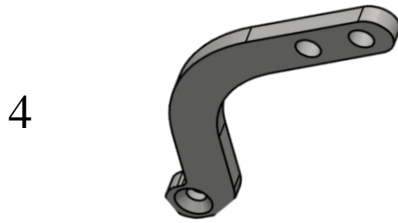
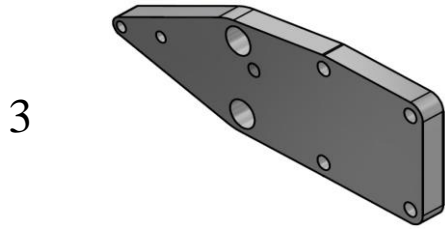
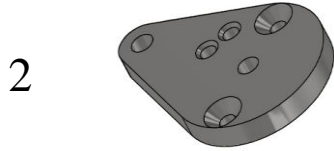


## HD AUTO-TENSIONER KIT

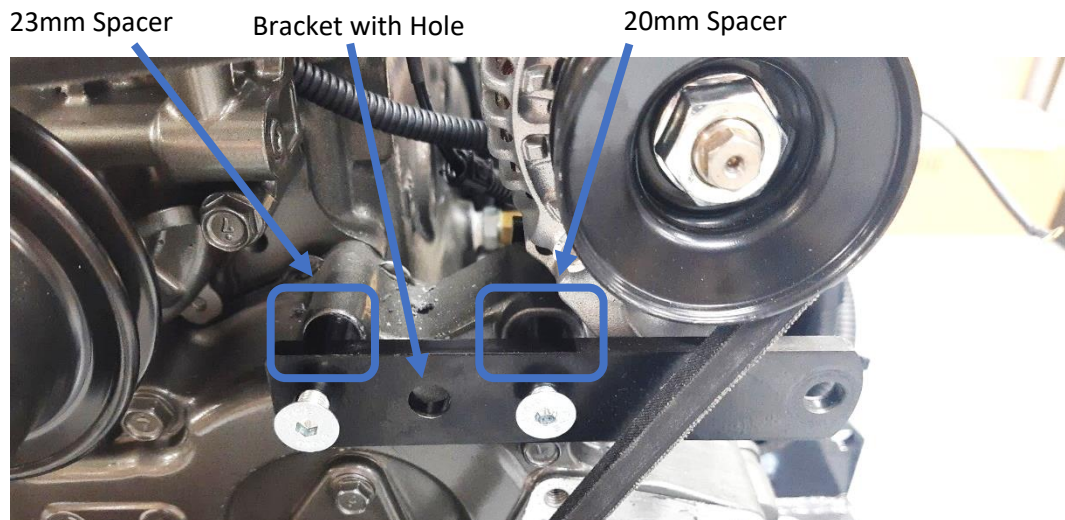
Part No. RDG702B41

Kit contents:

Part	Part No	Qty	Description
1	RE518097	1	Tightener
2	RDG401A306	1	Shire 50 Auto Tensioner Brkt. Port
3	RDG401A307	1	Shire Auto Tensioner Brace Brkt.
4	RDG401A429	1	Shire 50 Hyb Alternator Top Brkt.
5	RDG1417	2	M6 x 25 Cap Head Screw SS
6	RDG1622	2	M6 Flat Washer Form B SS
7	RDG1255	4	M8 x 30 Hex Head Screw SS
8	RDG5976	2	M8 x 100 CSK SKT Screw BZP
9	RDG986	1	M8 Flat Washer Form A BZP
10	RDG1029095	1	M10 x 30 Hex Head Screw SS
11	RDG10110173	1	M10 x 50 CSK Screw BZP
12	RDG102B5	1	M10 x 100 Cap Head Bolt BZP
13	RDG628	5	M10 Flat Washer Form A SS
14	RDG716	2	M10 "P" Type (Full) Nylock Nut BZP
15	RDG5731	1	Spacer 20OD x 10.5ID x 8mm Long
16	RDG103A196	1	M8 "T" Type Half Nylock Nut BZP
17	RDG549	4	M8 Spring Washer SS
18	RDG561	2	M6 Spring Washer SS
19	RDG1111	1	M10 Spring Washer SS
20	RDG105B9	1	M10 x 40 OD BZP washer
21	RDG669	3	M10 Flat Washer Form A BZP
22	RDG1068008	4	Spacer 10.5IDx20ODx10mm
23	RDG102A90	4	M10 x 40 Hex Head Bolt BZP



- **Notes:** This build uses the Tightener (RE518097 x 1), unlike SS1917 etc.
- **Before using these instructions**, the Front Mount Bracket (RDG4017490 x 1 - **with a hole between the mounting bolts**), 8.5ID x 16OD x 23mm Spacer (RDG6046 x 1), and the 10.5ID x 20OD x 20mm Spacer (RDG6057 x 1) should be fitted **as in SS2065** or SS1916 (or SS1611, or SS1615 etc), as called for in the **Build Standard**.



