

dodson[®]

INSTALLATION INSTRUCTIONS

GR6 CLUTCH CENTER MODIFICATION

DMS-00-0031 REV 004

24 MAY 2023

**PREPARED BY: GREG BUCHANAN
DATE: 24MAY23**

**RELEASED BY: J.PISL
DATE: 24MAY23** *AED*

REVISION UPDATE NOTES:

The following table indicates the changes we have made in either the disassembly or assembly of the product you have received. All changes are indicated by a revision bar in the margin.

If you have any questions email us at technical@dodsonmotorsport.com

Revision	Date	Description
REV.004	24MAY2023	<ul style="list-style-type: none">- Updated document name (was GR6 B-BASKET ASSEMBLY)- Page 3: Updated Step 2 with new machining specs for Dodson B-basket bearing.- Page 6: Added "Part 2" covering machining instructions for Dodson alloy pistons.
REV.003	24MAY2022	<ul style="list-style-type: none">- Revised formatting.- Added contents list and photo.
REV.002	13SEP2021	<ul style="list-style-type: none">- Updated to new format.

IMPORTANT NOTE

- FOR DODSON **"SUPERSTOCK WITH BASKETS"** CLUTCH KITS, ONLY **"PART 1"** OF THE FOLLOWING INSTRUCTIONS NEEDS TO BE COMPLETED
- FOR DODSON **"SPORTSMAN'S"** AND **"PROMAX"** CLUTCH KITS USING THE DODSON ALLOY PISTONS, BOTH **"PART 1"** AND **"PART 2"** NEED TO BE COMPLETED

GR6 CLUTCH CENTER MACHINING INSTRUCTIONS PART 1 - INSTRUCTIONS FOR B-BASKET (DMS-8092)

STEP 1

Ensure the basket and bearing you received are **NOT** already pre-assembled.



STEP 2

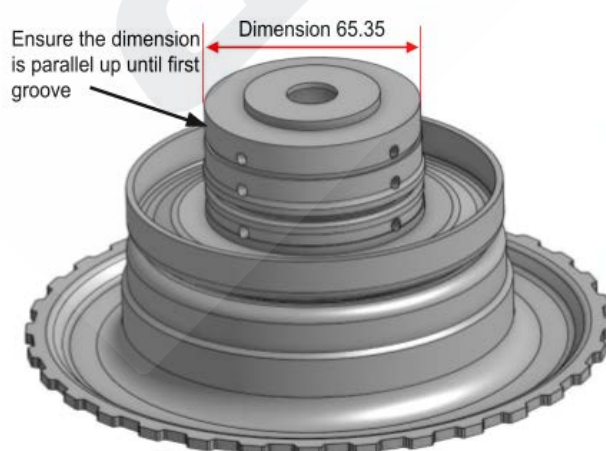
Prepare clutch center for the B-basket inner bearing fitment.

Measure the diameter of the top of the center. This dimension on the OE core should be between 65.42mm to 65.44mm.

Please note that there is a chance of this face being tapered.

Ensure the faces are parallel (up until the first groove) before installing the B-basket bearing.

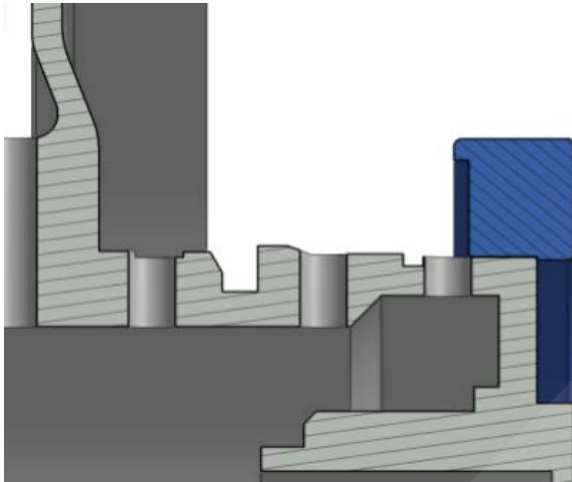
The clutch center needs to be machined to 65.35mm (+0.00, -0.03).



STEP 3

Test the fitment of the bearing on the clutch center. It should be a sliding fit and require no significant force.

