

August 20, 2010

Subject: **DS 450 Frame Replacement Parts**

No. **2011-1**

YEAR	MODEL	MODEL NUMBER	SERIAL NUMBER
2008	DS 450	All	All
2009			
2010			

The DS450 frame components are assembled at factory using a lock bolt system that requires special tools. BRP has developed a procedure so dealers can replace components without using these lock bolts while maintaining the frame's integrity.

NOTE: From here on out, we will refer to these lock bolts as rivets.

PROCEDURES

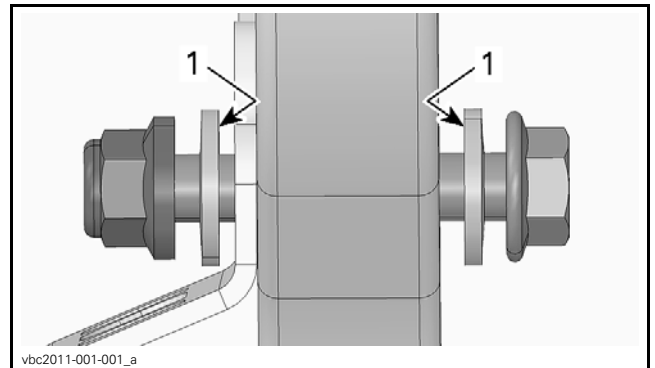
Parts Replacement

When installing new frame components on a DS450, always use this procedure to secure parts together.

Unless otherwise instructed, each rivet must be replaced by the following:

RIVET STEM SIZE	REPLACEMENT PARTS
1/4" rivet	M6 hexagonal flanged screw (grade 8.8) and M6 elastic flanged nut (grade 8.8)
3/8" rivet	M10 hexagonal flanged screw (grade 8.8), Belleville washers (2x) and M10 elastic flanged nut (grade 8.8)

Belleville washers must be installed with their concave side toward the parts.



TYPICAL ASSEMBLY

1. Concave side of Belleville washers

Tighten the new assembly using the following torque:

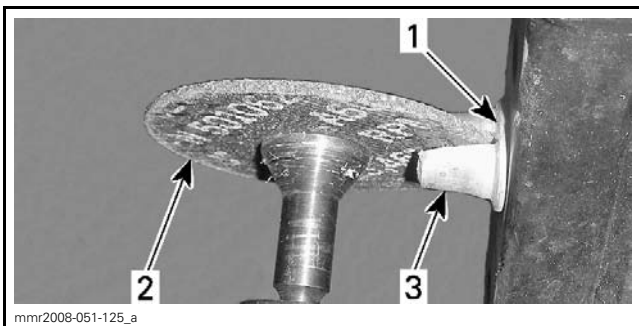
PART	TORQUE
M6 hexagonal flanged screw	5 N•m (44 lbf•in)
M10 hexagonal flanged screw	21 N•m (15 lbf•ft)

Refer to *DETAILS OF NEW ASSEMBLY* when installing new parts to see fasteners position and required length.

Rivets Removal

Recommended Method

1. Using a cut-off tool, cut the rivet attachment without touching the shoulder.



1. Rivet attachment shoulder
2. Cutter wheel
3. Rivet attachment

NOTE: Apply a thin layer of grease on cutter wheel to increase its durability.

2. Break the rivet attachment shoulder using a chisel.
3. Use a small punch to push the rivet stem out of hole.

Alternative Method

1. Measure outside diameter of rivet stem and select appropriate drill bit.
2. Drill the **rivet stem (not the rivet head)** until rivet attachment is freed.
3. It is recommended to use a variable speed drill.

NOTE: When possible, use an angle grinder to grind rivet head or use an air hammer to cut the rivet attachment.