- Remove the cover from the engine. Keep the gasket behind it secure, as it is still required

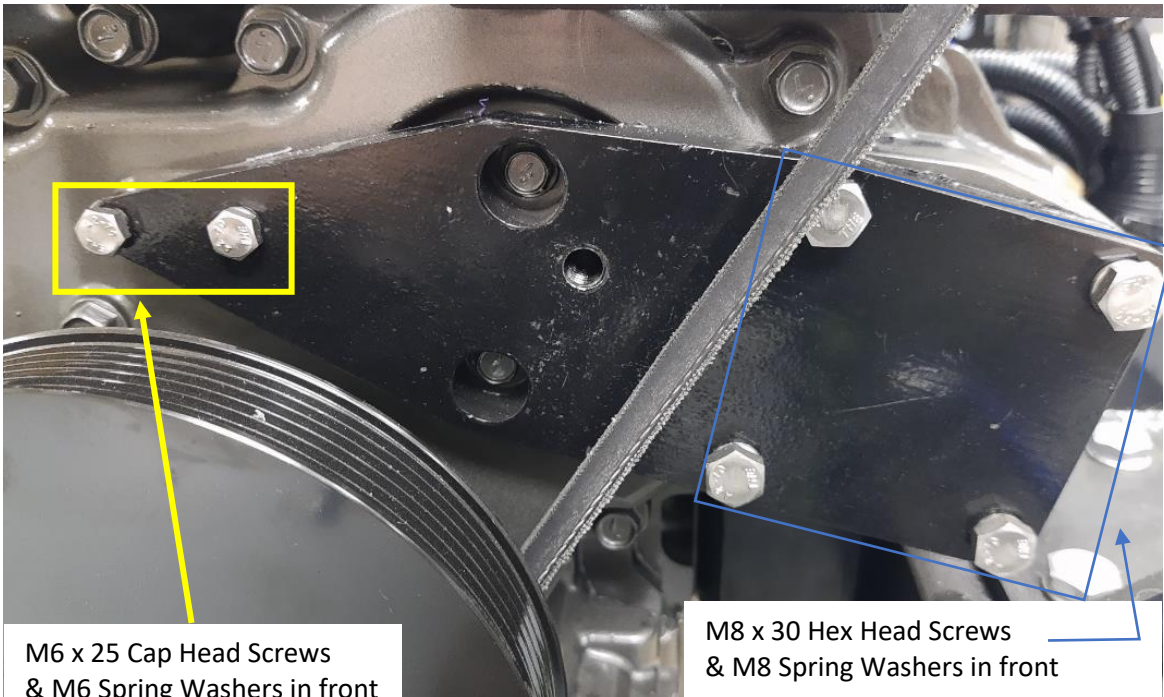
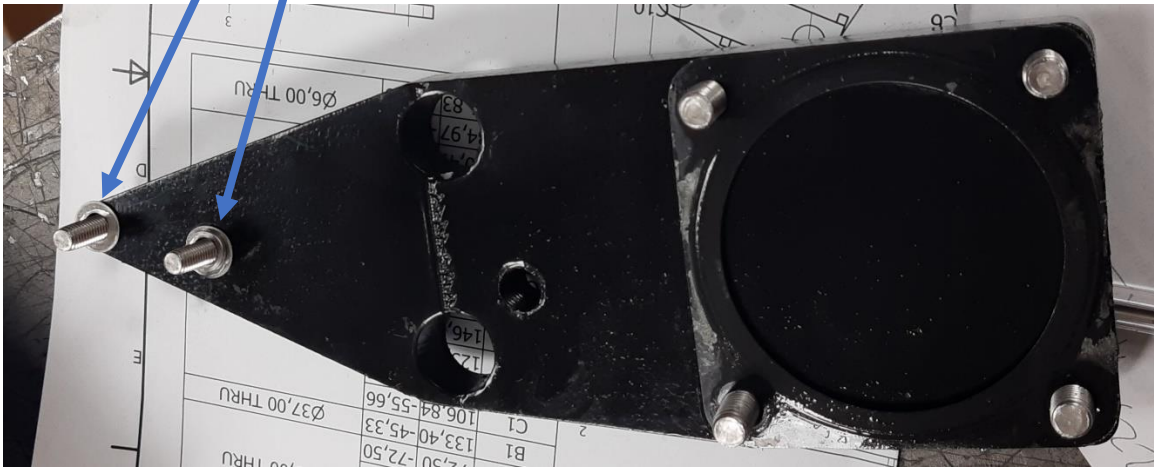




