



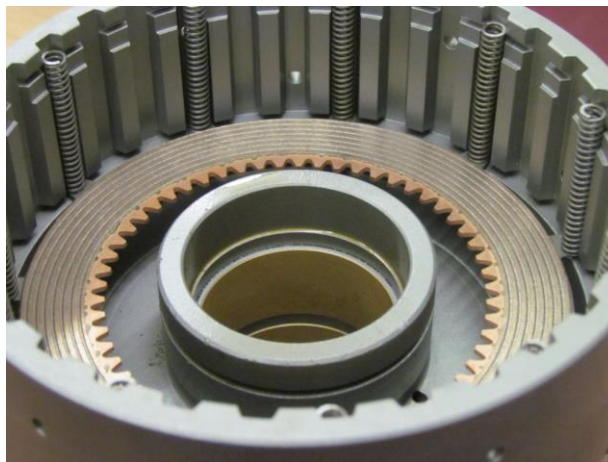
M830472 [IPTO Clutch Kit]

Instruction Guide

1. Place the clutch housing (M515875) on the assembly table with the large opening upward
2. Assemble and install the piston and sealing rings on the housing as specified in the service manual
3. Insert one of the supplied clutch plates into the housing with the lobes of the plate inserted into the serrations
 - a. Make sure the clutch plate rests against the piston (not shown)
4. Install the supplied piston return springs against the lobes of the piston plate



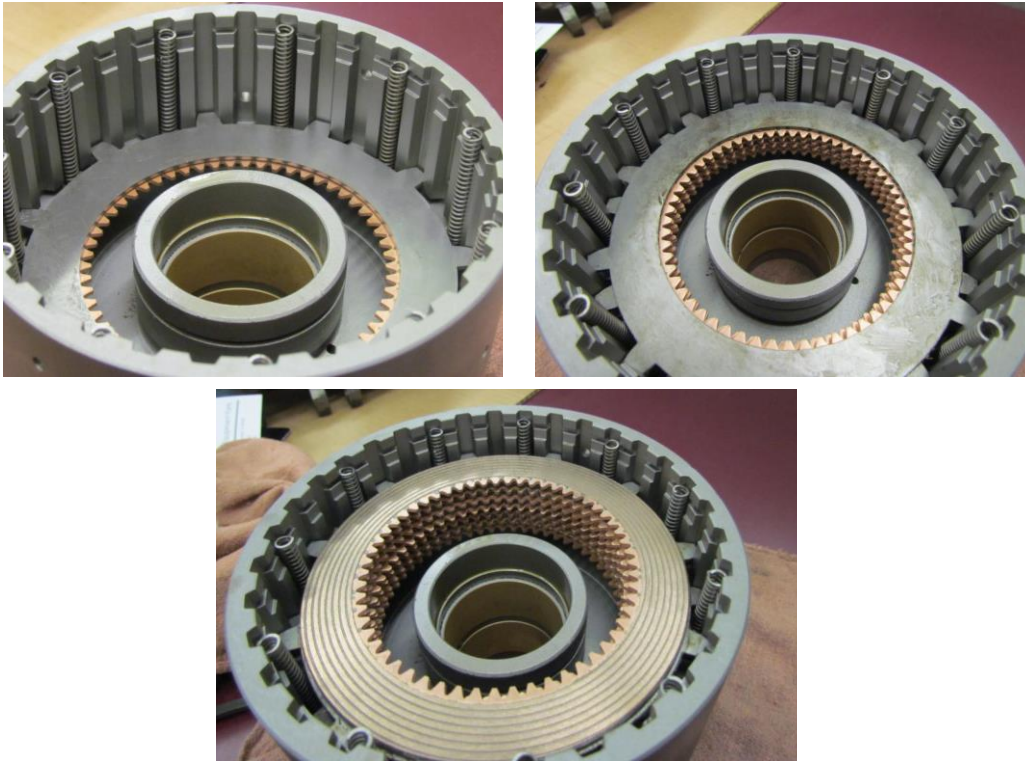
5. Carefully install the clutch disc on top of the clutch plate



6. Install the remaining clutch plates and discs into the housing
 - a. Make sure that each successive clutch plate's lobes are staggered alternatively one serration from the previous plate's lobes
 - b. Attempt to line up the splines of the clutch discs as they are installed

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7. Install the clutch retainer plate (reused core) on top of clutch assembly (not shown)
8. Compress the assembly and install the supplied pins in the oiling holes of the clutch housing to hold down the assembly



9. Install the snap ring and remove the pins