

# SERVICE BULLETIN



M-1080

May 17, 1999

## CLUTCH INSPECTION COVER QUAD RING (Part No. 25416-84A)

### General

Harley-Davidson has learned that compression of the clutch inspection cover O-ring on some vehicles with 1998 and earlier Evolution engines can lead to distortion of the cover resulting in leakage of the primary chaincase lubricant. To correct this problem, a new quad ring seal (Part No. 25416-84A) has been developed that requires less compression than the old style O-ring seal.

Since Harley-Davidson will no longer be selling the old style O-ring seal (Part No. 25416-84), use the new quad ring when repairing a leak or installing a new clutch inspection cover. We recommend that you follow the procedures below.

### Removal

1. Remove three socket screws with rubber sealing washers to remove clutch inspection cover from primary chaincase cover. Discard sealing washers.
2. Remove O-ring from groove of clutch inspection cover. Discard O-ring.

### Inspection

1. Check the clutch inspection cover for warpage.
2. Discard the clutch inspection cover if warpage exceeds 0.010 inch (0.25 mm).

#### NOTE

*Covers warped greater than 0.010 inch (0.25 mm) will not allow the seal to be properly compressed.*

### Installation

1. Obtain **new** quad ring (Part No. 25416-84A). The ring is identified by a white paint dot. Verify that white paint dot is present before installation.
2. Swab all lubricant from the quad ring groove.

#### NOTE

*If lubricant is not thoroughly removed from both the quad ring and groove, compression of the quad ring during installation of the clutch inspection cover can cause lubricant to be squeezed to the outboard side of the ring groove, resulting in some temporary weepage around the inspection cover.*

3. Install quad ring into primary chaincase cover with the nubs contacting the ring groove walls. For best results, proceed as follows:
  - a. Place quad ring into position above groove in clutch inspection cover with the flat sealing surface of the ring facing upward.
  - b. At three or four locations equally spaced around circumference of seal, press quad ring into groove so that the nubs contact the ring groove walls.
  - c. Place clutch inspection cover over quad ring and press ring into place.
  - d. Remove cover and carefully inspect ring to verify that it has not rolled over.

#### CAUTION

**Align holes in clutch inspection cover with those in primary chaincase cover and place into position. Do not place cover into position and then rotate to align holes or quad ring may be rolled over in the groove. A rolled over quad ring can result in leakage of the primary chaincase lubricant.**

4. Install clutch inspection cover in primary chaincase cover. Install three socket screws using **new** rubber sealing washers. Alternately tighten screws to 50-70 in-lbs (6-8 N-m).

ROUTING	SERVICE MANAGER	SALES MANAGER	PARTS MANAGER	LEAD TECHNICIAN	TECHNICIAN NO. 1	TECHNICIAN NO. 2	TECHNICIAN NO. 3	TECHNICIAN NO. 4	RETURN THIS TO:
INITIAL HERE									

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