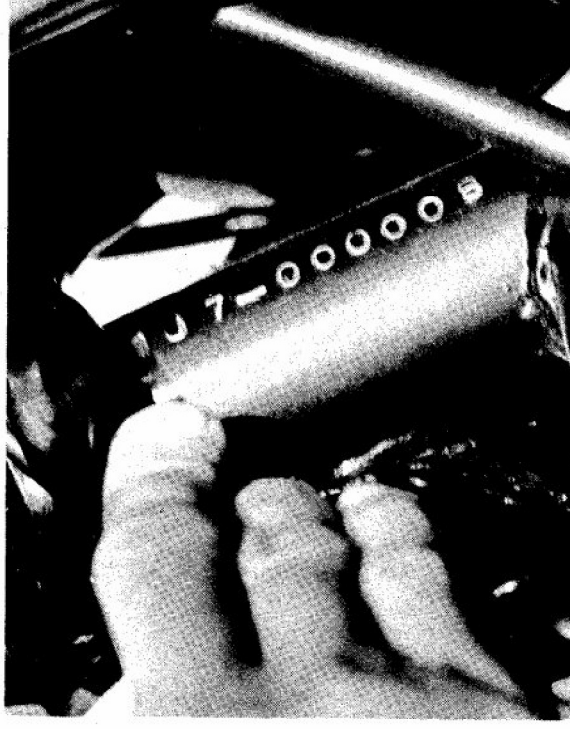


MACHINE IDENTIFICATION

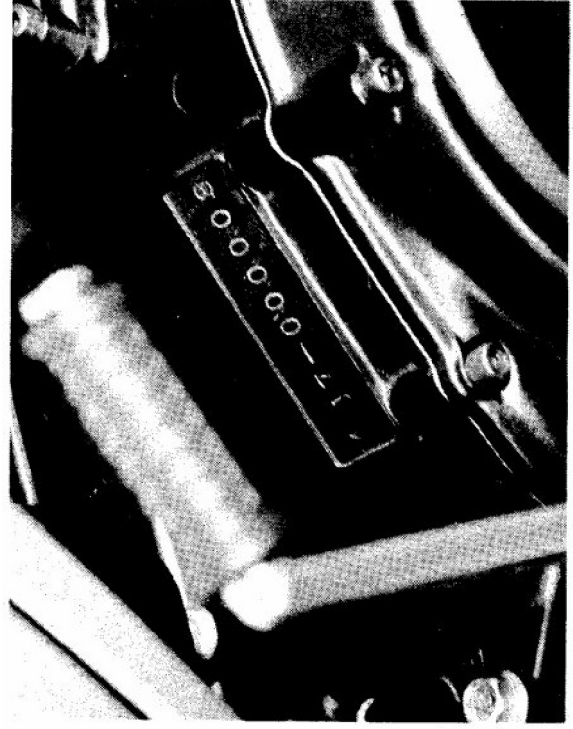
A. Frame Serial Number

The frame serial number is stamped on the right side of the steering head pipe.



B. Engine Serial Number

The engine serial number is stamped on the elevated part of the right rear section of the engine.



NOTE: The first three digits of these numbers are for model identifications; the remaining digits are the unit production number. The frame and engine numbers are usually identical.

SPECIFICATIONS

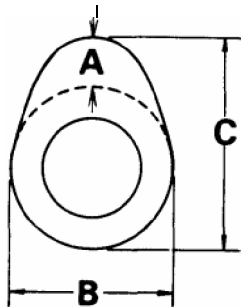
A. GENERAL SPECIFICATIONS	
Basic color Dimensions: Overall length Overall width Overall height Seat height Wheelbase Minimum ground clearance Caster (steering head angle) Trail	Crystal Silver 2180mm (85.8 in.) 835mm (32.9 in.) 1150mm (45.3 in.) 810mm (31.9 in.) 1465mm (57.7 in.) 145mm (5.7 in.) 27° 110mm (4.3 in.)
Weight: Net	229 kg (505 lbs.)
Engine: Type Bore x stroke x cylinders Displacement Compression ratio Compression pressure (warm engine)	D.O.H.C., air-cooled, triple 68mm x 68.6mm x 3 747cc 8.5: 1 142 lbs in ² (±14 lbs in ²)
Lubrication: Lubrication system Delivery pump type	Pressure lubricated, wet sump Trocoid
Carburetion: Manufacture Type, I.D. No., Quantity Rated venturi size	Mikuni BS34, constant velocity, 1J701, 3 pcs. 34mm
Air filter	Dry foam rubber
Ignition: Type Spark plug	Battery/coil NGK BP-7ES, Champion N-7Y
Charging Type Manufacture, I.D. No. Maximum output Battery type Battery dimensions Regulator Rectifier	Three-phase, regulated alternator Hitachi LD120-02 14.5 Volt/18 amp 12 volt 14 amp-hour 134 x 166 x 89mm Hitachi TL1Z-80 Stanley DE-4404, Silicon, full wave
Starting	Transmission coupled kick Mitsuba Electric SM-224C
Primary drive Type Teeth, ratio	Hy-Vo silent chain 45/27 1.666
Clutch	Wet, multiple disc.

