



INSTALLATION GUIDE

Harley-Davidson
Milwaukee 8
Cable-Actuated

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OVERVIEW

This kit replaces the OE (Original Equipment) or “stock” clutch pack.

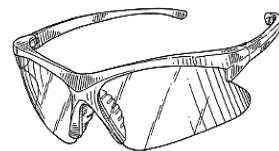
- This kit will replace all the OE frictions and drive plates with a Rekluse TorqDrive® clutch pack and EXP disk.
- No modification of the OE parts is necessary.
- This kit includes extra EXP springs, which can be used to tune for your desired engagement. See the **EXP tuning options** section in this document for specific tuning information.

⚠ CAUTION

Do not dyno-test this product without reviewing the included dynamometer document.

INSTALLATION TIPS

- Read the separate included Safety Information document before operating the vehicle with the product installed.
- Read this entire document before performing any steps.
- If you install this product for a customer or another person, instruct them to read the **Safety Information** document and the **Installation and User Guide** before operating the bike with the product.
- Videos related to this product can be viewed online at www.rekluse.com/support/videos.



- Protect eyes and skin – wear safety glasses and work gloves. Work in a well-ventilated area.
- Use the torque values listed in the instructions. Otherwise, use the torque specifications found in your OE service manual.
- Inspect your OE cable for fraying and replace it if needed.
- Visit www.rekluse.com/support for a full parts fiche illustration and part numbers.
- For optimal clutch performance, Rekluse recommends using fresh, clean oil that **meets JASO-MA** oil rating requirements. Rekluse offers Factory Formulated Oil™ developed specifically for Rekluse products. Rekluse Factory Formulated Oil is a perfect complement to any OEM or aftermarket wet clutch. Visit www.rekluse.com to learn more.

TOOLS

- SAE hex key set
- 4 mm hex key
- 5/8" Open-ended wrench
- Transmission Oil
- Telescoping magnet
- Torque wrench
- 1/2" socket
- 10 mm socket
- Dental pic
- Phillips screwdriver
- Torx bit set

INCLUDED PARTS

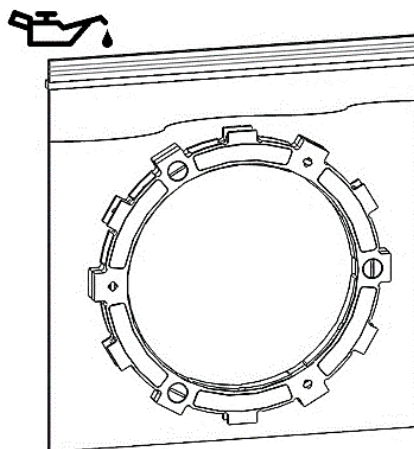
Refer to the included **Parts Fiche** for a detail of the components. Visit www.rekluse.com/support for a full parts fiche illustration and part numbers.

BEFORE YOU BEGIN

- Warm up the bike and check the idle speed before installing the clutch. The idle speed will determine which EXP springs to install for the optimal engagement setting. The chart can be found in the EXP tuning options section.
- Rekluse recommends replacing the chaincase cover gasket when installing this product.

DISASSEMBLE CLUTCH

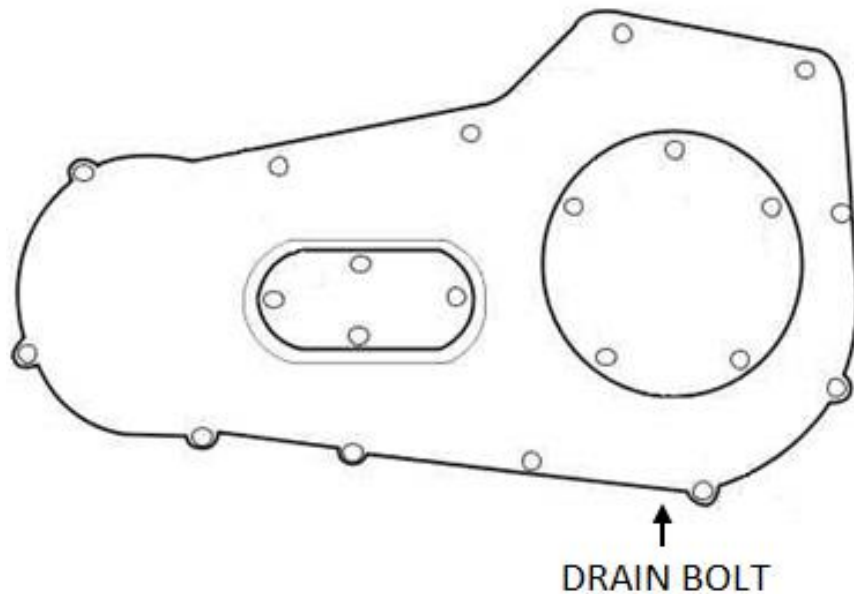
1. Make sure the bike has cooled before disassembling the clutch.
2. Soak the EXP disk and TorqDrive[®] friction disks in primary/transmission oil for 5 minutes. Make sure the EXP and friction disks are coated on both sides.



3. Stand the bike up on a suitable bike stand or lift.



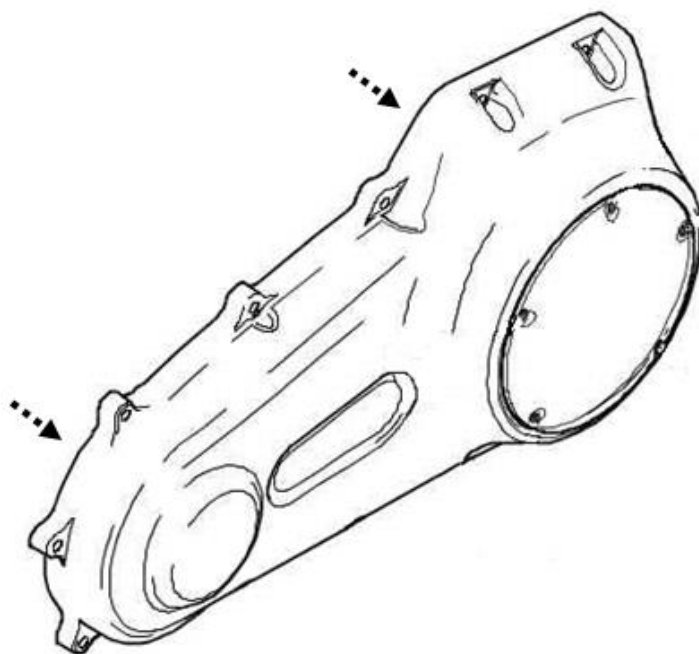
5. On the primary chain case, use a 5/8" wrench to remove the oil drain plug, then drain the oil.



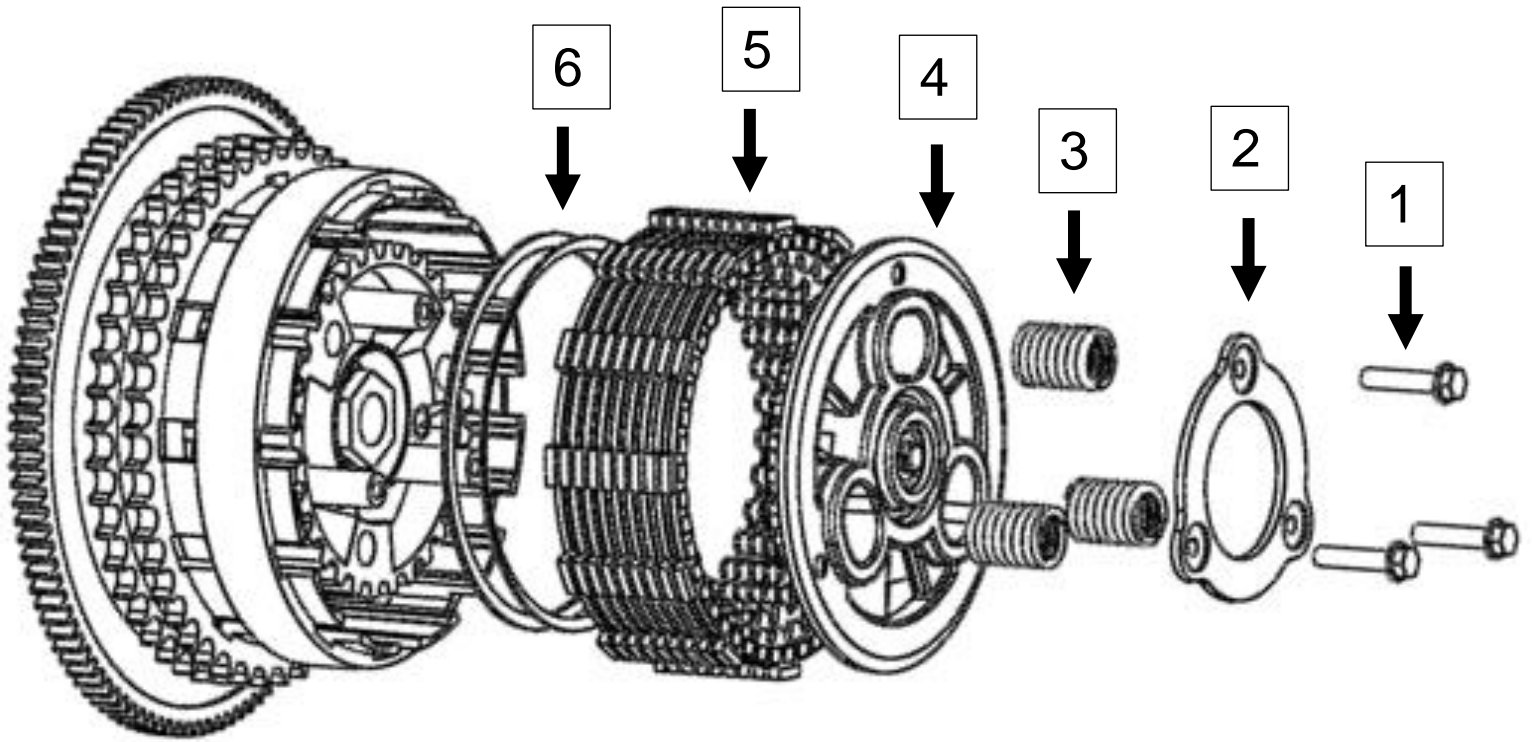
6. Remove any parts that are attached or blocking the primary chaincase cover. These may include the left floorboard, footpeg(s), shift lever, and/or the side stand.

