



STARTER RING GEAR REPLACEMENT INSTRUCTIONS for PRIMARY CHAIN DRIVE APPLICATIONS on LATE MODEL EVO BIG TWINS

Thank you for purchasing this Rivera Primo high quality replacement starter ring gear kit. Included in this kit are a starter ring gear and the allen bolts needed to attach the ring gear to the clutch basket (**Rivera Primo recommends the use of a high quality threadlock compound (red) on the bolts when attaching the ring gear to the clutch basket**).

NOTE: Prior to starting any work on the motorcycle, make certain that you disconnect both battery cables !

1. Remove the stock clutch basket from the primary drive and remove all the clutch plates keeping them in the same order so they can be returned to their original locations.
2. Using a drill press, drill-out the stock rivet heads. Then using a punch & hammer, drive the rivets out which will allow removal of the OEM starter ring gear. Using a 5/16" drill, enlarge the rivet holes in the basket.
3. Mount the Rivera Primo replacement starter ring gear on the clutch basket so that either the beveled or the flat side of the ring gear faces inward, towards the starter, when the clutch basket is re-installed.*
4. Line-up the holes in the Rivera Primo starter ring gear with the holes in the clutch basket.
5. Using the allen bolts provided in the kit, attach the Rivera Primo ring gear to the clutch basket. Make certain you use a "red" threadlock compound on the bolt threads.
6. Tighten the bolts down equally and uniformly until all are tight. Torque to 29 foot pounds.
7. Reinstall the clutch basket and check for clearance(standard operating procedure when installing something new). If everything clears, reinstall the clutch and primary drive components. Adjust the clutch, then re-connect the battery cables. Now you're ready to ride !

* Use of either the beveled or flat side of the ring gear is up to the discretion of the end user.

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