Transmission: Type Teeth, ratio, overall 1st 2nd 3rd 4th 5th	Constant mesh, 5-speed, drum shifter 32/13 2.461 13.285 27/17 1.588 8.636 26/20 1.300 7.069 23/21 1.095 5.955 22/23 0.956 5.201
Secondary Drive: Type Transmission Output: Type, teeth, ratio Middle gear case Type, teeth, ratio Final gear case Type, teeth, ratio	Shaft drive Spur gear, 34/32, 1.063 Bevel gear, 19/18, 1.056 Bevel gear, 32/11, 2.909
Chassis: Frame Suspension: Front (type, travel) Rear (type, travel) Tires: Front Rear Brakes: Front Rear Fuel tank Wheels: Front Rear	Tubular steel double cradle Telescopic fork, 175mm (6.9 in.) Swing arm, 75mm (3.0 in.) 3.25 H 19 Bridgestone 4.00 H 18 Bridgestone Dual hydraulic disc Single hydraulic disc 17L.(4.5 US gal.) Regular leaded or unleaded 1.85 x 19 Cast Aluminum 2.15 x 18 Cast Aluminum

B. MAINTENANCE SPECIFICATIONS	
1. Engine	
Engine Oil Capacity Dry Oil and filter change Oil change Recommended lubricant : If temperature does not go below 5°C (40°F) If temperature does not go above 15°C (60°F)	3500cc (3.7 US qt.) 3200cc (3.4 US qt.) 2800cc (3.0 US qt.) SAE 20W40 SE motor oil SAE 10W30 SE motor oil

Middle gear case capacity: Final Gear case capacity Recommended lubricant If temperature does not go below 5°C (40°F) If temperature does not go above 15°C (60°F) All weather	375cc (13 oz.) 300cc (100 oz.) SAE 90 Hypoid gear oil, GL-4 SAE 80 Hypoid gear oil, GL-4 SAE 80W90 Hypoid gear oil, GL-4
Cranking pressure (at sea level) Maximum difference between cylinders	10 ± 1 kg/cm ² (142 ± 14 psi) 1.0 kg/cm ² (14 psi)

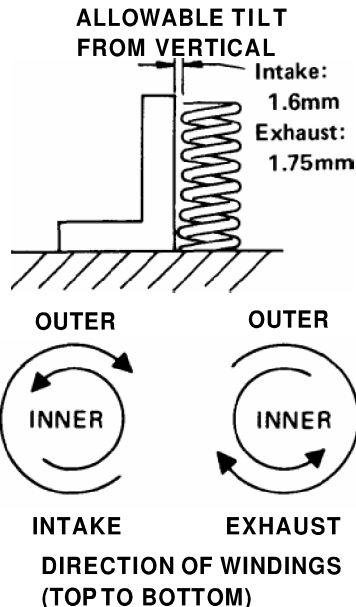
Camshafts



	Dimensions	Standard size	Wear limit
Intake	A	8.518mm	
	B	28.285 ± 0.05mm	28.13mm
	C	36.803 ± 0.05mm	36.75mm
Exhaust	A	8.018mm	-----
	B	28.285 ± 0.05mm	28.13mm
	C	36.303 ± 0.05mm	36.15mm

Camshaft bearing surface diameter	24.97~24.98mm (0.9830~0.9835 in.)
Camshaft-to-cap clearance :	
Standard	.020~.054mm (.0008~.002 in.)
Maximum	.160mm (.006in.)
Camshaft runout limit	0.1 mm (.004 in)

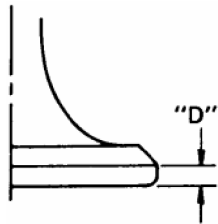
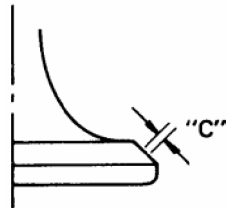
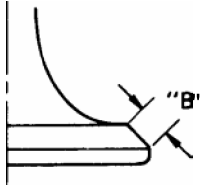
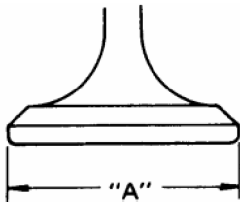
Valves



	INNER	OUTER
	INTAKE/EXHAUST	INTAKE/EXHAUST
Free length	35.6mm	39.9mm
Spring rate (kg/mm)	K1 1.84 K2 2.36	K1 3.32 K2 4.18
Installed length (valve closed)	31.5mm	34.5mm
Installed pressure (valve closed)	7.5 ± 0.75kg	17.5 ± 1.2kg
Compressed length (valve open)	23.0mm	26.0mm
Wire diameter	2.8mm	3.9mm
Number of windings	7.75	6.4
Winding O.D.	15+ 0.3mm 0	21.6 0 - 0.3mm

Valve stem run-out maximum	.03mm (.0012 in.)
Valve seat width standard/maximum	1.3mm (.050 in.) / 2.0mm (.080 in.)