Note: Before removing the shift lever, shift the bike into 5th gear.

7. Remove the primary chaincase cover.



8. Remove the following OE parts:



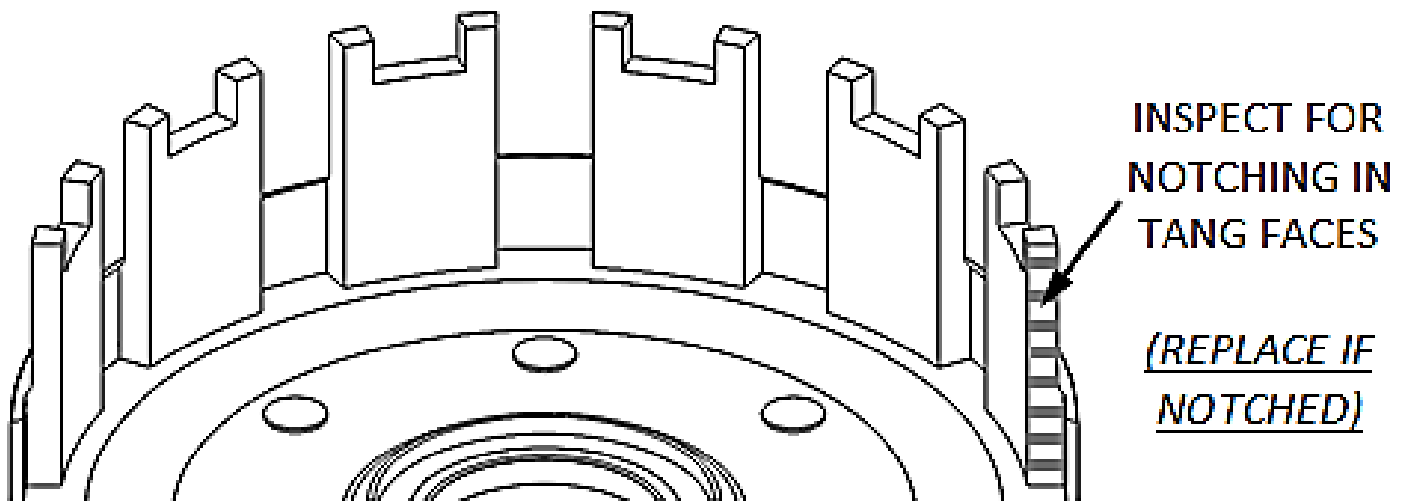
1	Spring ring bolts
2	Spring ring
3	Pressure plate springs
4	Pressure plate
5	Clutch pack
6	Damper spring and seat

INSPECT THE BASKET

⚠ WARNING

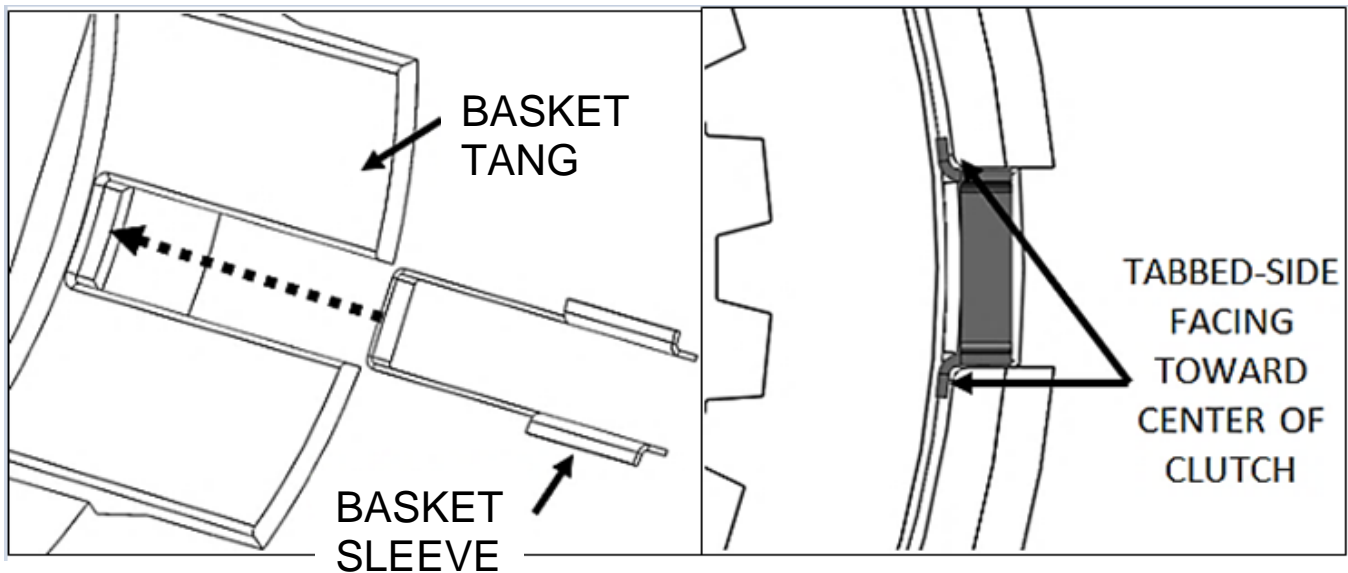
Failure to inspect the basket and replace it if necessary could result in death, serious injury, and/or property damage.

Inspect the clutch basket for notching. Do not install sleeves or use products with a notched basket. Notched basket tang faces can cause the sleeves to break. Do not use baskets that have been filed, machined, or modified on the tangs. Replace the basket if necessary.



INSTALL THE BASKET SLEEVES

Install **ALL** the Rekluse basket sleeves into the OE basket slots. Make sure the sleeve tabs sit against the inside of the basket, then push the sleeves down until they contact the bottom of the tang slot. See pictures for reference.



⚠ WARNING

Rekluse basket sleeves are designed to be installed into an OE or Rekluse clutch basket **ONLY**. The use of non-Rekluse aftermarket clutch baskets may cause clutch damage or failure.

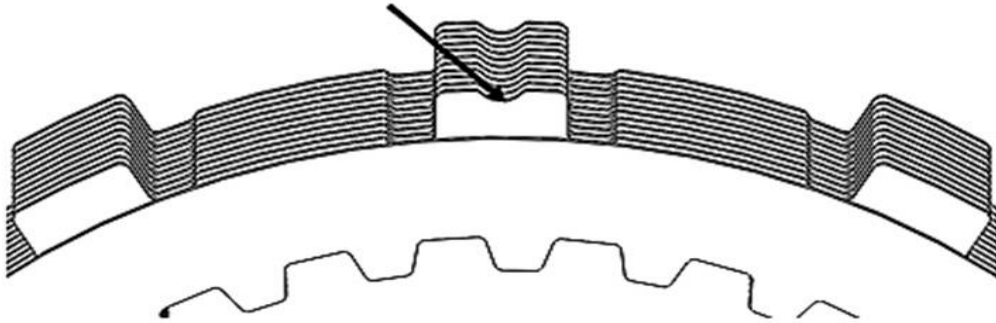
Note: *In some models, the sleeves will stick slightly above the top of the basket. This is normal.*

INSTALL THE CLUTCH PACK

Notes for installation

- When assembling the clutch pack, it is important to line up the alignment notches on the friction disk tabs. *Correct alignment is critical for optimal performance.*

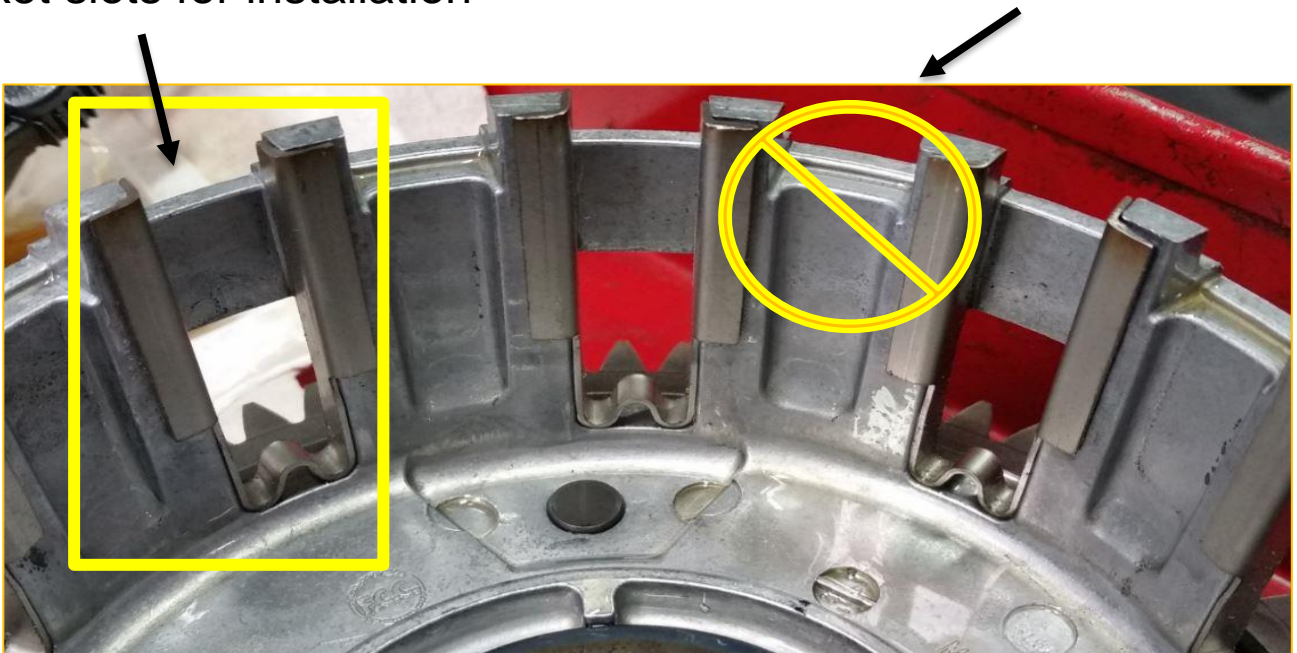
Align notches of friction disks



- Some friction disks are marked with a small colored dot. This mark is used for processing and can be ignored.
- Some OE baskets have “half slots” at the top of the basket tangs. Rekluse products require the entire clutch pack to be installed into the MAIN (deeper) basket slots. Installing the pack in the “half slots” will cause performance issues. See the following picture for reference.