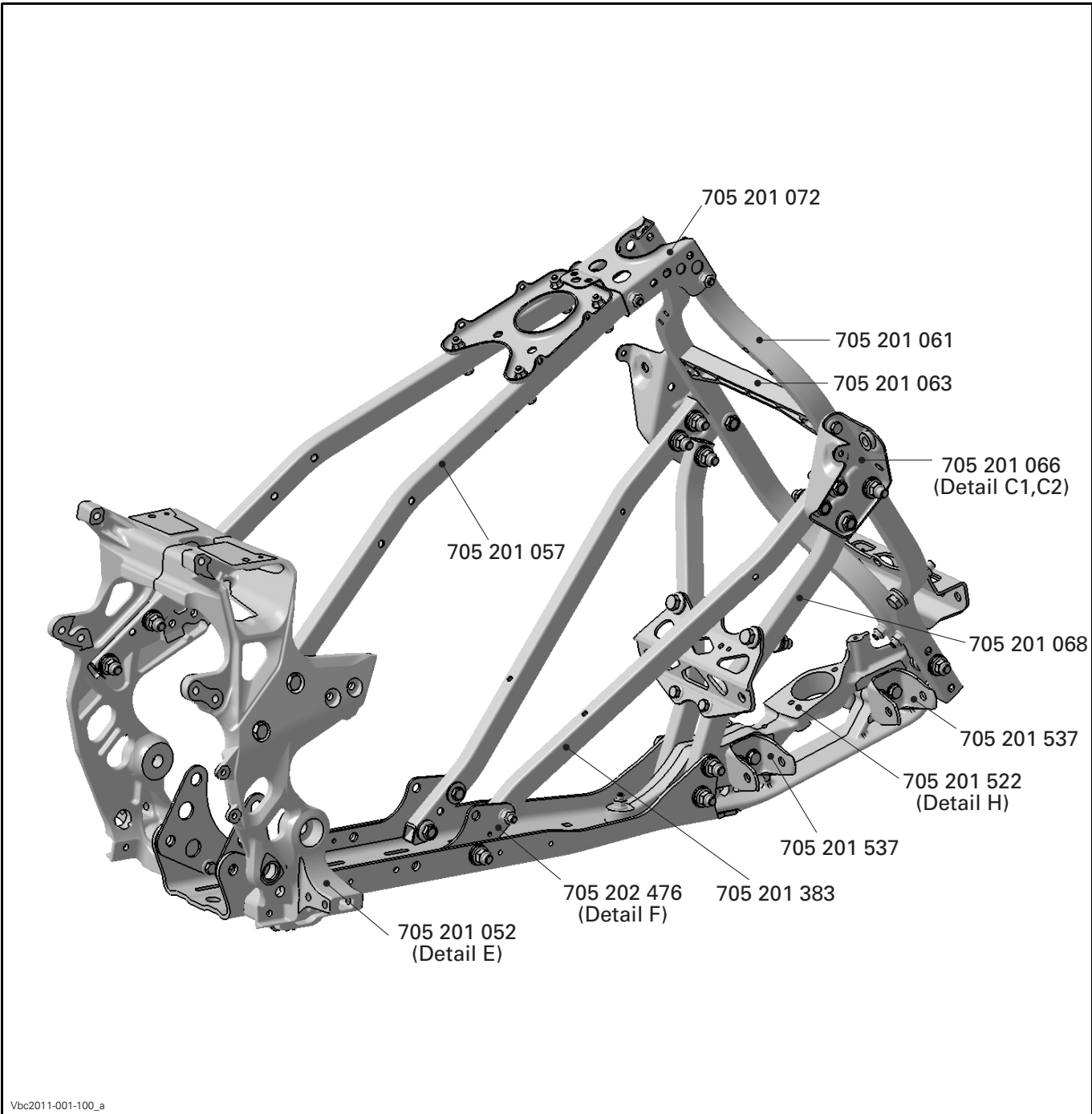
Parts Order

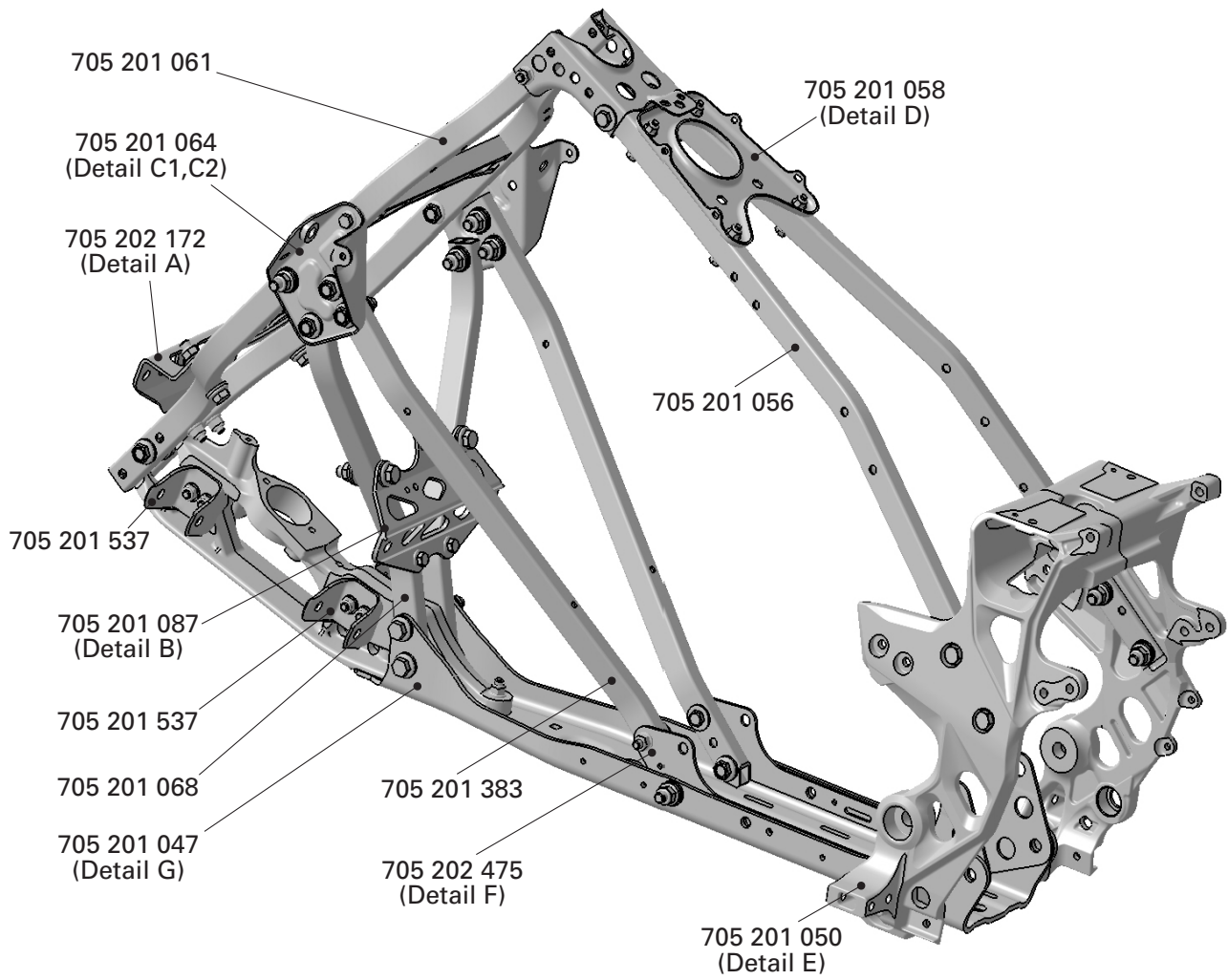
Frame parts may be ordered by dealers directly to the Racing Department, using the included form (see at the end of this bulletin) while all fasteners must be ordered through the normal channel.

REQUIRED FASTENERS	
DESCRIPTION	PART NUMBER
M6 hexagonal flanged nut	(P/N 233 261 414)
M6 x 40 hexagonal flanged screw	(P/N 207 664 044)
Belleville washer	(P/N 234 201 474)
M10 hexagonal flanged nut	(P/N 233 201 436)
M10 x 45 hexagonal flanged screw	(P/N 207 604 544)
M10 x 50 hexagonal flanged screw	(P/N 207 505 046)

REQUIRED FASTENERS	
DESCRIPTION	PART NUMBER
M10 x 55 hexagonal flanged screw	(P/N 207 605 534)
M10 x 70 hexagonal flanged screw	(P/N 207 507 046)
M10 x 100 hexagonal flanged screw	(P/N 230 500 046)

Use the following illustrations to know which parts are available.

