

V-Twin Mfg.
BARNETT SCORPION CLUTCH KIT
FITS 1971-1983 XL
VT No. 18-3722

This is a custom application rider safety depends on proper installation. This product should only be installed by a knowledgeable and trained motorcycle technician. V-Twin Mfg. accepts no responsibility for improper installation.

Installation Instructions:

1. To protect against accidental shock or start up disconnect both battery cables.
2. Remove primary drain plug at bottom of primary and drain primary fluid.
3. Remove foot pegs, etc.
4. Remove primary cover.
5. Reference your service manual for removal of pressure plate, spring and associated components.
6. Remove retaining ring.
7. Remove clutch fibers and steel plates.
8. Remove main shaft hub nut
9. Using proper puller, remove stock hub from shaft.
10. Inspect basket and all related components for wear. Check service manual for factor tolerance.
11. Install scorpion hub using new factory lock tabs and stock nut. Reference service manual for tightening procedure and torque specifications.
12. Install (6) MT-112 springs using (6) #207009 .250 x .625 x .125 washers and (6) #207012 6mm x 1 x .625 socket head cap screws. Install (1) #207006 spring retaining plate using crisscross pattern turn SHCS until they bottom out and torque set to 7-8 ft-lbs.
13. Install backing plate #207008. Align studs on backing plate with screws holding spring retaining plate.
14. Pre-soak friction in oil that is going to be used in primary for approximately 20 minutes. Wipe dry with lint free towel prior to installation.
15. Starting with friction plate first, steel plate next followed by friction, steel, friction, steel. Ending with steel plate last.
16. Next install part # SK-8 aluminum friction bonded on (1) side. Friction surface facing in.
17. Install stock plate retaining ring.
18. Install pressure plate #207004. using (6) #207010 .250 x .031 x .500 washer using (6) 207011 1/4-20 steel lock nut. Torque set 4-5 ft lbs.
19. Install #207013 throw out bearing insert.
20. Check and adjust primary chain as per factory specifications.
21. Install primary cover using new gasket.
22. Adjust clutch and clutch cable per factory specifications.
23. Reinstall primary drain plug.
24. Pour proper amount and type of primary lubricant into primary case inspection opening.
25. Reinstall foot pegs.

Clutch spring pressures:

- (6) MT-112 springs equals 420 lbs of spring pressure.
(6) MT-113 springs equals 480 lbs of spring pressure.
(3) MT 112 plus (3) MT-113 equals 450 lbs.

Item #	Qty	Part #	Description	Item #	Qty	Part #	Description
1	1	207002	Clutch hub	11	6	207009	Washer spring retainer
2	1	207003	Clutch disk spline	12	6	207010	Pressure plate washer
3	1	207004	Clutch pressure plate	13	5	207011	1/4-20 Steel lock nut
4	6	207005	Stud Clutch pack assm.	14	6	MT-112	Clutch springs 70 lbs @ 3/4
5	1	207006	Spring retainer plate	14	6	MT-113	Clutch spring 80 lbs @ 3/4
6	1	207007	Backing plate shoulder studs	14	1	201015	5mm Hex key wrench
7	1	207008	Backing plate	15	9	HDP-9	Red fiber friction plates
8	1	2050011	Throw out bearing	16	9	SK-6	Steel drive plates
9	6	207012	6mm x1 x .625SHCS	17	1	SK-8	Outer drive plate
10	1	207013	Sleeve throw out bearing				