INTAKE



Clearance (Cold engine)	0.16~0.20mm
"A" head diameter	36 + 0.2 0mm
"B" face width	2.26 ± 0.57mm
"C" seat width	1.3 ± 0.15mm
"D" margin thickness	1.2 ± 0.2mm
Stem diameter (O.D.)	7 + .010mm -.025mm
Guide diameter (I.D.)	7 + .019mm -.010mm
Stem-to-guide clearance	0.020~0.041mm

EXHAUST

Clearance (Cold engine)	0.21~0.25mm
"A" head diameter	31 + 0.2mm 0mm
"B" face width	2.26 ± 0.57mm
"C" seat width	1.3 ± 0.15mm
"D" margin thickness	1.2 ± 0.2mm
Stem diameter (O.D.)	7 + .025mm -.040 mm
Guide diameter (I.D.)	7 + .019mm -.010mm
Stem-to-guide clearance	0.035~0.059mm

Cylinder and Piston

Cylinder material
Cylinder liner
Standard bore size standard
maximum
Cylinder taper limit
Cylinder out-of-round limit
Piston clearance standard
maximum

Aluminum
Pressed in; special cast iron
68.00~68.02mm / (2.677~2.678 in.)
68.10mm (2.681)
0.05mm (.002 in.)
0.01mm (.0004 in.)
0.050~0.055mm / (.0020~.0022 in.)
0.1mm (.004 in.)

Piston Rings

Design
End gap (installed)
Side clearance

Top	2nd	Oil
0.2~0.4mm 0.04~0.08mm	0.2~0.4mm 0.03~0.07mm	0.2~0.9mm

3. Chassis	
Wheels and Tires Rim run-out, vertical Rim run-out, horizontal Tire pressure, front, normal riding High speed or with passenger Tire pressure, rear, normal riding High speed or with passenger	2.0mm (.080 in.) 1.0mm (.040 in.) 1.8 kg/cm ² (26 p.s.i.) 2.0 kg/cm ² (28 p.s.i.) 2.0 kg/cm ² (28 p.s.i.) 2.3 kg/cm ² (33 p.s.i.)
Brakes Recommended fluid Minimum boiling point Pad thickness wear limit Brake disc maximum deflection Brake disc minimum thickness Front brake freeplay (end of lever) Rear brake freeplay (end of pedal)	DOT No. 3 240°C (464 °F) 5.5mm (0.18 in.) 0.15mm (.006 in.) 6.5mm (0.26 in.) 5.0~10.0mm (0.2~0.4 in.) 5.0~10.0mm (0.2~0.4 in.)
Front forks Spring (upper) free length preload length Spring (lower) free length preload length Spring rate (0~100mm travel) (100~175mm travel) Fork oil capacity (each side)	55.8mm (2.2 in.) 50.8mm (2.0 in.) 448.3mm (17.65 in.) 423.3mm (16.67 in.) 0.5 kg/mm (28 lbs/in.) 0.6 kg/mm (33.6 lbs./in.) 170cc (5.75 US fl. oz.)
Rear shock absorbers Spring free length Spring preload length Spring rate (0~45mm travel) (45~75mm travel)	253mm (9.95 in.) 228 mm (9.0 in.) 1.9 kg/mm (106 lbs./in.) 2.6 kg/mm (145 lbs./in.)

Ignition timing retarded advanced advance starts	10° @ 1100 rpm 38.5° ± 1.5° @ 2,900 rpm 1550 + 200 rpm 0
Spark plug Electrode gap	NGK BP-7ES or Champion N-7Y 0.7~ 0.8mm (.028~.032 in)
Spark plug cap resistance	5.0 K ohms
Contact point gap Spring tension	0.3~0.4mm (.012 ~.016 in) 750 ± 100g (26.5 ± 3.5 oz)
Condenser capacity Insulation resistance	0.22µF ± 10% 10 M ohms or more
Ignition coil type Spark gap 6V 12V Primary resistance (20°C) Secondary resistance (20°C)	Hitachi CM11-52A 6mm @ 100 rpm 7mm @ 5,000 rpm 4.0 ± 0.4 ohms 11.0 ± 1.1K ohms

