



## Ring Gear Conversion Kit Instructions (66T, 84T, 102T)

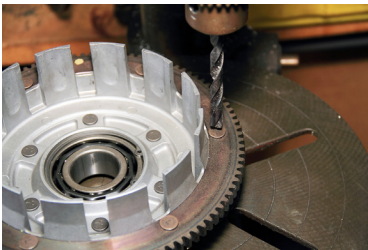
Evolution Industries strongly recommends installation be performed by a certified Harley-Davidson technician or an independent V-twin service shop.

Please follow the factory service manual to ensure proper installation and safety while installing this product. These instructions will only note the differences, if any, between Evolution Industries and D.E. Installations. All other steps can be followed from the factory service manual.

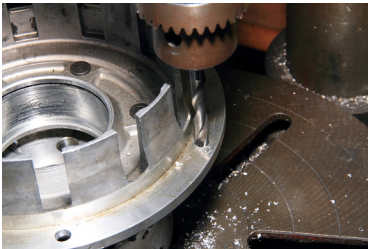
Before beginning installation of your kit, make sure you have received the correct parts necessary for the installation on your bike.



1. Follow the factory service manual to remove the clutch basket from the motorcycle. Once the clutch basket has been removed from the bike remove the clutch plates from the basket. It is not necessary to remove the drive hub for this procedure. Use a center punch to mark the center of the rivets to be drilled out and removed.



2. Use a #4 Drill Bit to start a Pilot hole as close to the center of the rivet as possible. After starting the pilot hole, use a 3/8" drill bit to drill through the rivets holding the gear to the clutch basket. Remove the old ring gear from the basket after all of the rivets are drilled out.



3. Ream all of the clutch basket rivet holes with a 21/64" drill bit. Clean up all loose material or burrs from the holes. Check to see that the holes are big enough to fit the new ring gear bolts provided in the kit.



4. Make sure the new ring gear's threaded mounting holes are free of contaminants by using brake-cleaner or similar solvent to clean the holes. Use compressed air to dry the holes. Place the new ring gear on the clutch basket with the bevel side facing the pinion gear.



5. Use Red thread lock on the provided mounting bolts (5/16"-24 x 5/8") and torque to 15-18 Ft/lbs. Then re-install the clutch components and any remaining items per the factory service manual. It is recommended to replace the starter motor pinion gear at the same time as replacing the ring gear.