NOTE: Ensure the bearing step is facing the clutch core.



For Dodson Superstock Clutches, the machining of the clutch center is now finished.

STEP 4

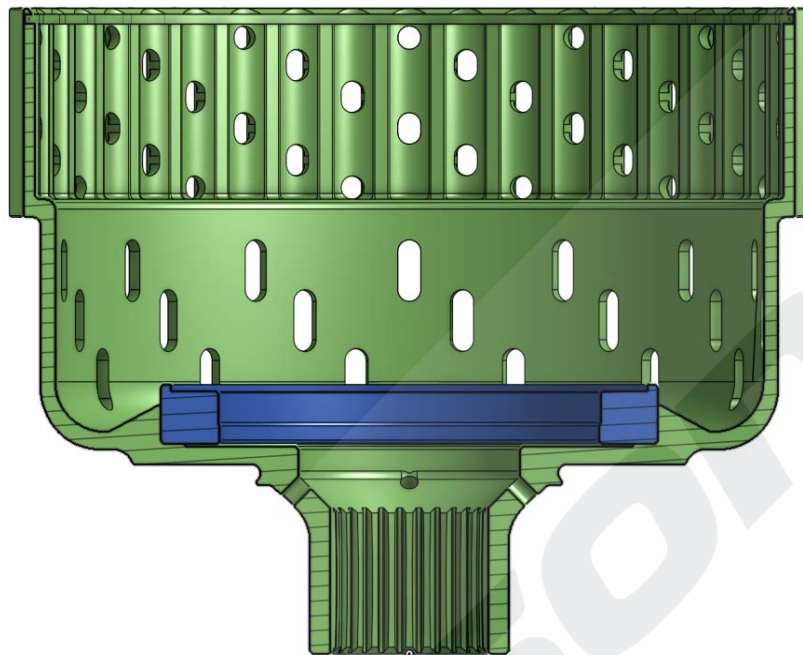
Install the thrust bearing on top of the clutch core.



STEP 5

Install the bearing inside the B-Basket.

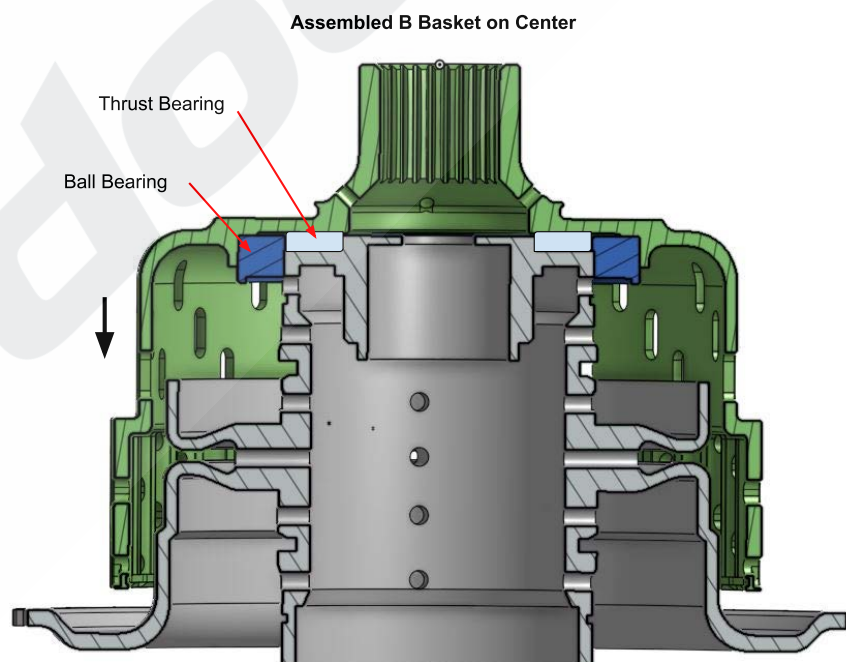
NOTE: Ensure the bearing step, with the larger internal diameter facing up.



STEP 6

Fit the B-basket onto the clutch core.

NOTE: It should be a sliding fit and require no significant force.