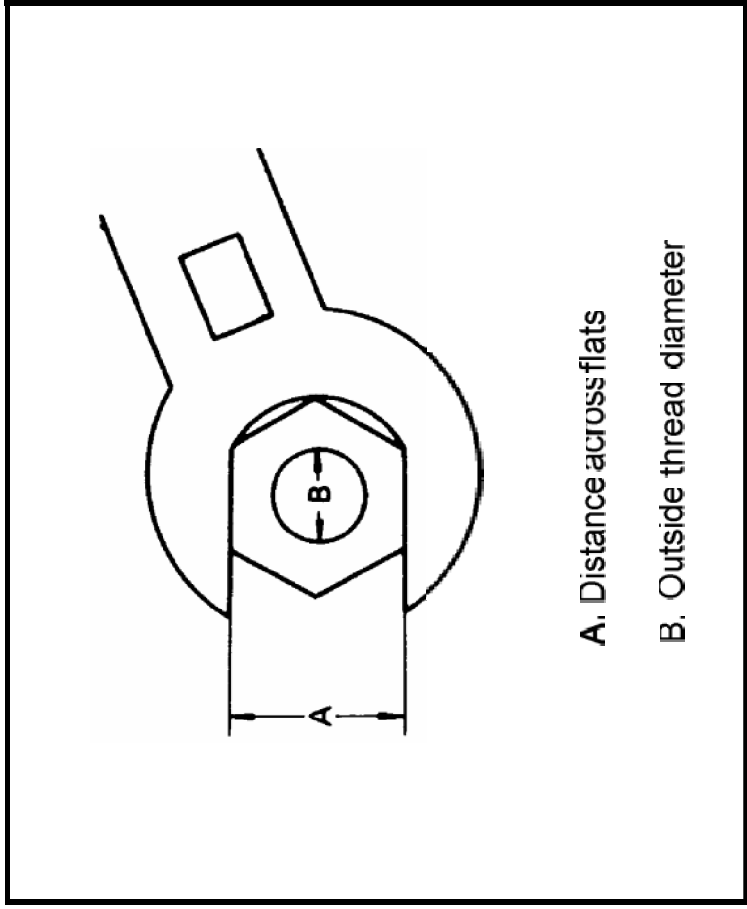
Starter motor type Armature coil resistance (20°C) Field coil resistance (20°C) Brush length standard minimum Brush spring pressure Armature mica undercut	Mitsuba SM-224C 0.007 ohms 0.01 ohms 12.5mm (0.5 in) 5.5mm (0.22 in) 620 ± 60g (22.0 ± 2.0 oz) 0.5 ~ 0.8mm (0.02 ~ 0.03 in)
Battery type Charging rate	Yuasa YB 14L 1.4 amps for 10 hours
Generator type No load voltage Field (inner) coil resistance(20°C) Stator (outer) coil resistance (20°C)	Hitachi Ld 120-02 14.5 ± 0.5V 4.04 ± 0.4 ohms 0.48 ± 0.05 ohms
Regulator type Regulated voltage Core gap Yoke gap Point gap	Hitachi TLIZ-80 14.5 ± 0.5V 0.6 ~ 1.0mm (.024 ~.040 in) 0.9mm (.035 in) 0.3 ~ 0.4mm (.012 ~.016 in)
Starter relay switch Cut-in voltage Winding resistance (20°C)	Hitachi A104-70 6.5 V 3.5 ohms
Lighting Headlight Taillight/stoplight License light Flasher light Flasher pilot light Meter lights High beam indicator light Oil pressure warning light Neutral light	Sealed beam 12V50/40W 12V 8/27W (two bulbs) 12v 8W 12V 27W (four bulbs) 12V 3.4W (two bulbs) 12V 3.4W (two bulbs) 12v 3.4w 12v 3.4w 12v 3.4w

C. Torque Specifications

Engine	
Spark plug	1.5 ~ 2.5 m-kg (11.0 ~ 18.0 ft-lbs.)
Cam cap nut	0.8 ~ 1.0 m-kg (6.0 ~ 7.0 ft-lbs.)
Rod cap	3.8 m-kg (27 ft-lbs.)
Starter clutch bolt	2.8 ~ 3.2 m-kg (20 ~ 23 ft-lbs.)
Shift cam locating bolt	1.3 ~ 2.1 m-kg (9 ~ 15 ft-lbs.)
Detent assembly	4.0 ~ 4.5 m-kg (29 ~ 32 ft-lbs.)
Transmission bearing caps	1.8 ~ 2.2 m-kg (13 ~ 16 ft-lbs.)
Crankcase bolts 8mm	2.0 m-kg (14 ft-lbs.)
10mm	3.7 m-kg (27 ft-lbs.)
Clutch holding nut	8 m-kg (58 ft-lbs.)
Clutch spring screws	0.8 ~ 1.0 m-kg (6.0 ~ 7.0 ft-lbs.)
Middle gear case mounting screws	2.0 ~ 2.5 m-kg (14 ~ 18 ft-lbs.)
Rotor holding bolt	3.0 ~ 4.0 m-kg (22 ~ 29 ft-lbs.)
Bearing housing bolt	2.0 ~ 2.4 m-kg (14 ~ 17 ft-lbs.)
Oil pipe union bolt	2.0 ~ 2.2 m-kg (14 ~ 16 ft-lbs.)
Oil pump drive gear nut	8.0 ~ 12.0 m-kg (58 ~ 87 ft-lbs.)
Crankshaft turning nut	1.5 ~ 2.9 m-kg (11 ~ 21 ft-lbs.)
Cylinder head 8mm	2.0 m-kg (14 ft-lbs.)
10mm	3.5 m-kg (25 ft-lbs.)
Cylinder holding nuts	2.0 m-kg (14 ft-lbs.)
Camshaft cap nuts	1.0 m-kg (7 ft-lbs.)
Engine mounting bolts 10mm	5.0 ~ 6.0 m-kg (36 ~ 43 ft-lbs.)
12mm	8.0 ~ 11.0 m-kg (58 ~ 80 ft-lbs.)
Engine oil drain plug	3.9 ~ 4.7 m-kg (28 ~ 34 ft-lbs.)
Oil filter mounting bolt	3.0 ~ 3.4 m-kg (22 ~ 25 ft-lbs.)
Middle gear drain plug	3.9 ~ 4.7 m-kg (28 ~ 34 ft-lbs.)
Chassis	
Front axle nut	7.0 ~ 10.0 m-kg (50 ~ 72 ft-lbs.)
Front axle holder nuts	1.3 ~ 2.3 m-kg (9 ~ 17 ft-lbs.)
Rear axle nut	12.0 ~ 18.0 m-kg (87 ~ 130 ft-lbs.)
Rear axle pinch bolt	0.45 ~ 0.75 m-kg (3.0 ~ 5.0 ft-lbs.)
Brakes	
Caliper support bolt	1.5 ~ 2.0 m-kg (11 ~ 15 ft-lbs.)
Caliper mounting bolt	4.5 ~ 5.0 m-kg (28 ~ 35 ft-lbs.)
Brake hose union bolt	2.3 ~ 2.8 m-kg (16 ~ 20 ft-lbs.)
Disc mounting bolt	1.7 ~ 2.2 m-kg (12 ~ 16 ft-lbs.)
Front fork pinch bolt	1.3 ~ 2.3 m-kg (9 ~ 17 ft-lbs.)
Steering stem top bolt	6.6 ~ 10.5 m-kg (48 ~ 76 ft-lbs.)
Swing arm pivot lock nut	8.0 ~ 10.0 m-kg (58 ~ 72 ft-lbs.)
Rear shock absorber nut	2.3 ~ 3.7 m-kg (20 ~ 27 ft-lbs.)