- If required, loosen the belt by loosening the screw above the Alternator.
- Fit the Shire Auto Tensioner Brace Brkt (RDG401A307 x 1) to the engine with the gasket previously removed with M8 x 30 Hex Head Screws (RDG1255 x 4), M8 Spring Washer (RDG549 x 4), M6 x 25 Cap Head Screws (RDG1417 x 2) and M6 Spring Washers (RDG561 x2).

Use blue loctite as the screws go into the casting. Use Grey Sealant on BOTH sides of the gasket before fitting (Silicone Flange Sealant, off Consumables for the build).

M6 Flat Washers (RDG1622 x 2) can go behind the bracket to provide space for the gasket.



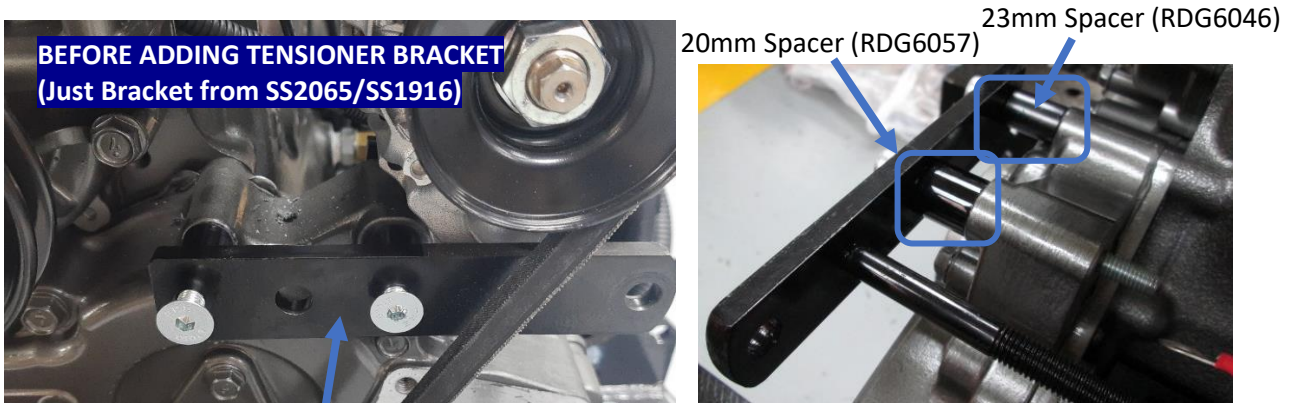
M6 x 25 Cap Head Screws & M6 Spring Washers in front

M8 x 30 Hex Head Screws & M8 Spring Washers in front

New Image required with M6 Cap Head Screws

- Fit the Shire 50 Auto Tensioner Brkt Port (RDG401A306 x 1), through the Front Mount Bracket (RDG4017490 x 1), 8.5ID x 16OD x **23mm** Spacer (RDG6046 x 1) and 10.5ID x 20OD x **20mm** Spacer (RDG6057 x 1) **from SS2065** with the M8 x 100 CSK Screw BZP (RDG5976 x 2) – don't fully tighten these screws yet.

Use blue Loctite on the M8 x 100 CSK Socket Screw BZP which goes into the casting (*left image*). The right screw will be further secured with a nut and washer shown on the next page.