Use only the deeper
basket slots for installation

Do not use the “half-slots”



Clutch Pack

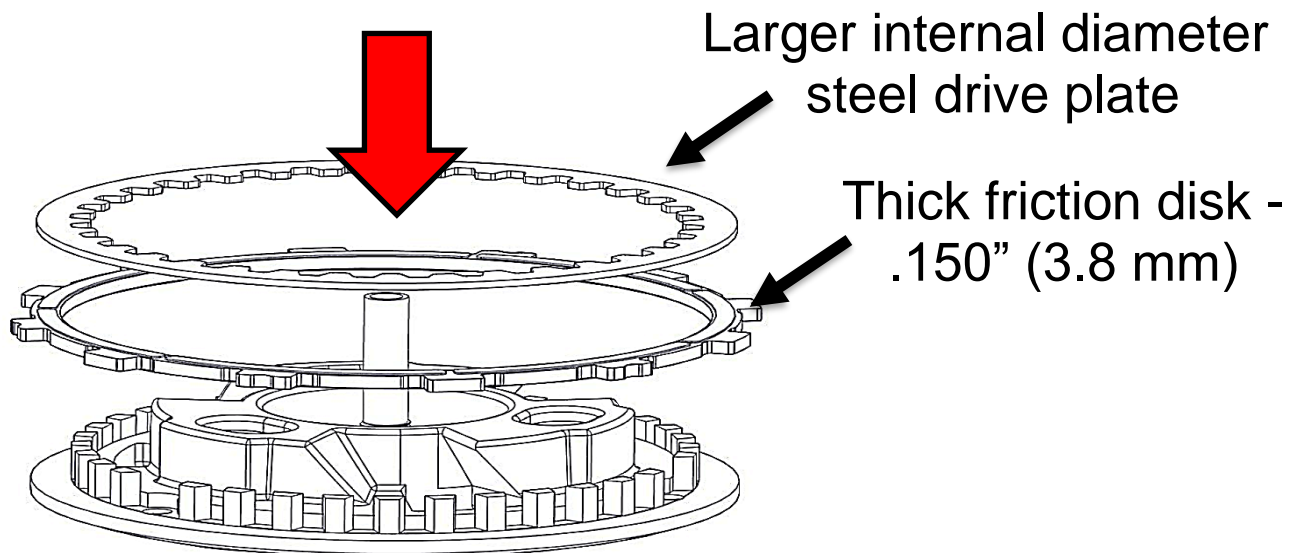
Install the clutch pack one plate at a time. Follow the **Setup Sheet** at the back of the manual for the order of clutch pack disk installation.

Do not install the last friction and the last drive plate. These will be placed on the pressure plate in the next step.

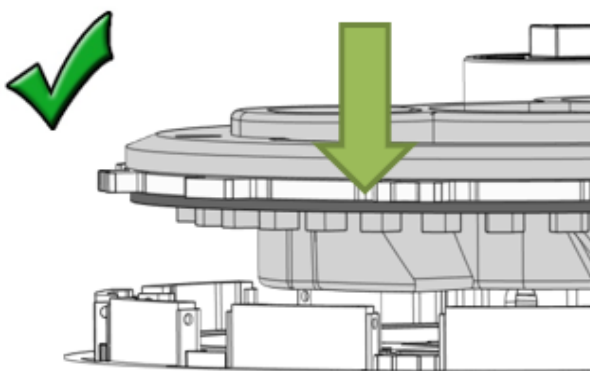
Note: *Using dental picks can help control the basket sleeves during the installation of the clutch pack.*

INSTALL THE PRESSURE PLATE

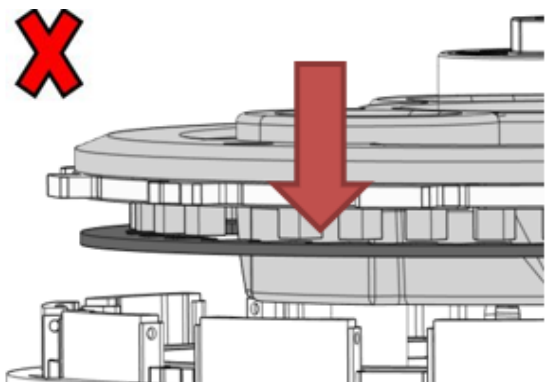
1. Install the remaining .150" (3.8 mm) thick friction on top of the pressure plate.
2. Install the narrow steel drive plate on top of the thick friction disk. Make sure the drive plate fits on the teeth of the pressure plate



3. Install the assembled pressure plate onto the clutch pack.
4. Make sure the steel stays indexed on the pressure plate. If this plate slips off, damage can occur.



Correct: Steel is indexed to pressure plate



Incorrect: Steel has slipped off

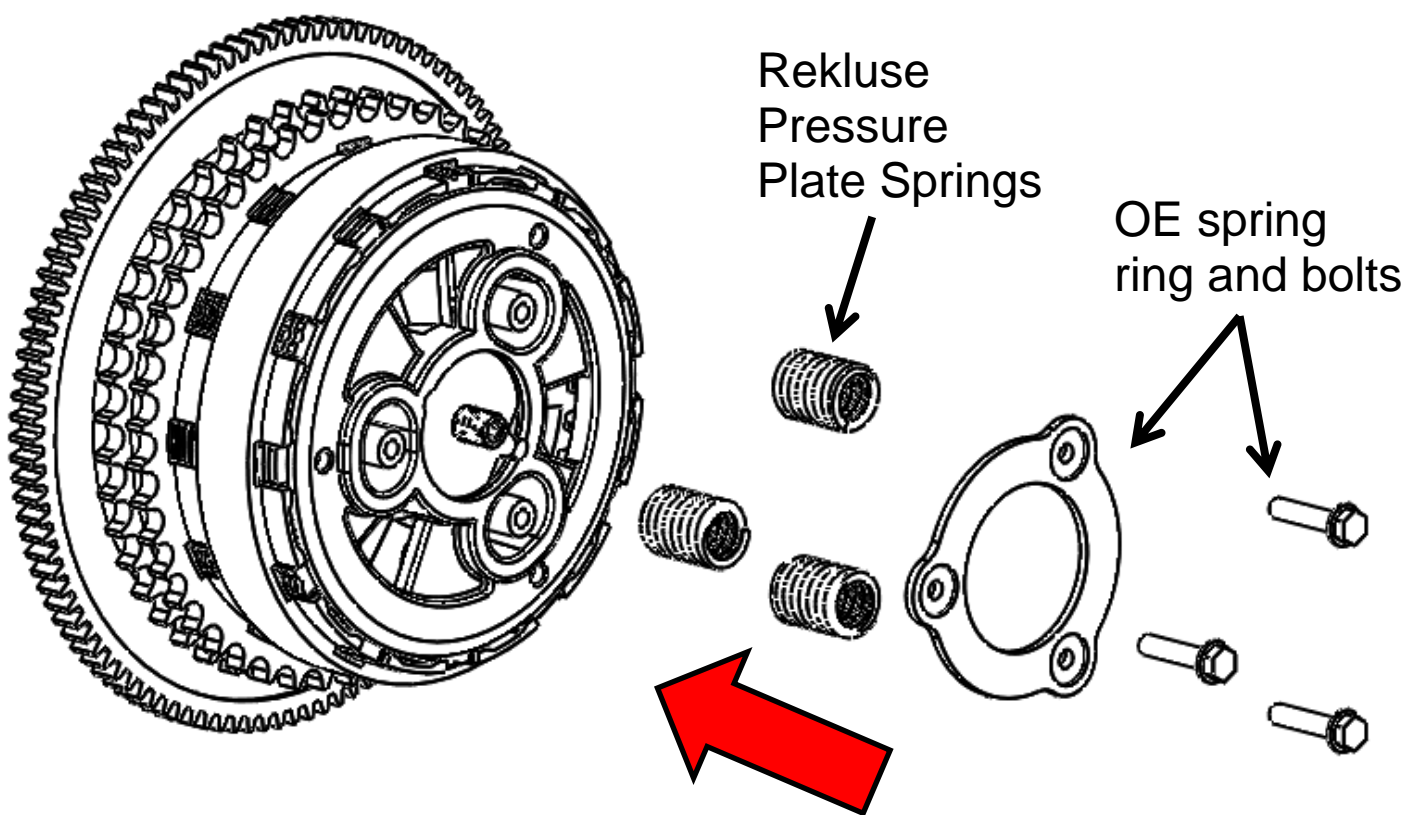
INSTALL THE CLUTCH SPRINGS

1. Select which pressure plate springs are best suited for your motorcycle and riding style using the table below. *For reference, the factory 3 spring clutch is rated to hold approximately 135 ft-lbs of engine torque.*

	Torque Capacity (ft-lb)	Change in Lever Pull	Spring Option	Spring Color
<u>RMS-6208</u>	165.0	+27%	Heavy Spring (744-127)	Yellow Stripe
	135.0	+4%	Standard Spring (744-126)	Black Stripe

Note: If you own a Trike or plan to tow with your motorcycle, Rekluse highly recommends selecting the “Heavy” spring option.

2. Install the Rekluse pressure plate springs, then install the OE spring ring and pressure plate bolts.



3. Torque the pressure plate bolts to **80 in-lb (9 N-m)**.

SET THE INSTALLED GAP

The installed gap is the separation in the clutch pack created by adjusting the Rekluse Adjuster Assembly.