General Torque Specifications

This chart specifies torque for standard fasteners with standard I.S.O. pitch threads. Torque specifications for special components or assemblies are included in the applicable sections of this book.



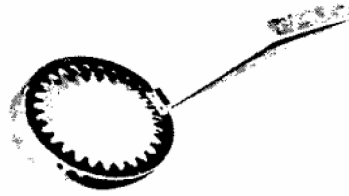
To avoid warpage, tighten multi-fastener assemblies in a criss-cross fashion, in progressive stages, until full torque is reached. Unless otherwise specified, torque specifications call for clean, dry threads. Components should be at room temperature.

A	B	TORQUE SPECIFICATION		
		m-kg	ft-lb	in-lb
10mm	6mm	1.0	7.2	85
12mm	8mm	2.0	15	175
14mm	10mm	3.5 - 4.0	25 - 29	300 - 350
17mm	12mm	4.0 - 4.5	29 - 33	350 - 400
19mm	14mm	4.5 - 5.0	33 - 36	400 - 440
22mm	16mm	5.5 - 6.5	41 - 49	480 - 570
24mm	18mm	5.8 - 7.0	42 - 50	500 - 600
27mm	20mm	7.0 - 8.3	50 - 60	600 - 700
Spark plug		2.5 - 3.0	20 - 22	230 - 250

SPECIAL TOOLS



Valve guide remover



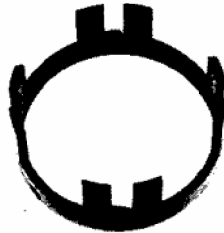
Clutch holding tool



Final drive gear holding tool



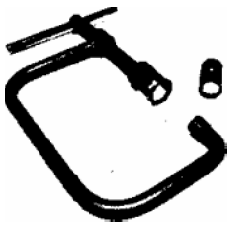
Valve guide installer



Clutch plate installation tool



Middle and final gear holding tool



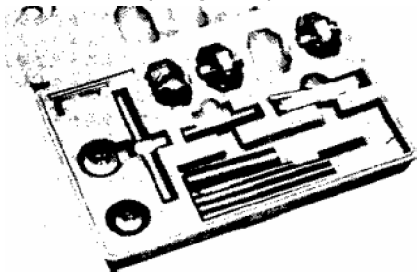
Valve spring compressor



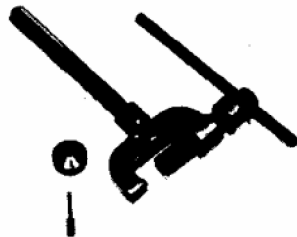
Clutch lock nut wrench



Damper special tool



Valve seat cutter set



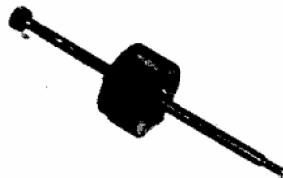
Cam chain cutter



Rotor puller



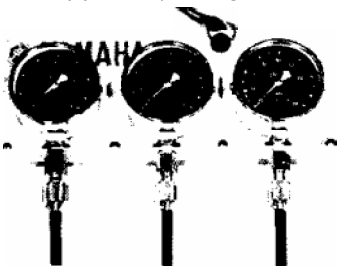
Tappet adjusting tool



Slide hammer



Rotor holding tool



Vacuum gauge



Gear lash measurement tool
(middle gear)



Gear lash measurement tool
(final gear)

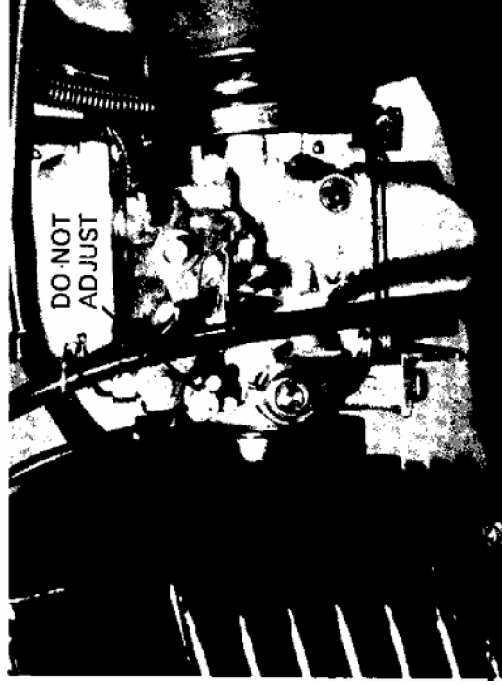
MAINTENANCE AND ADJUSTMENTS

2 - 3 ENGINE

A. Carburetor

1. Idle mixture

The idle mixture is set at the factory by the use of special equipment. No attempt should be made to change this adjustment by the dealer.



b. Remove cap from center carburetor manifold.



c. Connect vacuum gauges on carburetor manifolds as shown.