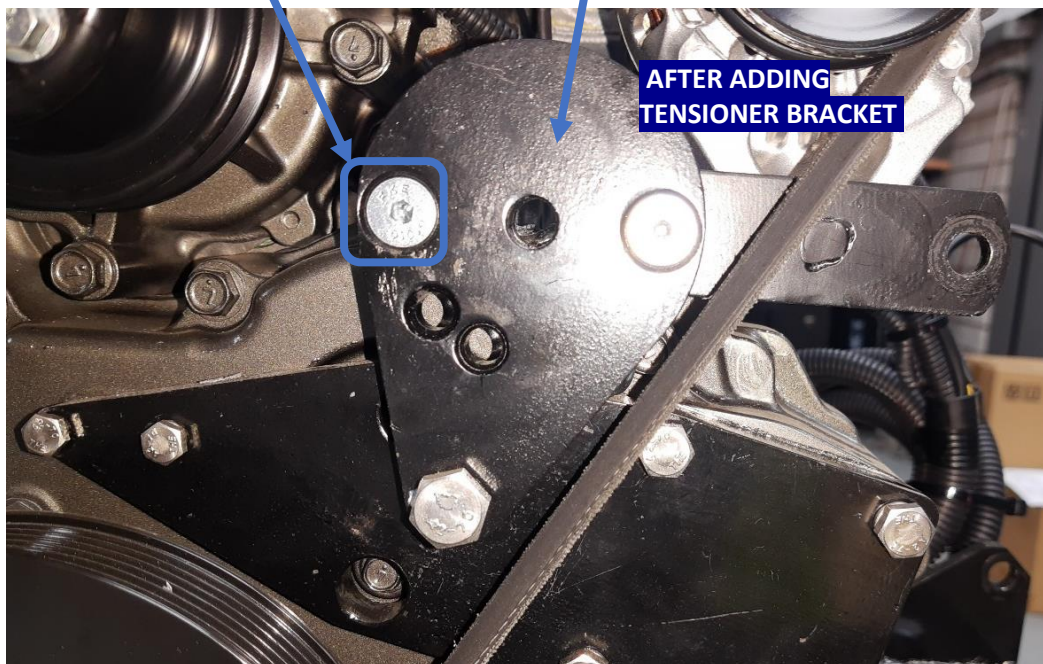
**BEFORE ADDING TENSIONER BRACKET**  
(Just Bracket from SS2065/SS1916)

20mm Spacer (RDG6057) 23mm Spacer (RDG6046)

Front Mount Bracket (with hole - RDG4017490 x 1)

Loctite this screw

Shire 50 Auto Tensioner Brkt Port

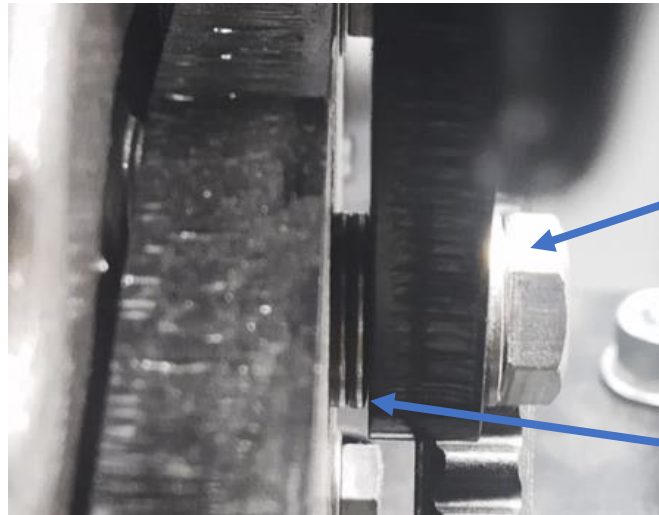


**AFTER ADDING TENSIONER BRACKET**



- Use a M10 x 30 Hex Head Screw SS (RDG1029095 x 1) with loctite and a M10 Spring Washer (RDG1111 x 1) on the outside to secure the bottom edge of the bracket.

M10 Flat Washers (RDG628 x2) will need placing between the brackets, add or remove them to make the brackets parallel if required.



M10 x 30 HHS Screw SS,  
M10 Spring Washer  
& Loctite

M10 Flat Washers x2  
(adjust amount if required)

- A M8 Flat Washer Form BZP (RDG986 x 1) and a M8 Half Nyloc Nut BZP (RDG103A196 x 1) will be needed to fully secure one of the M8 x 100 CSK Screws. Now ensure the nuts and screws applied in these past few steps (M10 x 30 and 2x M8 x 100 CSK) are tight.



- Fit the Tightener (RE518097 x 1) using the M10 x 100 BZP bolt (RDG102B5 x 1) with a M10 Flat Washer BZP (RDG669 x 1) in front.

**Ensure a high strength BZP bolt is used.**

The M10 x 25OD (Penny) Washer BZP (RDG105A7 x 1) goes behind the Auto Tensioner.

