

**V-Twin MFG.**  
**Tamer Style XL Thrust Collar for 1971-84 XL Models**  
**VT No. 18-2323**

**This is a custom application and should only be installed by a knowledgeable and  
trained motorcycle technician**

**V-Twin Mfg. accepts no responsibility for improper installation**

Instructions

1. Remove outer primary cover to expose clutch.
2. Use 2 or 3 Jaw gear puller or VT spring tool.
3. Remove pressure plate and spring.
4. Remove clutch plug in center of bearing and replace it with our clutch plug.
5. Main input gear in center of clutch shell is to receive the bushing, insert the bushing so that the chamfer is toward you.
6. Put some grease on the bushing.
7. Reinstall pressure plate and spring and tighten the 6 nuts.
8. Install outer primary and on later models adjust the primary chain.
9. Readjust clutch to specifications as stated in service manual.
10. Add oil to primary.