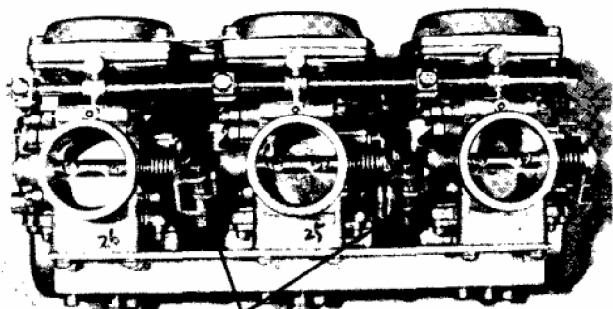
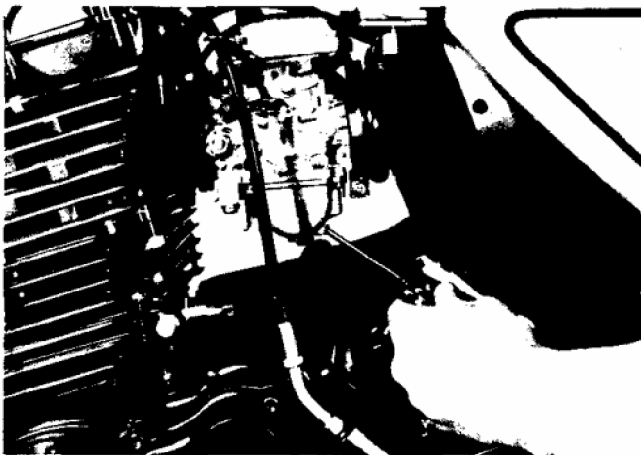
2 Synchronization

NOTE: Ignition timing and valve clearances must be set properly before synchronizing carburetors.

Procedure

- Turn fuel petcock to "On". Remove vacuum pipes from carburetor manifolds (left and right).

- d. Turn petcocks to "prime" position.
- e. Start motorcycle and allow it to warm up for 2-3 minutes. The warm-up is complete when engine responds normally to throttle opening.
- f. Adjust damping valve on each vacuum gauge until the needle flutters only slightly. The gauge needles must respond quickly to rapid opening of the throttle.
- g. Each gauge will indicate the same reading if the carburetors are synchronized. The left and right carburetors are to be synchronized to the center carburetor, which has no synchronizing screw. Turn the left carburetor synchronizing screw until the gauge reading is the same as for the center carburetor. Repeat for the right carburetor.



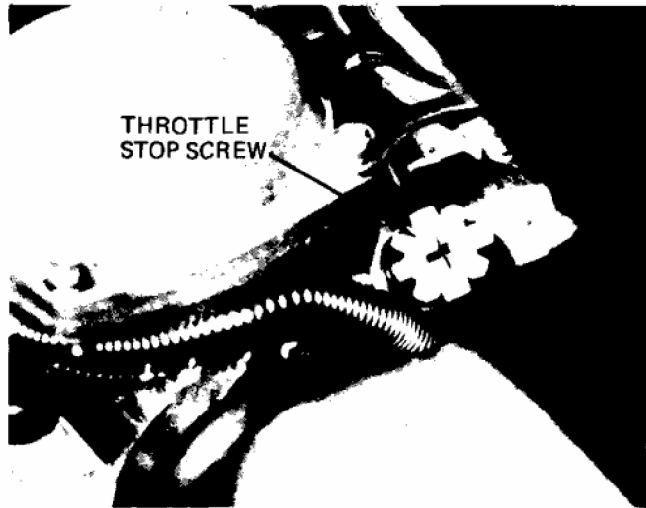
SYNCHRONIZING SCREWS

3. Idle speed adjustment.

NOTE: Carburetors must be synchronized before setting final idle speed. The idle speed adjustment is made by turning only one throttle stop screw.

- a. The engine must be warmed up before setting idle speed.
- b. Set engine idle speed by turning the throttle stop screw in (to increase engine speed) or out (to decrease speed).

Standard Idle RPM
1,050 - 1,150rpm



B. Air Filter

1. Removal

- a. Lift the seat and remove the air filter case cap by removing the pan head screws (2).



- b. Pull out the element.



2. Cleaning method

- a. Tap the element lightly to remove most of the dust and dirt; then blow out the remaining dirt with compressed air through the inner surface of the element. If element is damaged, replace.



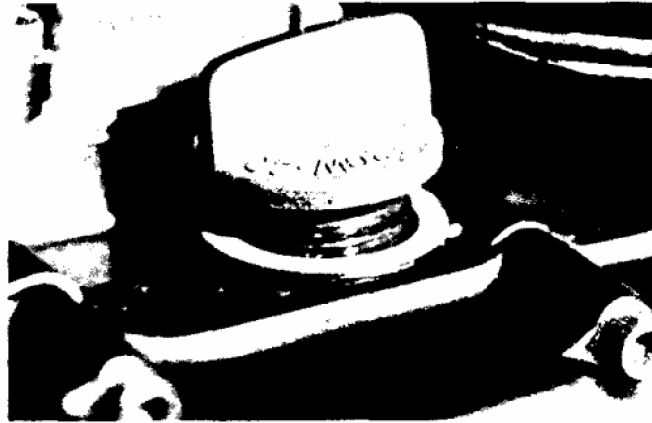
- b. Reassemble by reversing the removal procedure. Check whether the element is seated completely against the case.
- c. The air filter element should be cleaned once a month or every 1,600km (1,000 miles). It should be cleaned more often if the machine is operated in extremely dusty areas.

