

TECHNICAL BULLETIN

TO : All Yanmar Marine Distributors and Dealers
MODEL : SD20 and 25
SUBJECT : Periodic maintenance (every 250hrs) and assembling of clutch shifter
REF. No. : YMTQTB16-006
DATE : Sep.1st, 2016

Service Advisory

Yanmar would like to remind you about the periodic maintenance required every 250 hours of operation as well as assembling procedure for the clutch shifter for the SD20 and SD25.

Please take care the sail drive refers to the following description because the applicable maintenance depends on the Yanmar distributor or dealer.

*** Periodic maintenance every 250 hours of operation:**

>>>> Inspecting and/or replacing the clutch shifter

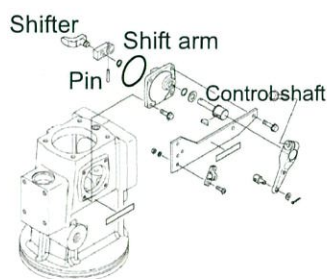
- Shifter and pin: Please check whether partial damage is existed or not.
If any damage is confirmed, replace these parts with new ones.
- Shift arm and control shaft: Please check whether partial damage is existed or not.
If any damage is confirmed, replace these parts with new ones.

Note: Please refer to Parts Catalog for each parts codes.

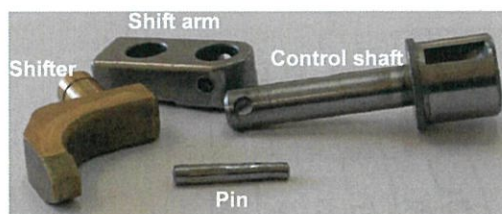
*** How to assemble clutch shifter :**

- Important 1. Taper hole in arm & shaft should be cleaned by spray cleaner.
2. Pin should be cleaned by spray cleaner.
Note: Purpose of both actions are for degreasing.
- 3. Opening angle of shared portion of pin : 45 +/- 5 degree
- 4. Projection of taper pin (head portion): <=2.5mm

[Illustration: location of clutch shifter]



[Photos of each parts]



Shigeo Nakamura
Senior Manager
Quality Assurance Group
Marine Recreational Promotion Div.
Yanmar Co., Ltd

Assembling procedure

1. Shift arm:

Cleaning taper hole



2. Control shaft:

Cleaning taper hole



3. Pin:

Cleaning entire outside of pin



4. Pin installation:

Hitting by hummer



5. Pin opening

Using by chisel



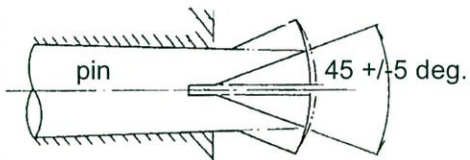
6. Check projection of taper pin

Projection ; $\leq 2.5\text{mm}$

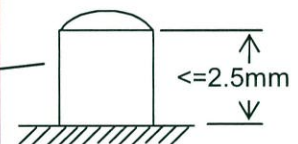
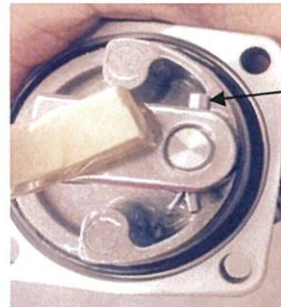


[Important]

Opening angle of shared portion
of taper pin : 45 ± 5 degree



Projection of taper pin (head portion): $\leq 2.5\text{mm}$



[Photos of clutch shifter assembly]