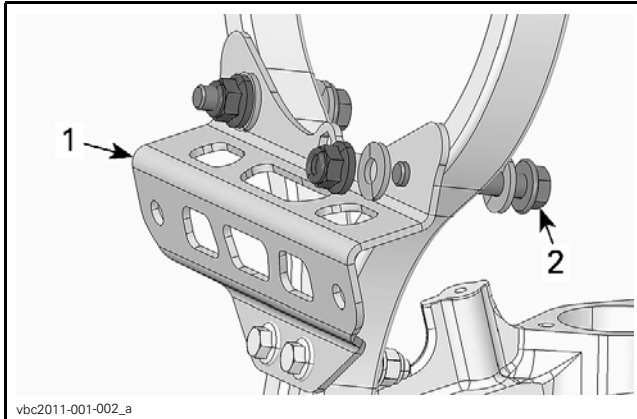




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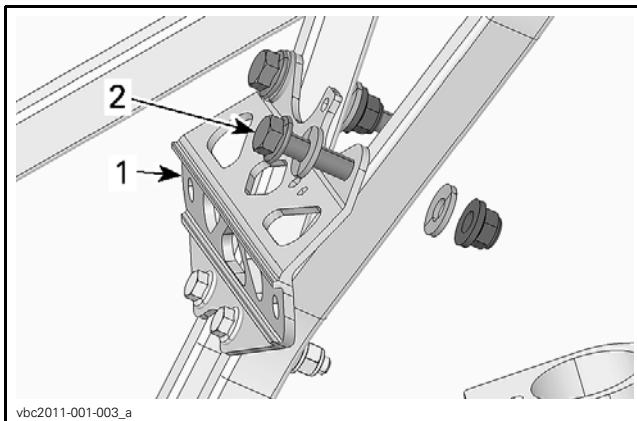
Details of New Assembly

Detail A



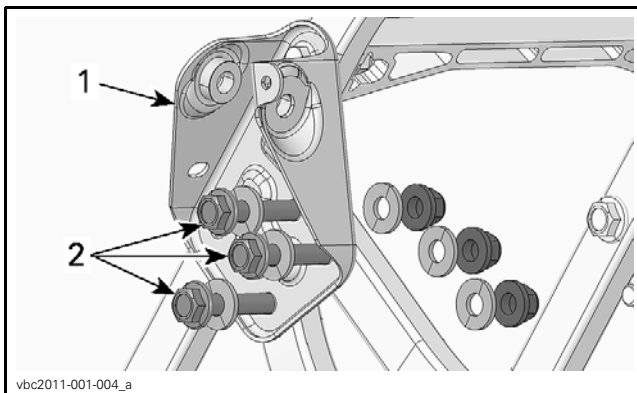
1. 705 202 172
2. M10 x 55 hexagonal flanged screw

Detail B



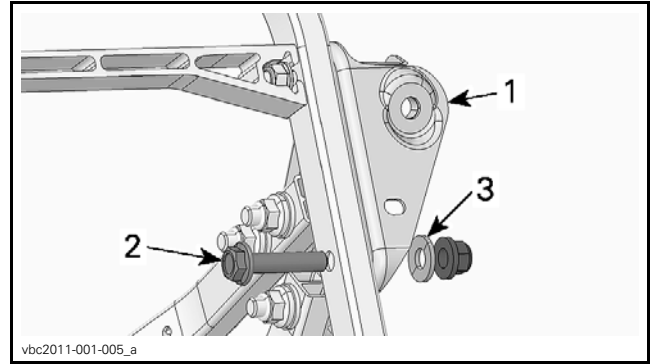
1. 705 201 087
2. M10 x 55 hexagonal flanged screw

Detail C1



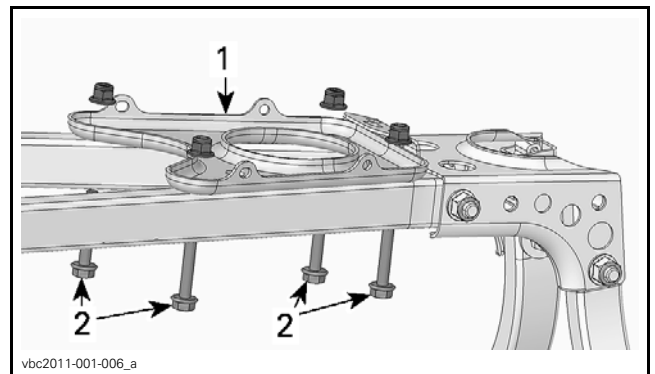
1. 705 201 064 shown, same assembly for 705 201 066
2. M10 x 45 hexagonal flanged screw

