

Instructions for DR650SE glue-on clutch and ignition guard

1. Obtain some RTV adhesive, any type of pure silicone adhesive will work fine. The plain clear GE silicone in the caulk tube or Permatex RTV gasket maker of any color is acceptable. **Do not use latex-based adhesives.**
2. Remove guard from the package
3. Clean the back surface of the guard with alcohol or brake cleaner to remove any oil or polishing compound from the back side of the guard. Also clean the magnesium clutch cover so no trace of dirt or oil remain.
4. Spread RTV adhesive about 1/8" thick on the backside of the guard. Taper the thickness of the adhesive towards the edge of the outer bevel. This will minimize squeeze out of the adhesive.
5. Place the guard over the over the ignition cover. Make sure the guard is in the center of the ignition cover. The adhesive does not dry immediately so there is time to adjust the position. The outer lip may not touch the cover all the way around. If there is a small gap fill it with RTV. Make sure the cutout is clocked to match the side of the engine. Also make sure the hole in the cover is centered over the crankshaft access plug. If you don't center properly you will have a problem later if you need to remove the plug.
6. Remove any squeeze out with a paper towel, then secure guard with clear packing tape until adhesive dries.
7. Allow the adhesive to dry 24 hours before riding the bike. Some water may come out of the glue joint as the adhesive fully cures.