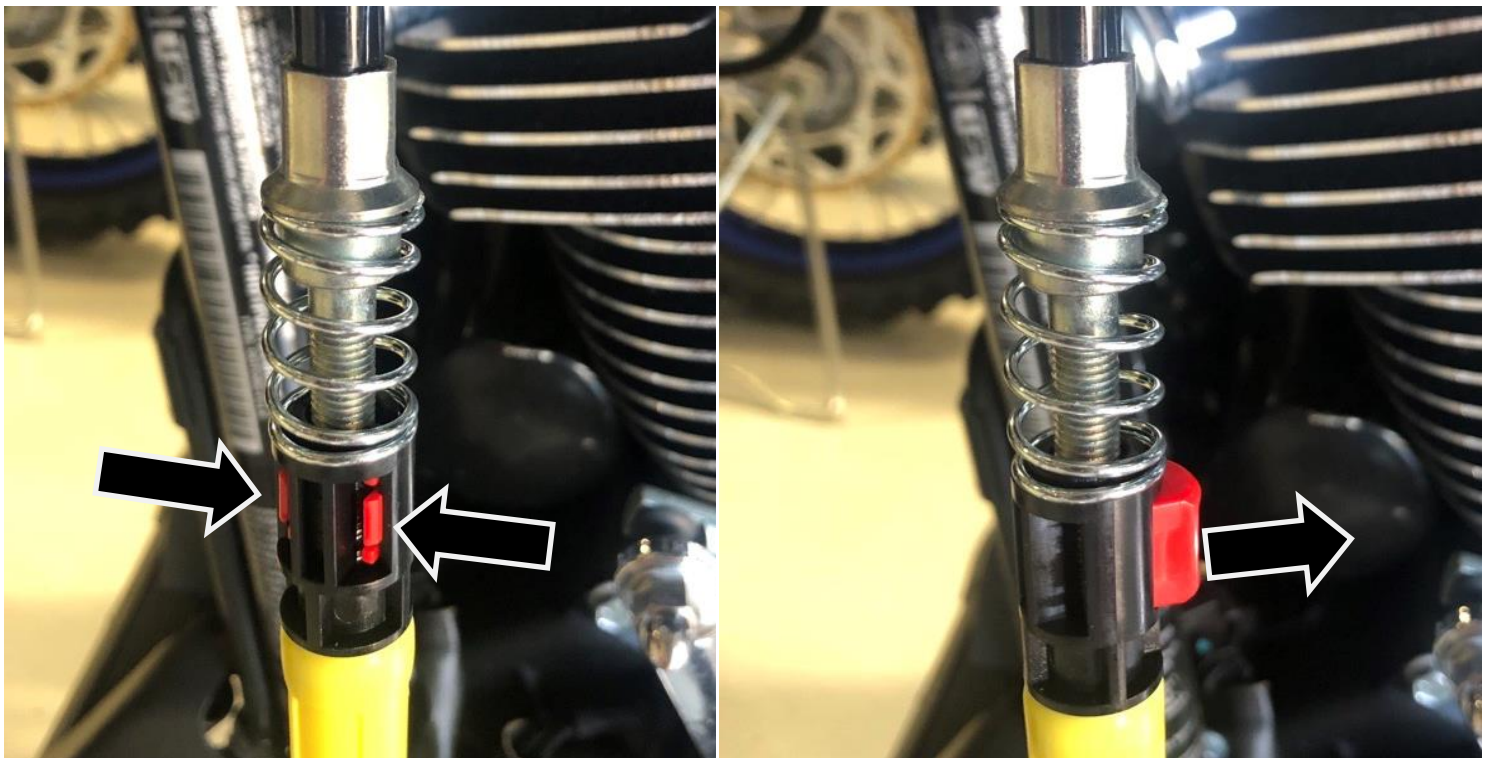
This gap is what allows the clutch to spin freely until the desired RPM is reached for engagement. The gap must be set correctly for optimal performance.

⚠ CAUTION

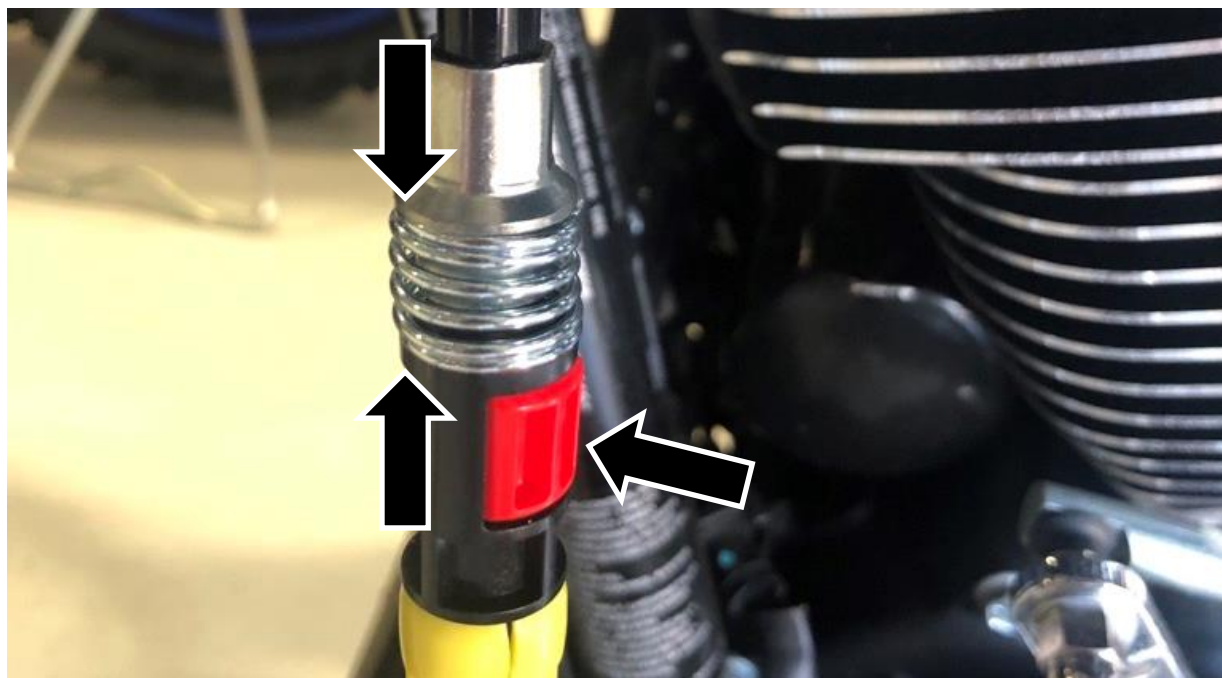
Do not ride your bike without adjusting the installed gap. You will not be able to disengage the clutch until you set the installed gap.

Collapse The Cable

1. Slide the black cover off the cable adjuster.
2. Unlock the red tab with a screwdriver.



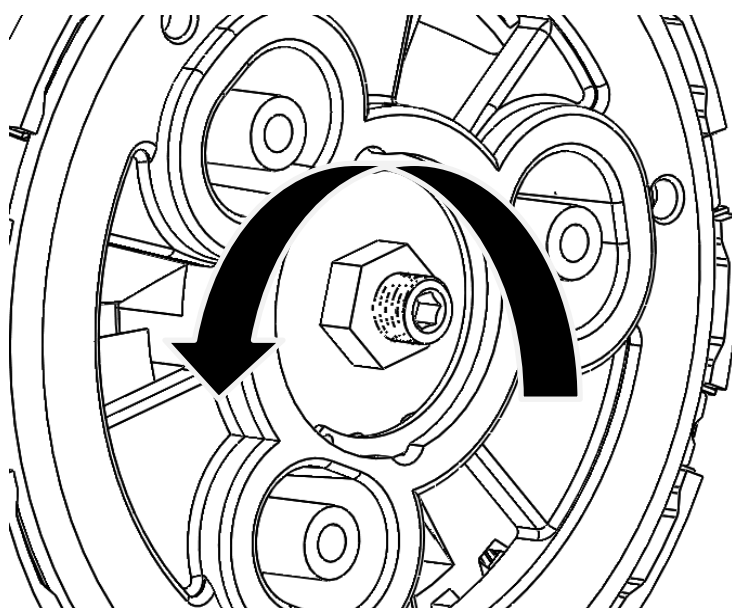
3. Compress the spring and relock the red tab to hold it.



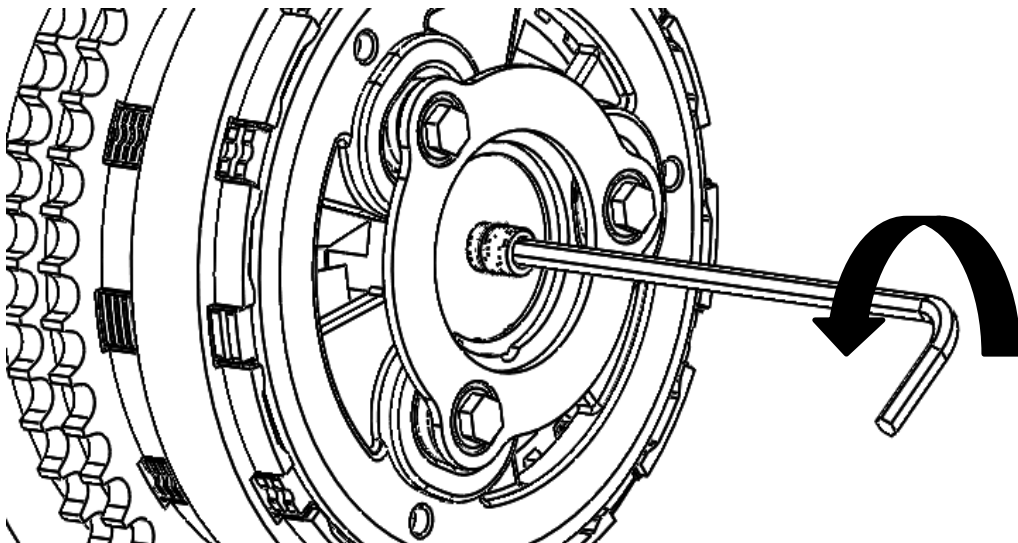
4. Check that the lever has a large amount of freeplay.

