

PRIMO BELT DRIVES

DESIGNED TO FIT, ENGINEERED TO LAST!

Late Model Evo Big-Twin *starter ring-gear replacement instructions*

Thank you for purchasing a high quality Primo Belt Drive replacement starter ring-gear. Included in this kit are a starter ring-gear, and the Allen-bolts needed to attach the ring-gear to the clutch basket! Use a high-quality thread-lock compound when attaching the ring-gear to the clutch basket!

- 1) Remove the stock clutch basket from the primary drive and remove all the clutch plates, keeping them in order so they can be installed in their original locations.
- 2) Using a drill-press, REMOVE the stock rivet-heads. Using a punch, drive the rivets out allowing the OEM starter ring-gear to be removed. Drill-out the holes in the clutch basket with a 5/16" drill bit to give clearance for the ring-gear attachment bolts to pass through.
- 3) Mount the Primo Belt Drives replacement starter ring-gear so that the beveled side is inward (toward the starter) when the clutch basket is re-installed!
- 4) Align the holes in the Primo starter ring-gear with the NEWLY ENLARGED holes in the clutch basket!
- 5) Using the Allen bolts provided in the kit attach the Primo ring-gear to the clutch basket. The bolts go thru the basket from the back side and thread into the ring gear. Use a quality thread-lock compound (Rivera "Red") to keep the bolts tight.
- 6) Uniformly torque the bolts to 25 foot pounds! Make sure all the bolts are tight before re-installing the clutch basket!
- 7) Reinstall the clutch basket and check for clearance (standard operating procedure when installing something new). If everything clears, re-install the clutch & primary drive components, adjust the clutch, and you're ready to ride!

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