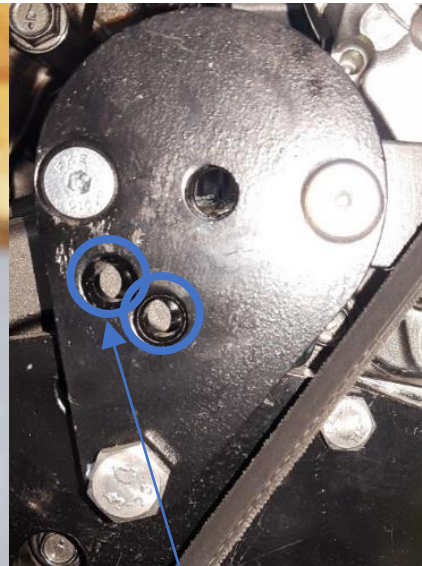


New Image Required  
Showing M10 BZP Cap  
Head Bolt

M10 Flat Washer x1 in front M10 x 25OD (Penny) Washer x1 goes behind



Nub



Slot nub into this hole.

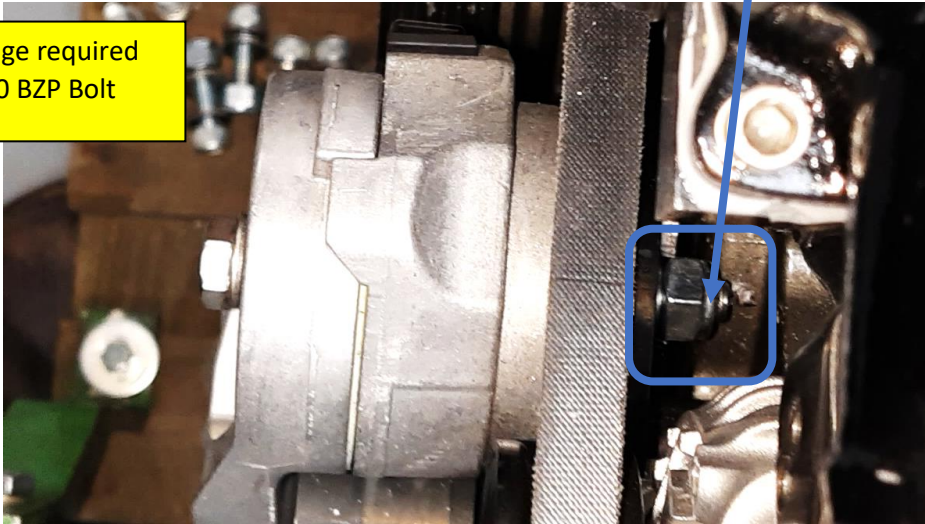
**Ensure the tension is not too tight whenever fitting the belt.**

The nub on the Auto Tensioner locates into one of the holes on the Shire 50 Auto Tensioner Brkt Port

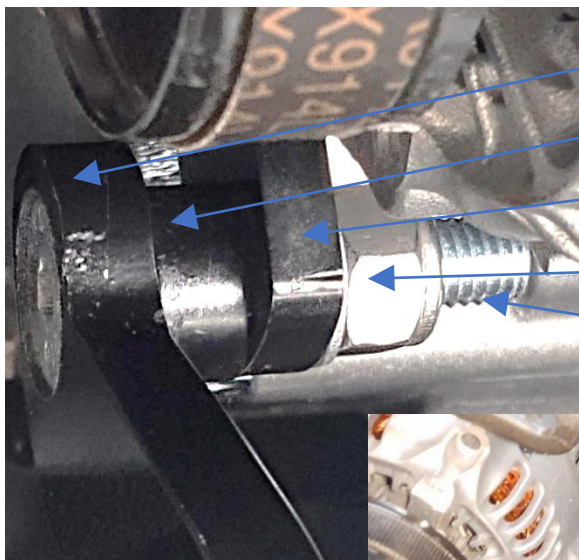


- Secure with a M10 Flat BZP Washer (RDG669 x 1) and a M10 Nyloc Nut BZP (RDG716 x 1) behind.

New Image required  
with M10 BZP Bolt



- Fit the “Shire 50 Hyb Alternator Top Brkt (RDG401A429 x1)” to the “Front Mount Bracket”, with the 200D x 10.5ID x 8mm Spacer (RDG5731 x 1) between the “Alternator Top Mount” and the “Front Mount Bracket”, using the M10 x 50 CSK Screw BZP (RDG10110173 x 1). Secure with a M10 Flat Washer Form A BZP (RDG669 x1) and M10 Nyloc Nut BZP (RDG716 x1) behind.



Shire 50 Hyb Alternator Top Mount

8mm Spacer

Front Mount Bracket

M10 Washer & Nyloc Nut

M10 x 50 CSK bolt





- Check the tightness of the fitted Alternator belt(s) afterwards if needed.