Set The Adjuster Screw

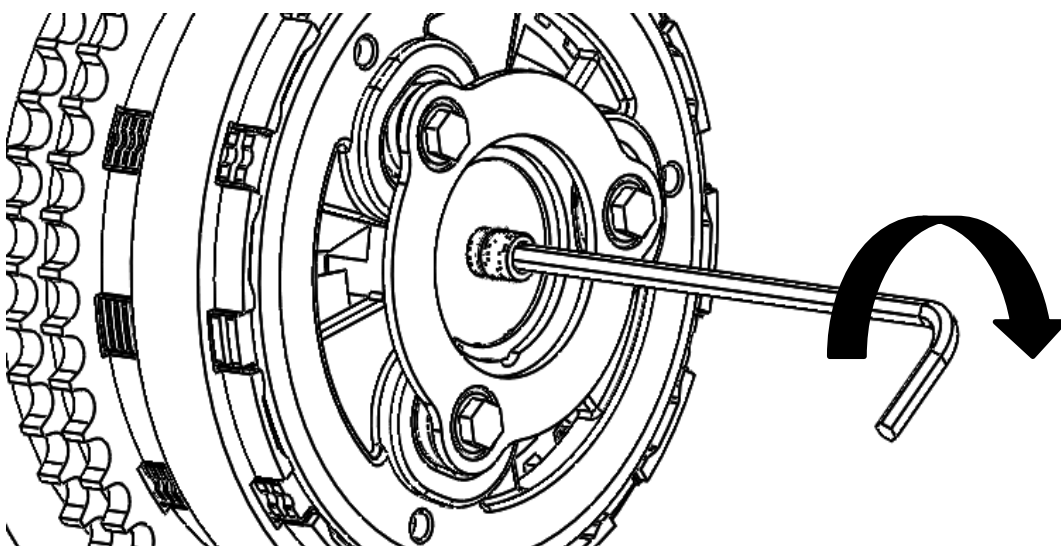
1. Loosen the jam nut



2. Turn the adjuster screw **COUNTERCLOCKWISE** until it spins freely



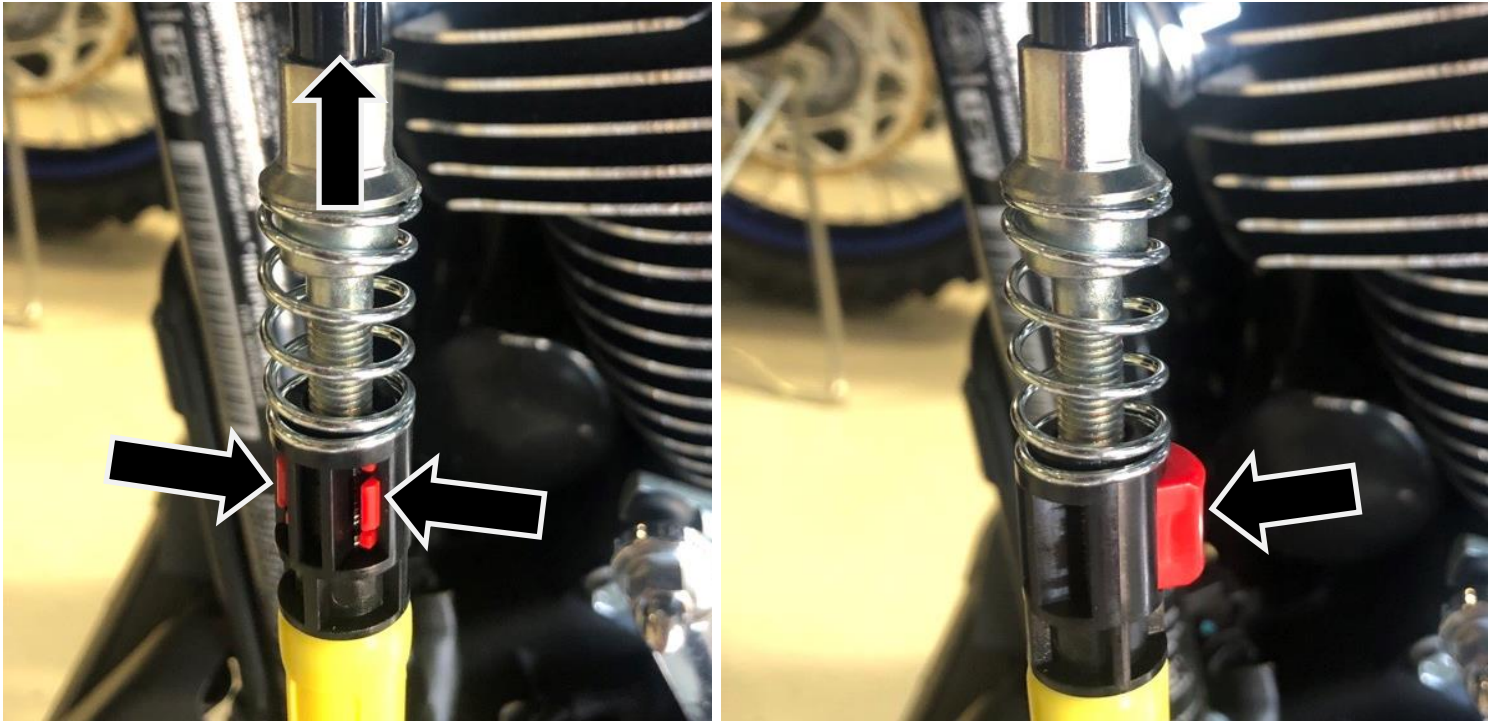
3. Next, gently turn the adjuster screw **CLOCKWISE** until it stops under moderate pressure.



- You are feeling for the point at which the screw bottoms out and starts to lift the pressure plate. This position is called your **starting point**.
4. Once you have found the starting point, tighten the adjuster screw 1 turn **CLOCKWISE** to lift the pressure plate.
5. While holding the adjuster screw from rotating, tighten the jam nut to lock it in place.

Reset the Cable Freeplay

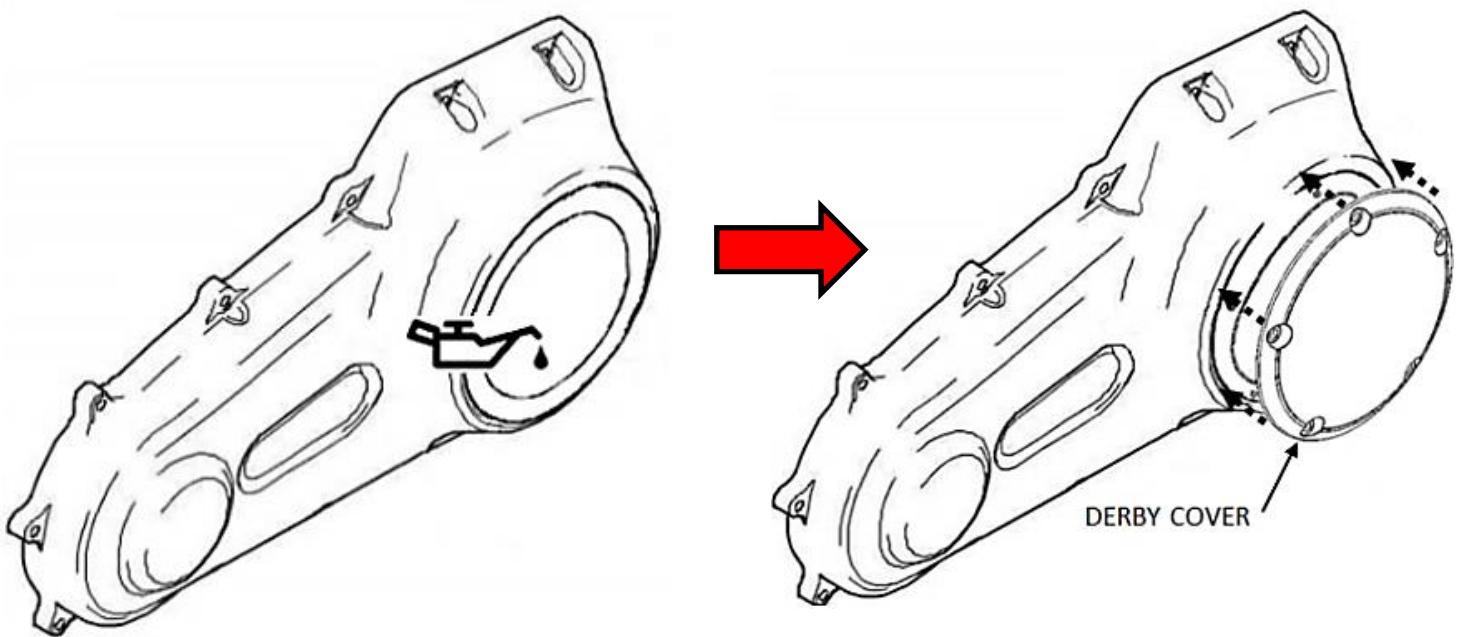
1. Release the red tab on the cable adjuster so that the spring expands, then press the red tab to lock the adjuster in place.



2. Check that the lever has the proper 1/16-1/8" of freeplay

INSTALL THE PRIMARY COVER

1. Thoroughly clean the mating surfaces of the primary cover and the engine case.
2. Reinstall the primary gasket, then reinstall the primary cover.
3. Torque the cover bolts to **84-108 in-lb (9.5-12.2 N-m)**.
4. Reinstall the drain bolt and torque it to **36-60 in-lb (4-6.8 N-m)**.
5. With the primary cover installed, use a T-27 Torx bit to remove the derby cover.
6. Using a funnel, add 1.25 quarts of oil to the primary case through the derby cover cavity. For optimal clutch performance, Rekluse recommends using fresh, clean oil that **meets JASO-MA** oil rating requirements. Rekluse offers Factory Formulated Oil™ developed specifically for Rekluse products.
7. Reinstall the derby cover.