CAUTION: The engine should never be run without the air cleaner element installed. Excessive oil contamination and engine wear may result.

C. Engine/Transmission Oil

1. Oil level measurement

- a. To check the level, warm the engine up for several minutes. Stop the engine. With the engine stopped, screw the dip stick completely out and then rest the stick in the hole.



NOTE: When checking engine oil level with the dip stick, let the unscrewed dip stick rest on the case threads. Be sure the engine is stopped and the machine is positioned straight up and on both wheels.

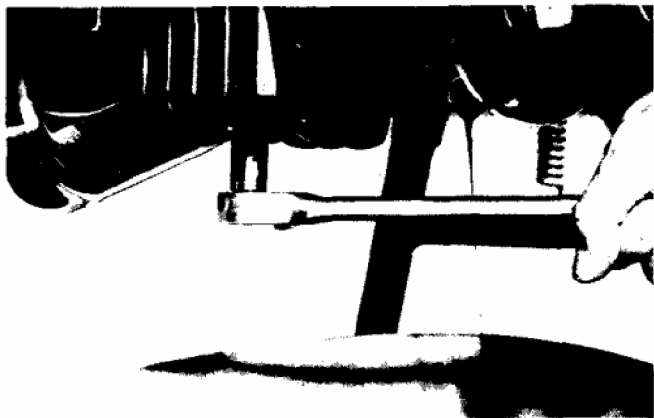
- b. The dip stick has a Minimum and a Maximum mark. The oil level should be between the two. If the level is low, add sufficient oil to raise it to the proper level.

2. Engine/Transmission oil and oil filter replacement

- a. Start the engine. Allow it to warm up for minutes. Stop the engine.
- b. Place an oil pan under the engine and remove the oil filler cap.
- c. Remove the drain plug and drain the oil.



- d. Remove the oil filter bolt and filter element.



- e. Reinstall the drain plug (make sure it is tight).

Drain plug torque:

4.0 ~ 4.5m·kg (28.9-32.5ft·lb)

- f. Install the oil filter element and cover. Tighten the oil filter bolt.

NOTE: Make sure the "O" ring is positioned properly.



- g. Add oil through the dip stick hole.

Oil quantity: Periodic Oil Change

2.8 liter (3 US qt)

With oil filter change:

3.2 liter (3.4 US qt)

Recommended oil: except in cold weather

Yamalube 4-cycle or SAE 20W40 "SE"

(see page 8)



- h. After replacement of engine oil, and/or oil filter, be sure to check the oil pressure and oil leakage. The oil pressure indicator light should go off after the engine is started.

CAUTION: If the "Oil" indicator light remains on, immediately stop the engine. Refer to lubrication information in **Sec. 3-5** for corrective action.

D. Middle Gear/Final Gear Oil

1. Oil level measurement

- a. Place the machine on a level surface and place it on the center stand. The engine should be cool (at atmospheric temperature). Allow 2 minutes for oil to drain to bottom of cases.
- b. Remove the oil filler cap. Check the oil level with level gauge (from tool kit) as shown. The correct oil level is between the two marks on each end of the level gauge. Use end of gauge marked "REAR" for measuring the rear (final) gear case. Use the end marked measuring the middle gear case.

NOTE: Middle gear and final gear oil can be checked with same level gauge, which is in the owners tool kit.





CAUTION: Take care not to allow foreign material to enter the middle and/or final gear case.

2. Gear oil replacement

- Place an oil pan under the transmission for the middle gear and under the final gear case.



- Remove the middle and/or final gear oil filler cap(s) and the drain plug(s), and drain the oil.

WARNING: When draining or filling, take care not to allow foreign material to enter the middle and/or final gear case. Do not allow the gear oil to contact the tire and wheel.

- Reinstall the middle and/or final drain plug(s).



- Fill the gear case(s) up to specified level.

Oil Capacity:

Middle gear case: 375cc (12.7 U.S. fl oz)

Final gear case: 300cc (10.0 U.S. fl oz)

Recommended oil: (see page 8)

- Reinstall the filler cap(s) securely.

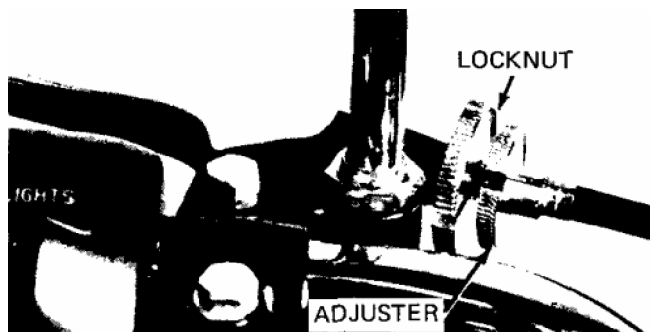
NOTE: After initial 250 mile oil change, it is normally not necessary to change middle and final gear oil more frequently than the indicated service interval of 6,000 miles.

