
GROUP 21B

CLUTCH OVERHAUL

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GENERAL SPECIFICATIONS

M1212000200171

Item		Specification
Clutch disc	Type	Dry single disc type
	Facing size mm	240 × 160
Clutch cover	Type	Diaphragm spring pull type
	Set load N	9320
Clutch control		Hydraulic system

SERVICE SPECIFICATIONS

M1212000300145

Item	Limit mm
Depth of rivets from clutch disc facing surface	0.3
Difference in height of clutch cover diaphragm spring fingers	0.5

TORQUE SPECIFICATIONS

M1212001800143

Item	Torque N·m
Clutch tube flare nut	15 ± 2
Clutch fluid line bracket bolt	18 ± 3
Release cylinder mounting bolt	18 ± 3
Release fork shaft mounting bolt	9.8 ± 2.0
Release cylinder union bolt	22 ± 2
Clutch cover bolt	18 ± 3
Release cylinder air breather	11 ± 1

LUBRICANTS

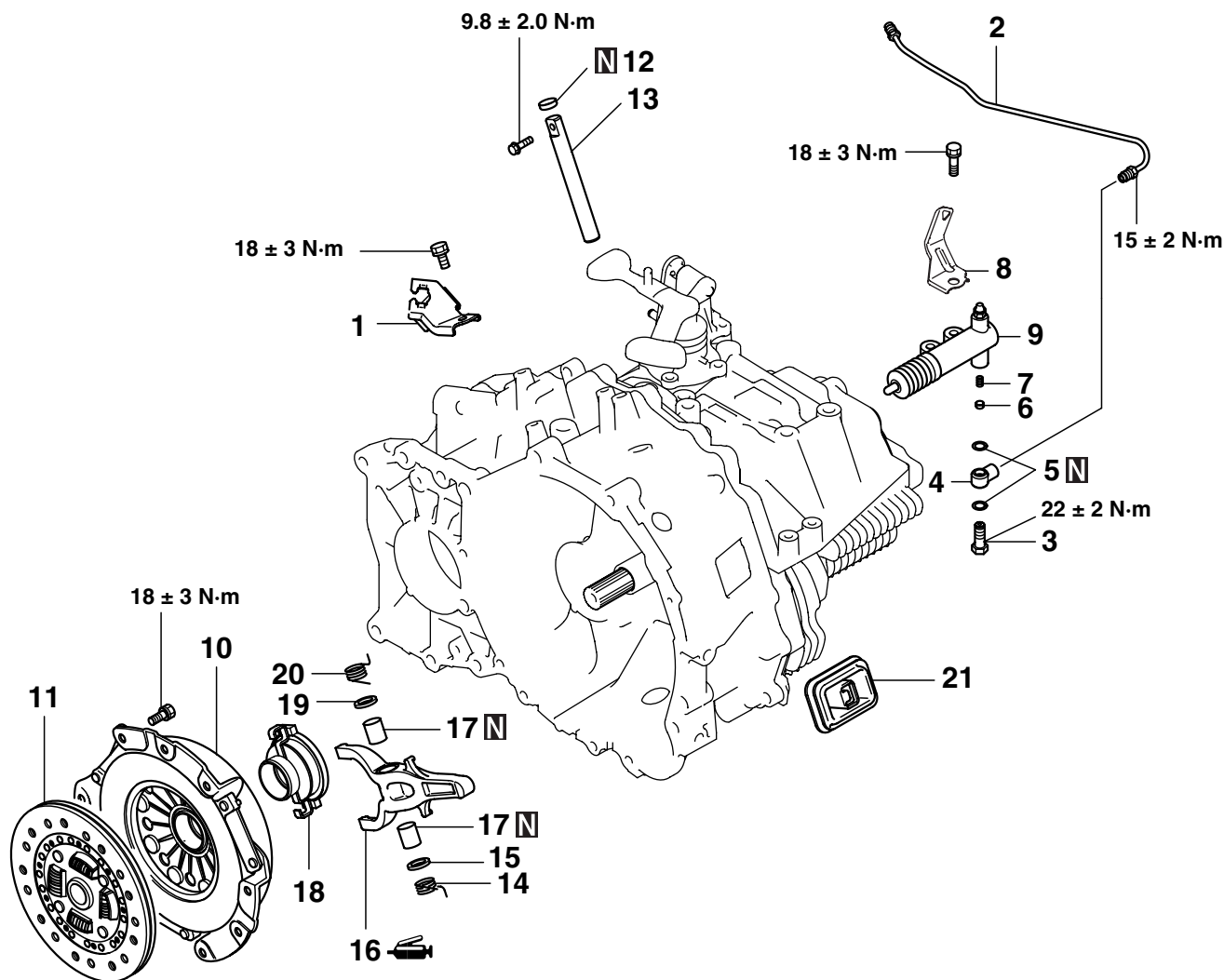
M1212000400153

Item	Specified lubricants
Release fork to release cylinder push rod contact surface	MITSUBISHI genuine grease Part No. 0101011 or equivalent
Release fork to release fork shaft rubbing surface	
Release fork to release bearing contact surface	