Note: An accessory derby cover is available for the Harley-Davidson Milwaukee. If you purchased the Rekluse derby cover, install the cover now using the OE bolts.

CHECK FREE PLAY GAIN

It is very important that you understand how to verify the correct installed gap by checking Free Play Gain. The installed gap is what allows the auto function of the product to perform properly.

Correct Free Play Gain = Correct installed gap

Setup, break-in, and recheck of the installed gap are CRUCIAL. Failure to properly maintain your installed gap can result in premature wear or failure of your clutch. Use the following steps to verify the installed gap by checking Free Play Gain.

⚠ WARNING

Failure to check and verify Free Play Gain can cause failure or damage to this product. Setting the correct installed gap is critical for clutch performance.

Learn how to check Free Play Gain

If you are familiar with checking Free Play Gain, check for Free Play Gain then skip to the “Adjust the Installed Gap” section.

If Free Play Gain is new to you, follow the instructions below to help you learn this important step. You can also view the video entitled “How to Check Free Play Gain” on our website at <https://rekluse.com/support/videos>.

Checking Free Play Gain allows you to externally monitor the installed gap so you can know when to adjust if the installed gap is too large or too small.

The correct installed gap is verified by observing and feeling the increased freeplay movement in the clutch lever. This extra movement is called “Free Play Gain.”



Lever with "slack" removed

Lever position around 4,000 RPM

Free Play Gain
1/8"-1/4" (3 mm-6 mm) lever movement

- **If there is too much Free Play Gain**, the installed gap is too small.
 - The bike may drag and stall because it has difficulty disengaging the clutch. It may also be difficult to shift.
 - Too much Free Play Gain will not hurt the clutch, but it will negatively affect clutch performance.
- **With too little or no Free Play Gain**, the installed gap is too large.
 - This means when the EXP is fully expanded it does not lift the pressure plate. The clutch may slip and make the bike seem like it is losing power.

- The bike may not move forward even though the engine RPM increases as if the clutch lever is slightly pulled.
- Too little Free Play Gain will cause the clutch system to burn up.

Optimal Free Play Gain yields 1/8”-1/4” (3 mm-6 mm) of clutch lever movement, measured at the ball end of the lever. This measurement at the lever correlates to achieving the ideal installed gap.

Two Ways to Check for Free Play Gain

The following steps explain **2 ways** to check Free Play Gain. One way uses the rubber band Rekluse includes in the clutch kit, and one uses your hand. You can use either method to check for Free Play Gain.

Rekluse recommends that you begin with the rubber band method first to check for Free Play Gain and then learn the hand method. The rubber band will help you learn how to recognize Free Play Gain until you are comfortable with the hand method. Learning to check Free Play Gain by hand effectively and comfortably can make it easy to check Free Play Gain every time you ride.

The Rubber Band Method

Use the rubber band method for the initial setup. It can also be used before each ride until you feel comfortable checking the Free Play Gain using the hand method.

⚠ WARNING

BEFORE YOU BEGIN, verify that the bike is in **NEUTRAL** before checking Free Play Gain. Failure to do so may result in the bike lurching forward, and loss of control and/or injury may result.

A Rekluse auto-clutch can make your motorcycle appear to be in neutral when in gear, even when the engine is running and clutch lever is released.

Motorcycles equipped with a Rekluse auto-clutch can move suddenly and unexpectedly and cause riders to lose control. To avoid death, serious injury, and/or property damage, always sit on the motorcycle to start it.

- a) On the cable adjuster, un-index the cable.
- b) Before you begin, place the bike in **NEUTRAL**, start the engine, and let it warm up for 2-3 minutes to idle down and warm the engine oil.

- c) Stretch the included rubber band between your thumbs, then place the top end of the rubber band on the outer end of the left handlebar grip.



- d) While holding the top end of the rubber band against the handlebar, stretch the band downward, then loop it through itself.



- e) Pull the band through the loop, then attach it to the outside end of the clutch lever. This will take up the initial free play (slack) and put the lever in a position to detect the Free Play Gain.



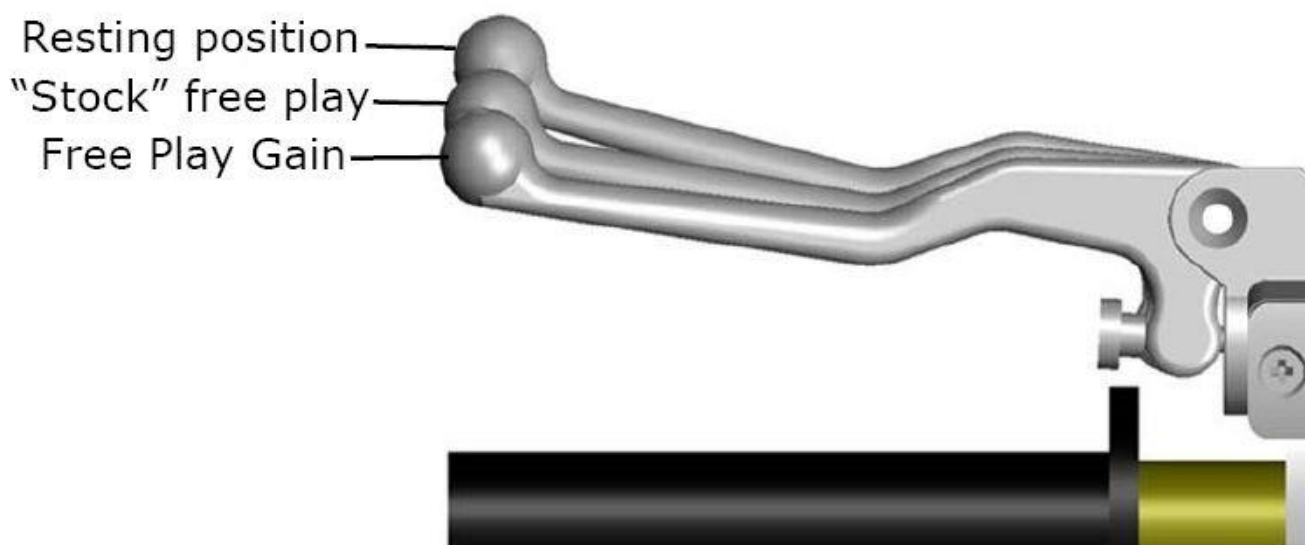
- f) While still in **NEUTRAL**, quickly rev the engine between 3,000-5,000 RPM (1/4 to 1/2 throttle), then let it return to idle. Notice the movement in the clutch lever when the engine is revved. This is your Free Play Gain.

Note: *It is very important the motor returns to idle before revving the engine again or Free Play Gain will not be correct.*

- g) When the bike returns to idle, rest your hand across the clutch lever. Rev the engine again to 3,000-5,000 RPM so you can observe the movement while feeling Free Play Gain with your hand.

The Hand Method

Use the hand method to check Free Play Gain before the start of every ride for optimum performance and longevity of your new clutch.



- a) Before you begin, place the bike in **NEUTRAL**, start the engine, and let it warm up for 2-3 minutes to idle down and warm up the engine oil.
- b) With the bike at idle, apply enough pressure to the clutch lever to take up the initial free play (slack) in the clutch lever.
- c) While still in **NEUTRAL**, continue to apply light pressure and quickly rev the engine between 3,000-5,000 RPM (1/4 to 1/2 throttle), then let it return to idle. Notice the movement in the clutch lever when the engine is revved. This is your Free Play Gain.
- d) When the bike returns to idle, rev the engine between 3,000-5,000 RPM a second time to verify the Free Play Gain again.

ADJUST THE INSTALLED GAP

After checking for Free Play Gain, you may need to adjust the installed gap. If Free Play Gain is optimal, continue to the section, “Break in the new clutch.” If Free Play Gain is not optimal, the installed gap needs to be adjusted.

The installed gap should be fine-tuned in small increments and then recheck Free Play Gain. Refer to the table below to set the properly installed gap based on your Free Play Gain.

Note: Before you adjust the installed gap, you need to unlock the adjuster cable lock by pulling the red tab out.

- Once adjusted, pull the clutch lever 5 times to reset the cable slack, then push the red tab in until it latches in the back to relock the cable.

Symptom	Reason	Solution
<ul style="list-style-type: none">• Too much Free Play Gain: The clutch lever moves too far• Clutch has excessive drag or stalls• It is difficult to fully override the clutch with the lever	The installed gap is too small	<p>Turn the adjuster clockwise to increase the Installed Gap.</p> <p>Recheck Free Play Gain.</p>
<ul style="list-style-type: none">• Too little Free Play Gain: The clutch lever only moves slightly or does not move at all• Clutch slips• The bike seems to lose power	The installed gap is too large	<p>Turn the adjuster counterclockwise to reduce the Installed Gap. It may be helpful to re-find the starting point.</p> <p>Recheck Free Play Gain.</p>

BREAK IN THE NEW CLUTCH

Once you install your new clutch, it is important to break it in. A series of roll-on starts are used to break in the clutch. Follow these procedures for breaking in your clutch and any time new friction disks, EXP bases, Teflon pads, or wedges are installed.

⚠ WARNING

Failure to follow the break-in procedure and oil screen inspection process could cause motor oil delivery failure, which can result in motor failure, serious injury, or death.

Break-in Procedure	Number of times
<p>1. Warm up the bike for 2-3 minutes. With the bike in NEUTRAL and your hand off of the clutch lever, rev the engine 10 times, being sure to let it return to idle between each rev cycle.</p>	<p>① N ② ③ ④ ⑤</p>
<p>2. With the engine still running, pull in the clutch lever, then shift the bike into 1st gear. Slowly release the clutch lever. The bike should stay running and in place, or have a slight amount of forward creep.</p> <p>3. With the bike idling in first gear, slowly apply the throttle to begin moving.</p> <p>4. Without using the clutch lever, accelerate moderately to approximately 3,500 RPM to fully lock up the clutch and come to a complete stop. Repeat 15 times.</p>	<p>① N ② ③ ④ ⑤</p> <p>15 roll-on starts</p>

Note: *If the engine wants to stall or the creep is excessive, the idle may be too high or the installed gap may be too small. Make necessary adjustments before proceeding.*

5. Place the bike in **NEUTRAL** and recheck Free Play Gain. Continue to adjust the installed gap until the clutch lever is 1/8"-1/4" (3 mm-6 mm).



