
   - With the clutch pedal depressed, in gear, check that you can turn the output shaft/ drive shafts to ensure the clutch is fully released. With the pedal relaxed you should not be able to turn the driveshafts/ output shaft.
   - Finally assemble the rest of the vehicle.
   - Test drive the vehicle

Please note that the same break in procedures apply for a repair kit as for a brand-new clutch kit.
Recommended 1000km/700mi of easy driving.

LEADING BRANDS

CLUTCHPRO CLUTCHPRO COMMERCIAL XTREME PERFORMANCE CLUTCH XTREME OUTBACK XCLUTCH AG CLUTCH AUSTRALIA

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