Piston and piston cup outer surfaces	Dia Queen Brake Fluid Super 4 or equivalent
Release cylinder inner surface	

CLUTCH

DISASSEMBLY AND REASSEMBLY

M1212001000158



AK501884AB

Removal steps

1. Clutch fluid line bracket
2. Clutch tube
3. Union bolt
4. Union
5. Gasket
6. Valve plate
7. Valve plate spring
8. Corrugate clamp bracket
9. Release cylinder
10. Clutch cover assembly
11. Clutch disc

>>E<<

>>E<<

>>D<<

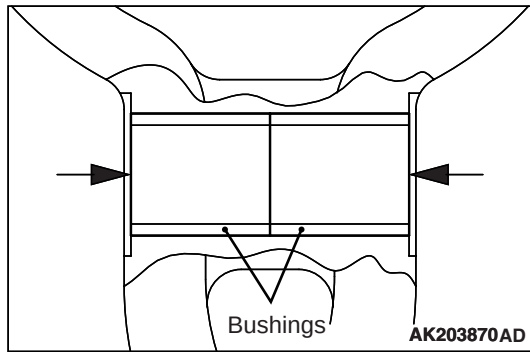
>>C<<

>>B<<

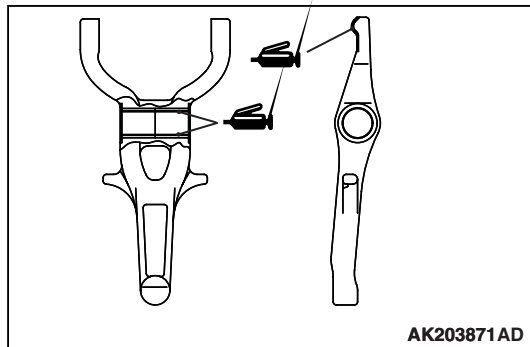
>>A<<

Removal steps (Continued)

12. Sealing cap
13. Release fork shaft
14. Support spring (L)
15. Packing
16. Release fork
17. Bushing
18. Clutch release bearing
19. Packing
20. Support spring (R)
21. Release fork boot

REASSEMBLY SERVICE POINTS**>>A<< BUSHING INSTALLATION**

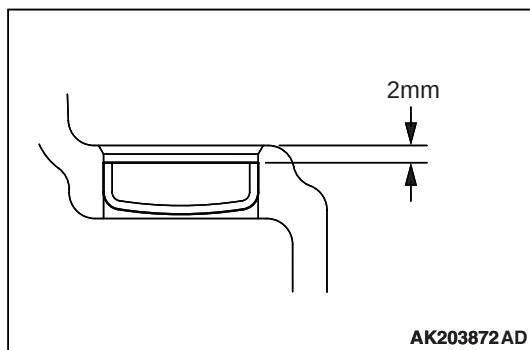
Press fit the bushing into the release fork as shown in the drawing.

>>B<< RELEASE FORK INSTALLATION

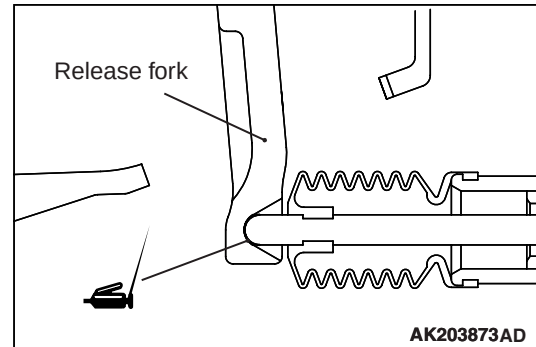
Grease the release fork at the areas indicated in the drawing.