Recheck Free Play Gain and adjust the installed gap if needed

Note: *Your clutch pack will expand with heat, so the final adjustment to Free Play Gain should be made when the bike is warm. Remember not to ride without sufficient Free Play Gain.*

⚠ CAUTION

Do not perform 2nd and 3rd gear starts with this product. Always keep the motorcycle in first gear when taking off from a stop. Taking off from a higher gear can cause premature clutch wear and damage to the product.

DO NOT DYNO TEST YOUR MOTORCYCLE BEFORE BREAK-IN! Always break in the product before performing dyno testing. Read the included dynamometer sheet for more information.

EXP TUNING OPTIONS

Adjusting the engine idle speed to match your engagement setting is important and greatly affects the overall feel of how the EXP disk engages.

To prevent freewheeling and maximize engine braking, set the idle so there is a slight amount of drag while the bike is idling in gear and warmed up. The idle should not be so high as to move the bike forward in gear with the throttle closed. However, with a small opening of the throttle, the bike should move forward.

You can tune the engagement RPM of the EXP disk by changing the spring configuration. The EXP disk comes set with the recommended “**Medium**” setting from Rekluse, based on an idle of RPM = 850 - 1050. If your idle is higher than 1050 RPM, it may be best to install the “High” spring setting. A low idle may benefit from a low spring setting.

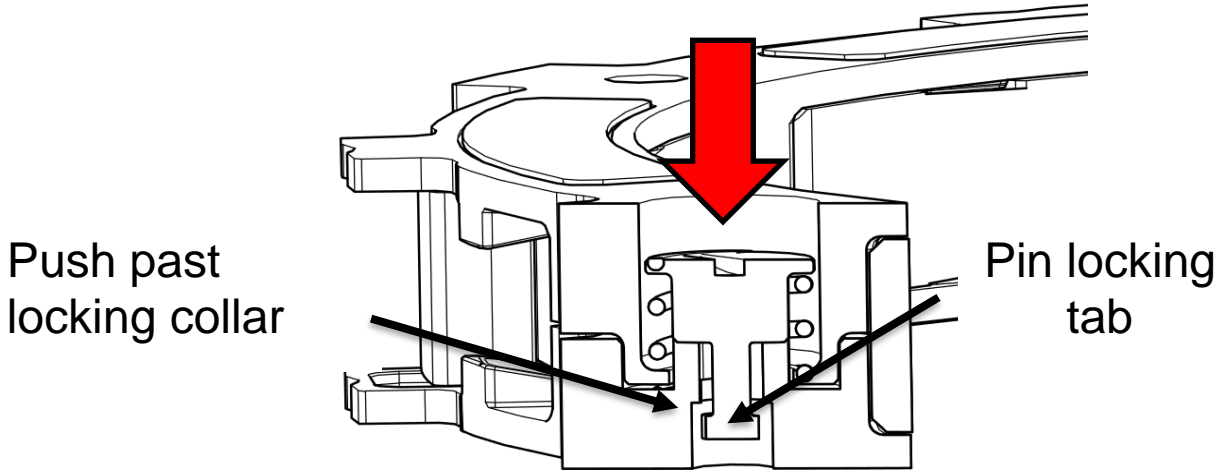
See the following chart for settings. Use the following steps to change the springs. It is **NOT necessary** to disassemble the EXP halves to change springs!

Engines with Stage 3+ modifications or modified cylinder heads/cams are recommended to be tuned to the **High** or **Extra High** setting.

Idle RPM	Engagement Spring Combination	Engagement setting
< 850 RPM	3 Green, 3 Gold	Low
850 - 1050 RPM	6 Green	Medium
1050 - 1150 RPM	3 Green, 3 White	High
> 1150 RPM	6 White	Extra-High

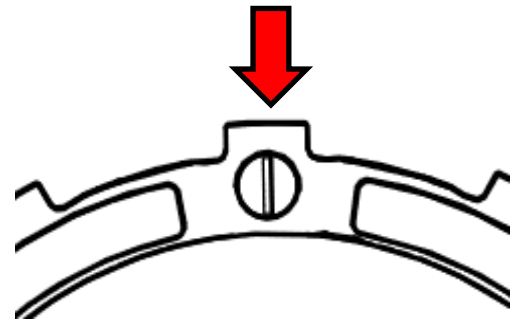
Changing the springs

1. Using a flat-blade screwdriver, push the $\frac{1}{4}$ turn pin in far enough for the locking tab to push out of the locking collar.
2. With the pin still pushed past the locking collar, turn 90° to remove the pin and spring.



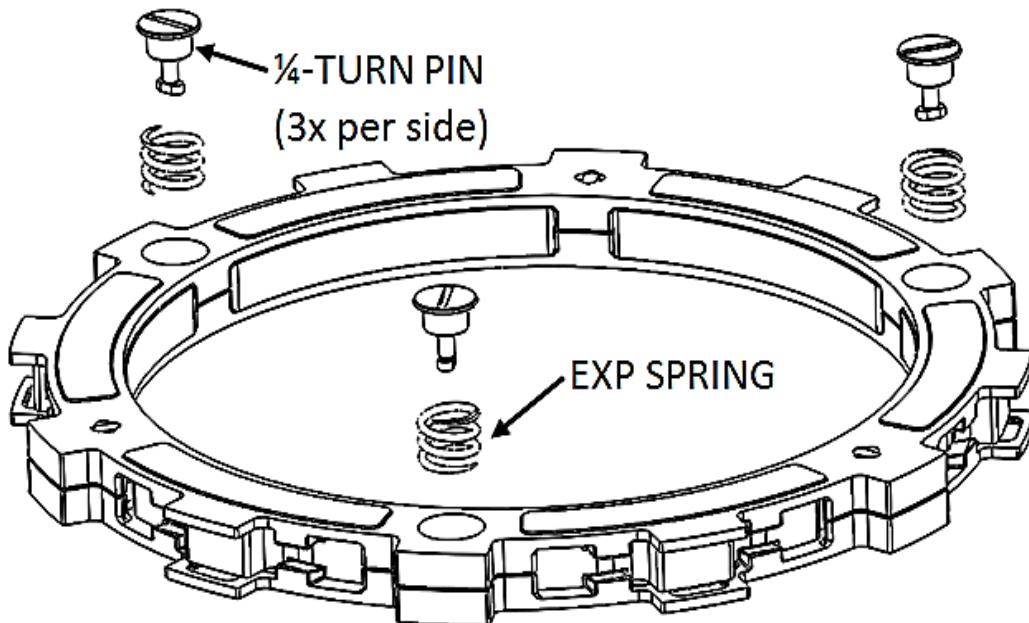
3. Remove the remaining 2 pins and springs from the same side of the EXP base.
4. Drop a new spring into the spring slot on the base, then add the $\frac{1}{4}$ turn pin.

NOTE: *Lining up the slot in the pin with the tab in the EXP will align the pin in the proper position for locking the pin.*



5. Push the turn pin in far enough to clear the locking collar, then turn 90° and release the pin. The pin should sit almost flush with the EXP base.

6. Flip the EXP friction disk over, and repeat on the other side depending on engagement preference.

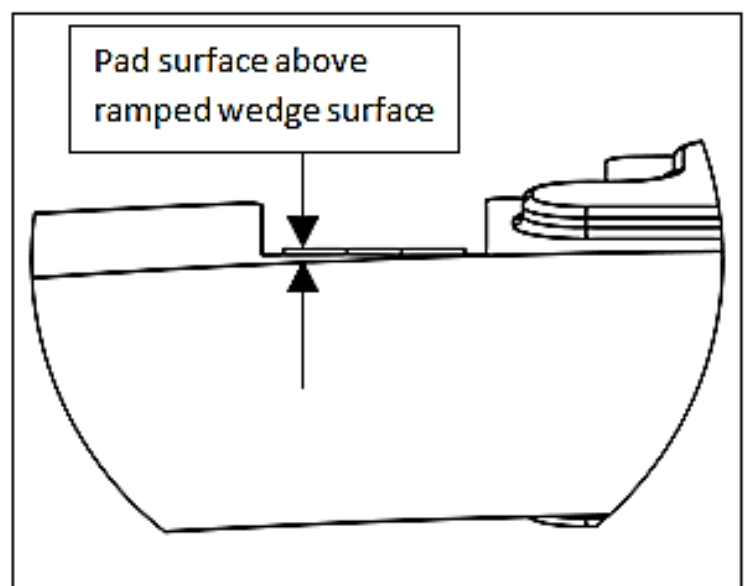
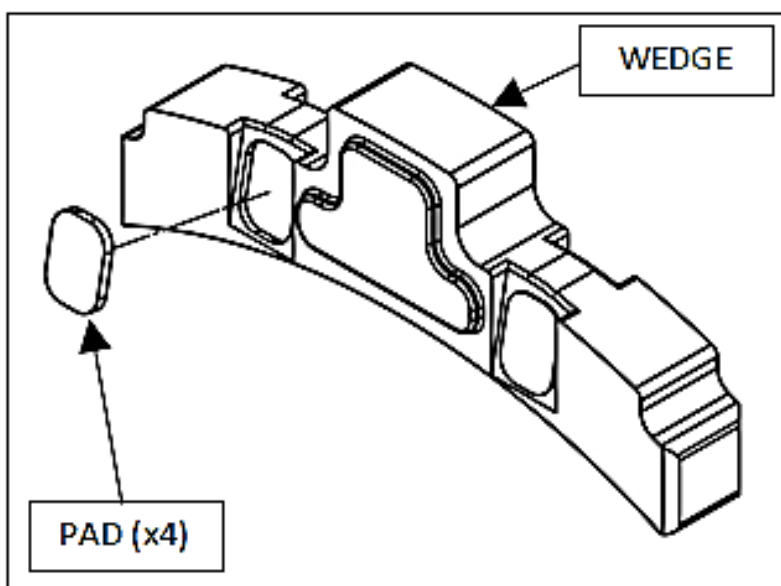


7. If you need to disassemble the EXP disk, you can watch the video on our website under Tech Tips at www.rekluse.com/support/videos/atv-mc-support-videos.

