

d. Reassembly

1. Assemble the cam chain and primary chain on the crankshaft and assemble it into the upper crankcase.
2. Assemble the primary chain on the primary sprocket and install the sprocket on the main shaft. (Fig. 3-84)
3. Install the two dowel pins, oil pass collar and an "O" ring on the upper crankcase and apply a uniform coating of liquid packing on the mating flange. (Fig. 3-85) Carefully set the lower crankcase on top, and install the mounting bolts and torque in the pattern shown in Fig. 3-86 to a value of 16.6~18.1 ft-lbs (2.3~2.5 kg-m) for 8 mm hex. bolts and next, tighten the 6 mm hex. bolts.

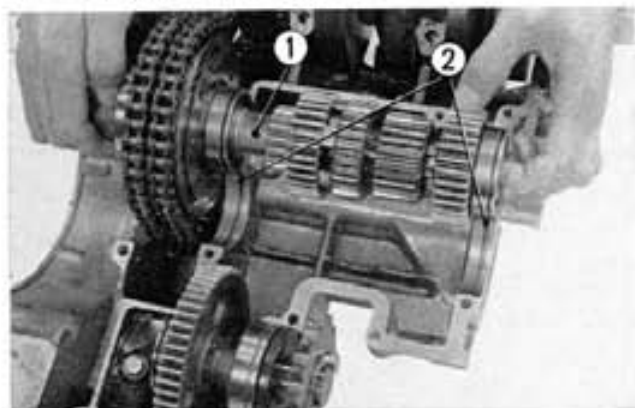


Fig. 3-84 ① Transmission mainshaft
② Bearing set rings

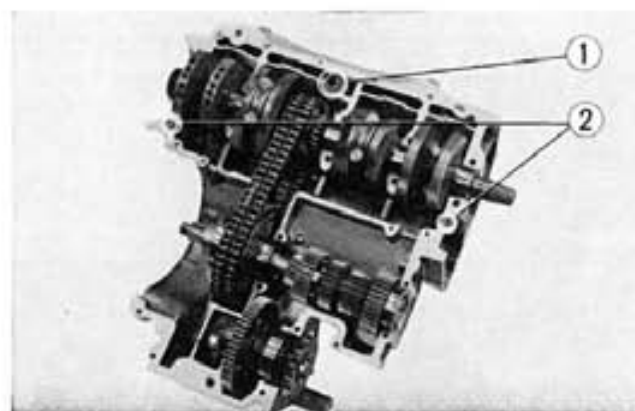


Fig. 3-85 ① Oil pass collar & "O" ring
② Dowel pins

4. Turn the crankcase assembly and torque down the upper crankcase.
5. Install the countershaft bearing and then assemble the gear change positive stopper, drum stopper and the gear shift arm (Fig. 3-70).
6. Install the clutch (refer to page 60~61).

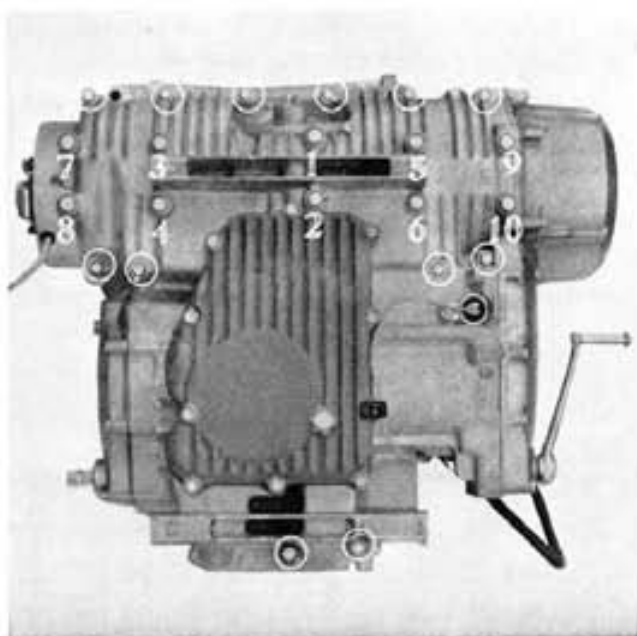


Fig. 3-86 Tightening sequence