Grease

Brand: MITSUBISHI genuine grease Part No. 0101011 or equivalent

>>C<< SEALING CAP INSTALLATION

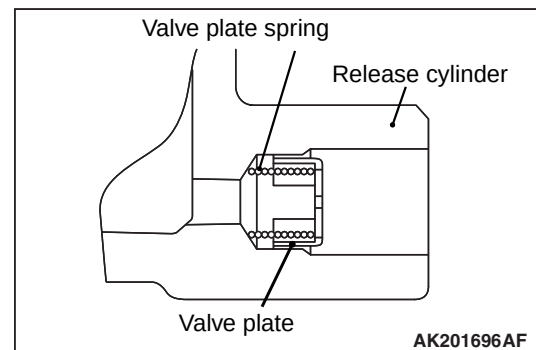
Press fit the sealing cap into the release fork to a depth indicated in the drawing, making sure it does not tilt.

>>D<< RELEASE CYLINDER INSTALLATION

Grease the release fork at the area indicated in the drawing.

Grease

Brand: MITSUBISHI genuine grease Part No. 0101011 or equivalent

>>E<< VALVE PLATE SPRING / VALVE PLATE INSTALLATION

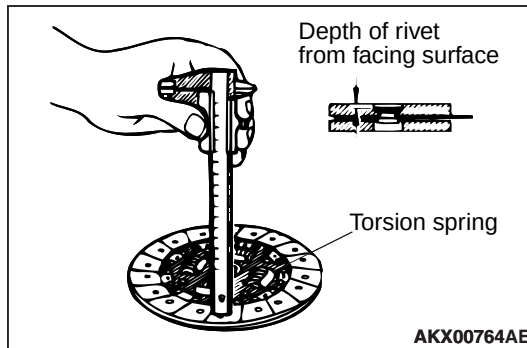
Install the valve plate spring and valve plate with the spring's major diameter end toward the valve plate.

INSPECTION

M1212001100133

CLUTCH COVER ASSEMBLY

1. Check the pressure plate surface for wear, cracks, or discoloration.



2. Check the rivets on the strap plates for looseness. If there are any loose rivets, replace the clutch cover assembly.

CLUTCH DISC

CAUTION

Do not wash the clutch disc with cleaning solvent.

1. Check the facing for loose rivets, uneven contact, glazing due to overheating, or oil or grease contamination. Replace the clutch disc if defective.

2. Measure the depth of each rivet from the facing surface. Replace the clutch disc if the depth is less than the limit.

Limit: 0.3 mm minimum

3. Check the torsion springs for looseness and damage. If defective, replace the clutch disc.
4. Combine the clutch disc with the input shaft and check that it slides smoothly on the shaft without excessive play in the rotating direction. If the disc does not slide smoothly, clean the shaft and disc, reassemble them, and check again for sliding condition. If the play is excessive, replace the clutch disc and/or the input shaft.