Detail C2



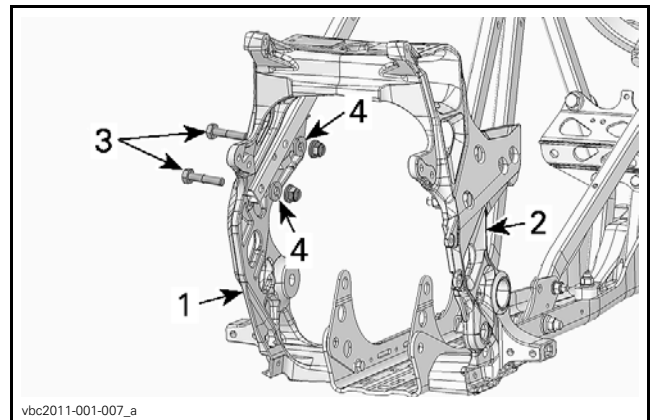
1. 705 201 064 shown, same assembly for 705 201 066
2. M10 x 45 hexagonal flanged screw
3. One Belleville washer only (nut side)

Detail D



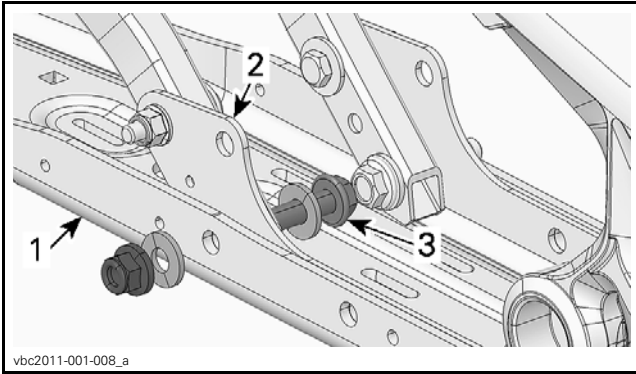
1. 705 201 058
2. M6 x 40 hexagonal flanged screw

Detail E



1. 705 201 050
2. 705 201 052
3. M10 x 45 hexagonal flanged screw
4. One Belleville washer only (nut side)

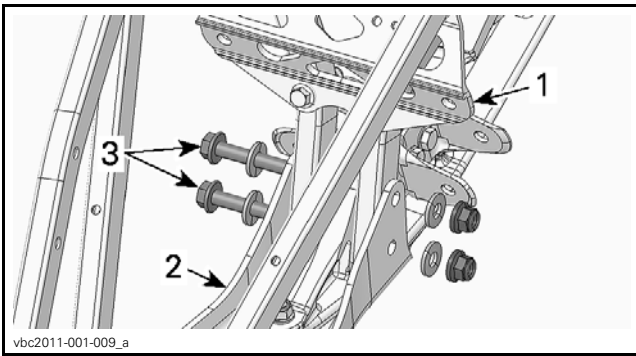
Detail F



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1. 705 201 047
2. 705 202 475
3. M10 x 50 hexagonal flanged screw

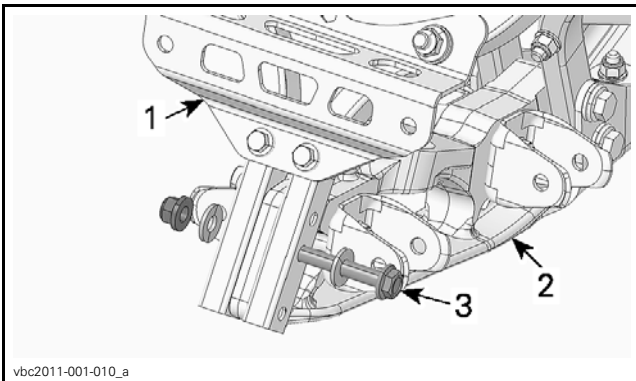
Detail G



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1. 705 201 087
2. 705 201 047
3. M10 x 100 hexagonal flanged screw

Detail H



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1. 705 202 172
2. 705 201 522
3. M10 x 70 hexagonal flanged screw