PART 2 - INSTRUCTIONS FOR SPORTSMAN'S AND PROMAX

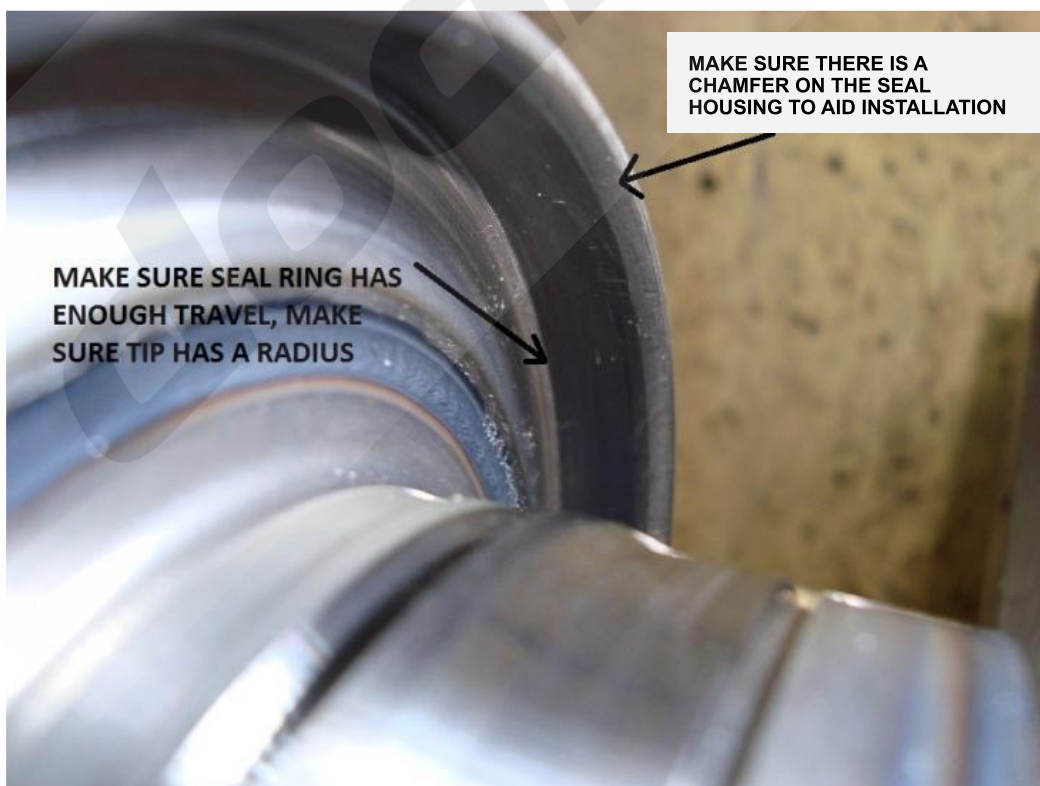
STEP 1

Check runout and concentricity of the part. Use a dial gauge to align the part correctly. Machine both surfaces until perfectly round. OEM inner diameter is roughly 110.15mm. You must machine this bore diameter to **110.50mm** It should be a polished finish as it is a seal face.



STEP 2

Machine a small chamfer on the seal housing edge to assist with piston installation. Polish the seal surface to speed up bed in.



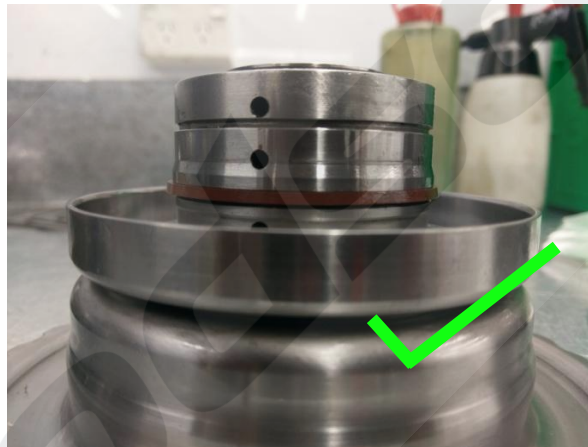
STEP 3

Machine the outside diameter to **114.50mm**. Make sure this part is thoroughly cleaned before use. Wire brush the teeth on the clutch centre to remove any burrs.



NOTE:

Remember to install the piston shaft seals during the reassembly of the clutch.



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