CLUTCH RELEASE BEARING

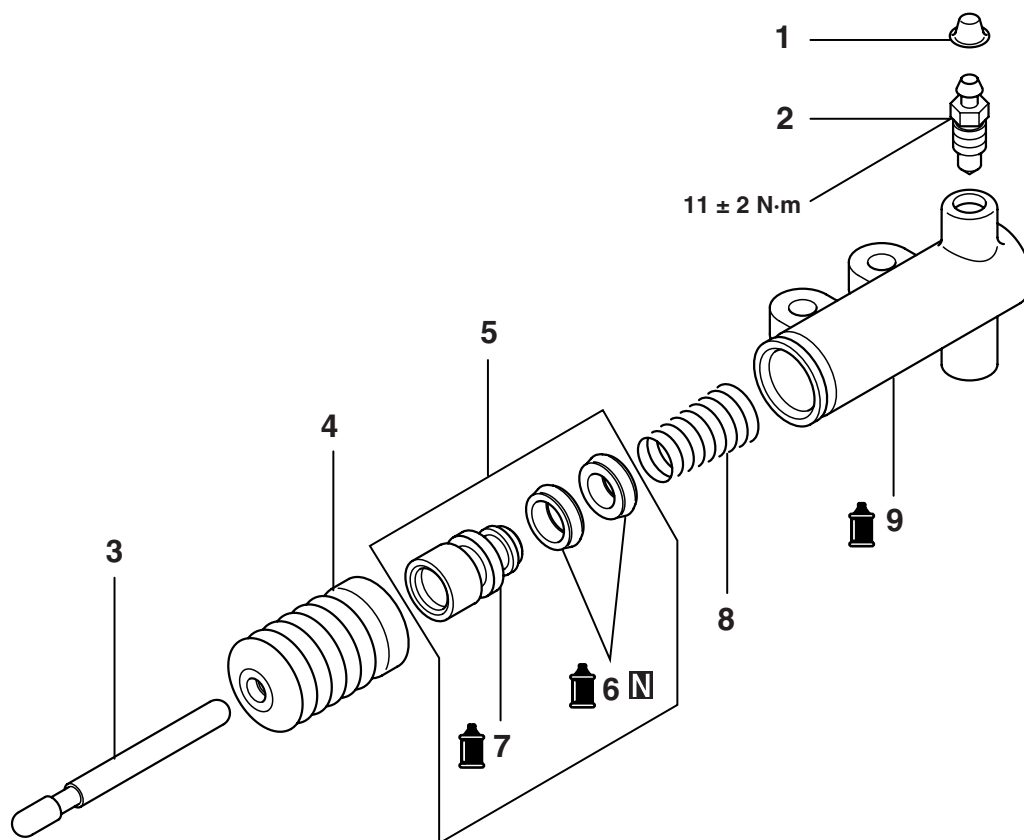
CAUTION

The release bearing is packed with grease. Do not wash it with a cleaning solvent.

1. Check the bearing for seizure, damage, noise or improper rotation.
2. Check the pull ring on the release bearing for wear.
3. Replace bearing if its release fork contact surface is abnormally worn.

CLUTCH RELEASE CYLINDER**DISASSEMBLY AND REASSEMBLY**

M1212001500142



AK203874 AD

Disassembly steps

1. Cap
2. Air breather
3. Push rod
4. Boot
5. Piston assembly

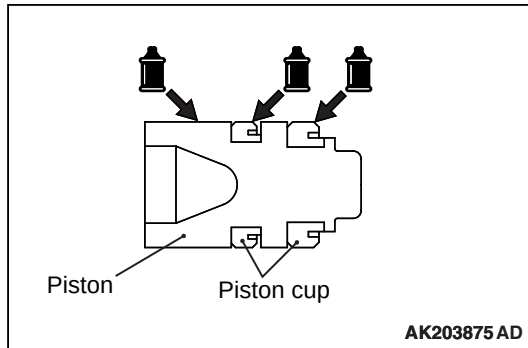
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Disassembly steps (Continued)

6. Piston cups
7. Piston
8. Conical spring
9. Release cylinder

REASSEMBLY SERVICE POINTS

>>A<< PISTON ASSEMBLY INSTALLATION



Apply brake fluid to the outer surfaces of the piston and piston cups and inner surface of the release cylinder, and then insert the piston assembly into the release cylinder.

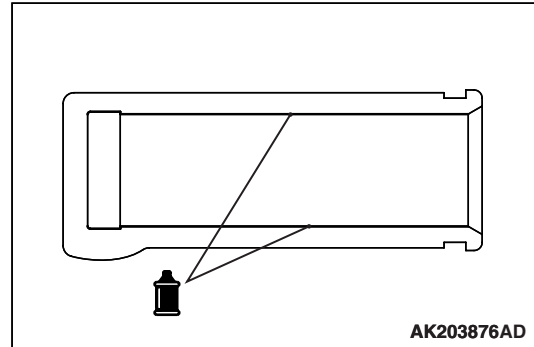
Brake Fluid

Brand: Dia Queen Brake Fluid Super 4 or equivalent

INSPECTION

RELEASE CYLINDER

M1212001600149



1. Check the inner surface of the release cylinder for rust or scratches.
2. Use a cylinder gauge to measure the inside diameter of the release cylinder at three different points (innermost, middle, and outermost points). Replace the release cylinder assembly if the clearance between the piston and cylinder exceeds the limit at any of the measurement points.

Limit: 0.15 mm

NOTES