

# Revision for Chart 1, Addition of Chart 3 and Remarks for OS GIKEN Bolt Torque Specs on Page 9 in the OS Racing Clutch Series Installation Manual

## Bolt Tightening Torque Specifications

**Revised Chart 1**

|   |                           |                    |                            |
|---|---------------------------|--------------------|----------------------------|
| 360° Housing Type Clutch<br>(Single, Twin, Triple, Quadruple, Pressed Steel and Aluminum Cover) | Housing Bolt (M6)         | Cover Bolt (M6)    | Diaphragm Bolt             |
| Refer to Pic 1  | 1.8kg-m (13 lb-ft)        | 1.8kg-m (13 lb-ft) | Do not tighten nor loosen. |
| Shaft Type Clutch<br>(Super Single Only, Pressed Steel and Aluminum Cover)                      | Shaft Bolt (M8)           | Cover Bolt (M8)    | Diaphragm Bolt             |
| Refer to Pic 2  | 3.0-3.5kg-m (22-25 lb-ft) | 3.0kg-m (22 lb-ft) | Do not tighten nor loosen. |

**Pic 1**



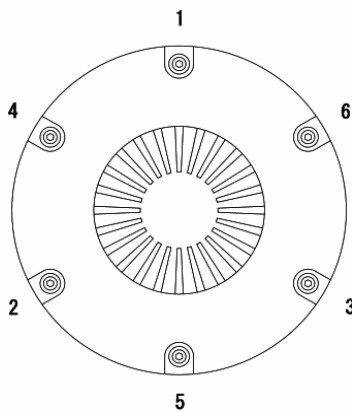
**Pic 2**



### How to Tighten Clutch Cover Bolts

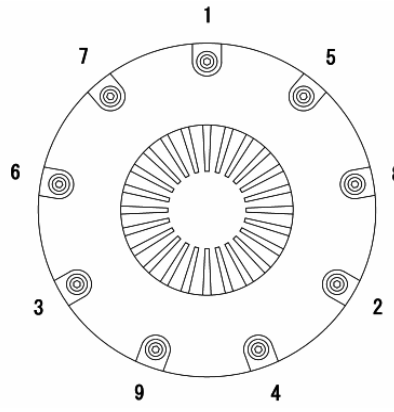
- Step 1. Temporarily tighten the clutch cover bolts by hand. At this time, tighten the bolts in order following the order shown on Chart 3. After temporarily tightening by hand, insert center alignment tool and make sure friction discs are aligned. If you can not move the alignment tool smoothly, you need to loosen all the cover bolts and repeat from the beginning.
- Step 2. Temporarily tighten the clutch cover bolts using a tool in the same order as Step 1. At this time, do not fully tighten to the torque spec shown on Revised Chart 1. After temporarily tightening with the tool, insert center alignment tool and make sure friction discs are aligned. If you can not move the alignment tool smoothly, you need to loosen all the cover bolts and repeat from Step 1.
- Step 3. Tighten the clutch cover bolts with a torque-wrench at the torque spec shown on Revised Chart 1 in the same order as Step 1. Afterwards, insert center alignment tool and make sure friction discs are aligned. If you can not move the alignment tool smoothly, you need to loosen all the cover bolts and repeat from Step 1.

**Chart 3**



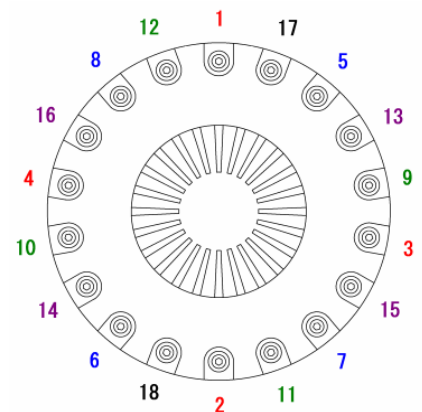
**6 Bolt Type Clutch Cover**

(Pressed Steel and Auminum)



**9 Bolt Type Clutch Cover**

(Pressed Steel and Aluminum)



**18 Bolt Type Clutch Cover**

(Pressed Steel and Aluminum)

Red=1st, Blue=2nd, Green=3rd,  
Purple=4th and Black=5th Sequence

**Remarks:** Some clutch kits come with OS GIKEN Flywheel Bolts. If this is the case, you must to tighten them to OEM torque specs as listed in the manufacturer's service manual.