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so many fake sites. this is the first one which worked! Many thanks

R. Inspection
Check the clutch friction discs and plates for wear, damage and warpage, and replace any parts which are excessively worn. Clean clutch water (contaminant on disc).

C. Reassembly

1. Reassemble the clutch assembly.
2. Install the primary drive gear on the main transmission shaft and lock the gear to the shaft with a 17 mm cotter pin.
3. Install the roller on the crankshaft with the larger diameter side.
4. Assemble the primary drive gear and clutch master bearing on the clutch assembly and install the clutch assembly on the crankshaft. Install 14 mm lock washer, clutch lock washer and lock nut on the crankshaft, and torque the nut to 30N~100 kg cm (27.2~23.5 lb ft) with the aid of the clutch holder. Tighten the nut of the 14 mm lock washer into the locking notches.
5. Install the clutch master cover and gasket with four mounting screws. Assemble the clutch push rod and bearing into the master cover.
6. Install the eye-bolts, hand pin and crankcase cover gasket on the right crankcase.
7. Install crankcase cover and tighten cover mounting screws.

NOTE:
There are three sizes of screws; make sure that they are installed in the proper places.

Adjustments
Loosen the clutch adjuster lock nut, turn the adjuster screw counterclockwise until tight, and then, turn clockwise 1/8 turn. Tighten the lock nut.

6. OIL PUMP

Fig. 3-25 ① Oil filter ② Oil pump ③ Oil filter screws

Fig. 3-23 ① Clutch holder ② 14 mm lock and washer

Fig. 3-24 ① Lock nut ② Adjuster screw

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Honda SI70 Manual