Note: To maintain even pressure, when using two different color spring sets, install one set of 3 on one side of the EXP and the remaining set of 3 on the other side.

CAUTION

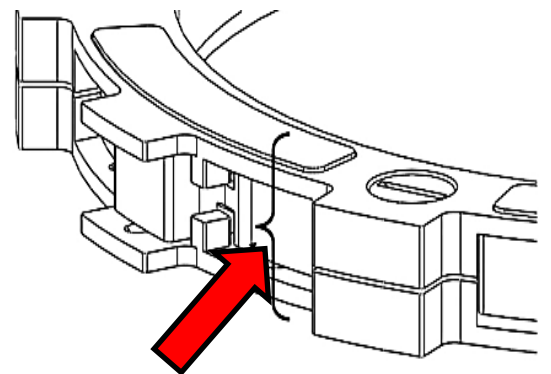
If you disassemble the EXP, the Teflon pads may fall out or be stuck to the ramp surfaces of the EXP bases. Take care to ensure all pads are correctly placed into wedge pockets using gentle pressure to avoid damage to the pad surfaces before reassembling the EXP. Properly seated pads will be secured in place once the EXP is reassembled. Operating the clutch without the pads in place will cause part damage or failure.



MAINTENANCE

To keep your clutch performing at its best, perform regular maintenance on your bike and clutch.

- Inspect all of your clutch parts for signs of wear or excessive heat, and replace components as necessary. This includes your basket sleeves and/or dampers. Clutch wear is dependent on the rider's use.
- If you frequently adjust your cable to fix Free Play Gain, drag, or performance issues, the clutch pack may need to be replaced.
- Measuring the clutch pack and/or the EXP disk can help determine if the components need replacing.
 - Friction disk minimum allowable thickness = **0.065"**
(1.65 mm)
 - Thick Friction disk minimum allowable thickness = **.145"**
(3.68 mm)
 - EXP disk minimum allowable thickness = **.586" (14.9 mm)**
- Repeat the break-in procedure anytime you replace the friction disks.
- Always soak the EXP, wedges, and friction disks in oil for at least 5 minutes before installing.
- Replace friction disks if they measure below specifications or if the disks are glazed and/or burnt.
- Replace the drive plates if they show signs of excessive heat.



Measure EXP
for allowable

Disk inspection examples

When inspecting the clutch pack, the following pictures can be used as a reference. **These are best viewed in color by viewing this install document on www.rekluse.com/support.**

Drive Plates – If the clutch pack is getting high amounts of heat, purple, blue, or black color can be seen on the drive plate teeth. See the pictures below. Not all drive plates look the same and may look different than pictured.



Normal Heat

High Heat
(Blue)

Excessive Heat
(Black)

Friction Disks – Due to the dark color of the friction material, the friction disks will appear almost black as soon as they are put in oil. During inspection, look for glazing of the friction material. Glazing will appear shiny and feel like glass, even after the oil is cleaned from the friction disk. Not all friction disks look the same and may look different than pictured.



Normal Friction



Glazed Friction

TROUBLESHOOTING

Clutch Drag:

- Make sure the bike has reached operating temperature. Drag may occur when the engine is cold
- Check that freeplay gain is set properly. Incorrect freeplay gain may cause drag.
- Check idle speed. If idle speed is too high, drag may occur. Refer to the EXP adjustment chart for further tuning.
- Put in new Rekluse recommended oil. Old or improper oil can cause performance issues.
- Check the clutch pack for signs of excessive heat or warpage.

Clutch Slip:

- Inspect the clutch for signs of excessive heat.
- Check that freeplay gain is set properly. Incorrect freeplay gain can cause slip.
- If clutch slip persists, heavier clutch springs are recommended.

LEVER SAFETY STRAPS

Your kit includes 2 Velcro-type straps to be used to secure both the clutch and front brake levers when the bike is parked.

These straps are intended to reduce the risk of injury or damage that may occur from the bike rolling or launching unexpectedly with or without a rider. Use the lever safety straps every time you park or leave the bike. **Refer to the Safety Information sheet for more information.**

1. Pull the lever tight against the handlebar.
2. Wrap the Velcro safety strap around the lever and handlebar, pull it tight, then fasten it.



Clutch Lever Strap: to prevent unwanted launching.



Brake Lever Strap: for use as a parking brake.

NEED ADDITIONAL HELP?

Website

www.rekluse.com/support

Phone

(208) 426-0659

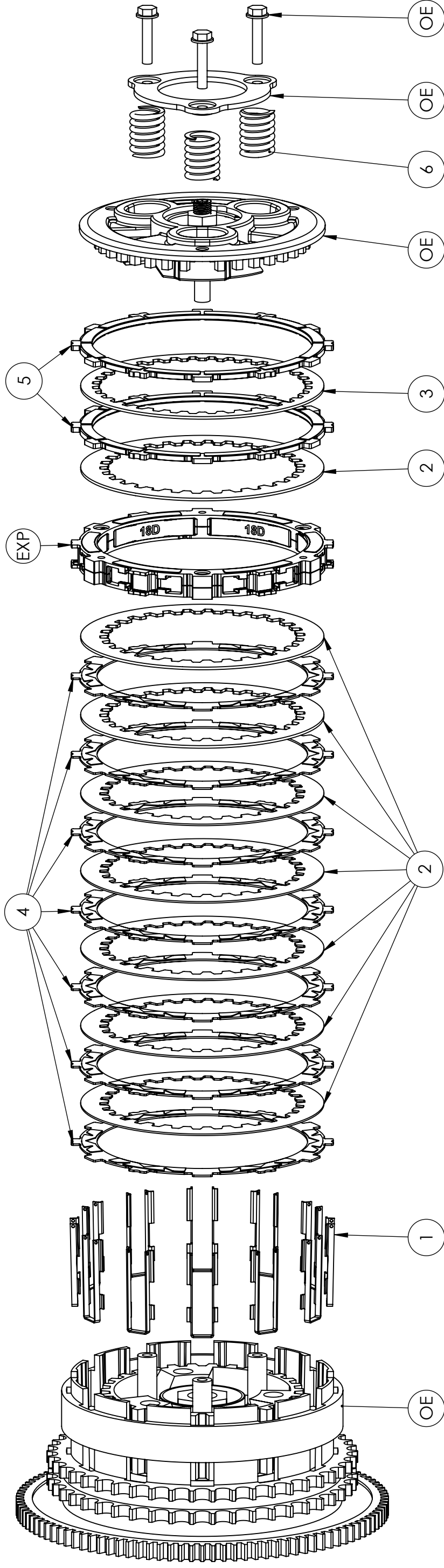
Monday thru Friday: 8 am – 5 pm Mountain Time

Email

tech@rekluse.com



SETUP SHEET 198-6208



SERVICE LIMITS

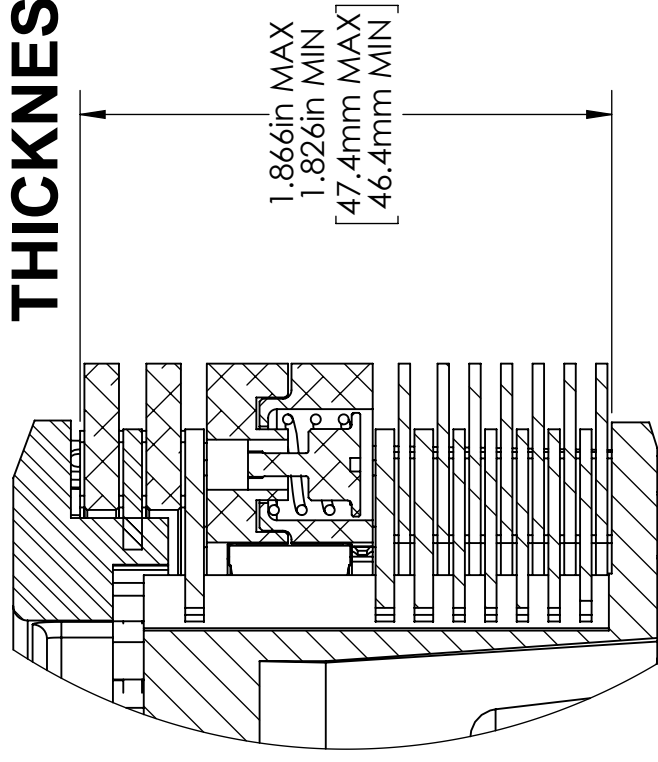
COMPONENT	STANDARD	SERVICE LIMIT
TORQDRIVE FRICTION	.068-.072in 1.73-1.83mm	.065in 1.65mm
THICK FRICTION	.116-.120in 2.95-3.05mm	.113in 2.87mm
EXP	.596-.616in 15.1-15.6mm	.586in 14.9mm

TUNING OPTIONS

ENGAGEMENT RPM	EXP SPRINGS
LOW	3 GREEN & 3 GOLD
MEDIUM *	6 GREEN
HIGH	3 GREEN & 3 WHITE

* MEDIUM SETTING IS PREINSTALLED IN THE EXP DISC

CLUTCH PACK THICKNESS



COMPONENTS

ITEM NO.	DESCRIPTION	QTY.
1	BASKET SLEEVES	12
2	DRIVE PLATE - .065	8
3	DRIVE PLATE - NARROW	1
4	TORQDRIVE FRICTION	7
5	THICK FRICTION DISC	2
6	CLUTCH SPRING	3
EXP	EXP DISK	1
OE	OE COMPONENTS	VAR.