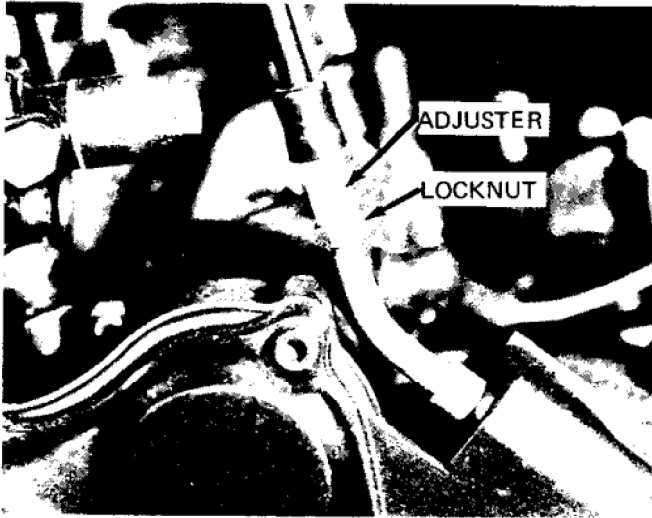
E. Clutch Adjustment

This model has a clutch cable length adjuster and a clutch mechanism adjuster. The cable length adjusters are used to take up slack from cable stretch and to provide sufficient free play for proper clutch operation under various operating conditions. The clutch mechanism adjuster is used to provide the correct amount of clutch "throw" for proper disengagement. Normally, once the mechanism is properly adjusted, the only adjustment required is maintenance of free play at the clutch handle lever.

1. Free play adjustment

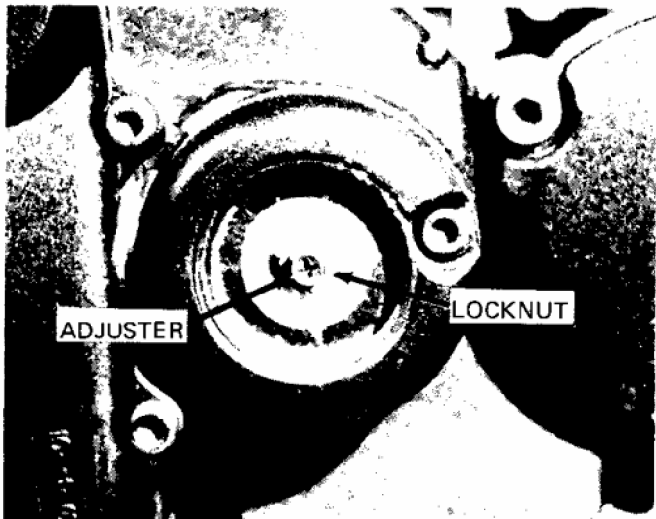
Loosen either the handle lever adjuster lock nut or the cable length adjuster lock nut. Next, turn the length adjuster either in or out until proper lever free play is achieved.





2. Mechanism adjustment

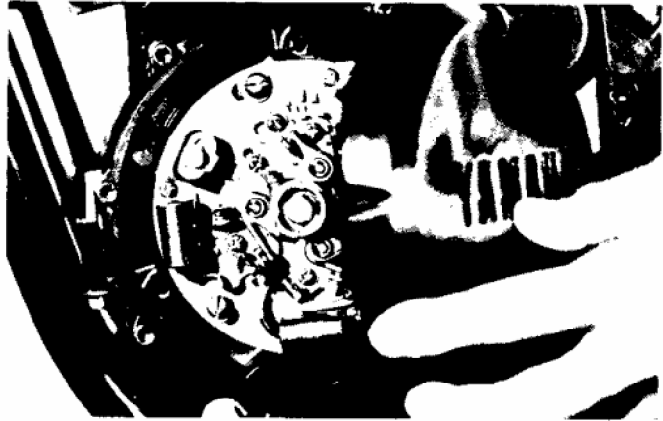
The second adjustment is located behind the adjusting cover. Removing the cover will expose the adjusting set screw and lock nut. Loosen the lock nut and rotate the set screw in until it lightly seats against a clutch push rod that works with the set screw to operate the clutch. Back the set screw out $\frac{1}{4}$ turn and tighten the lock nut. This adjustment must be checked because heat and clutch wear will affect this **free** play, possibly enough to cause improper clutch operation. Recheck clutch cable adjustment at handlebar after adjusting.



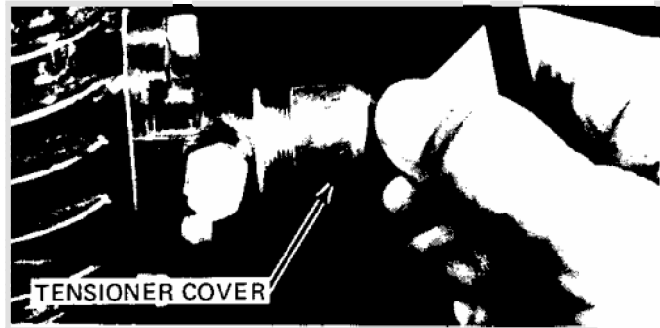
F. Cam Chain Adjustment

The cam chain becomes stretched with **use**, resulting in improper valve timing and engine noise. To prevent this the cam chain tensioner must be adjusted regularly.

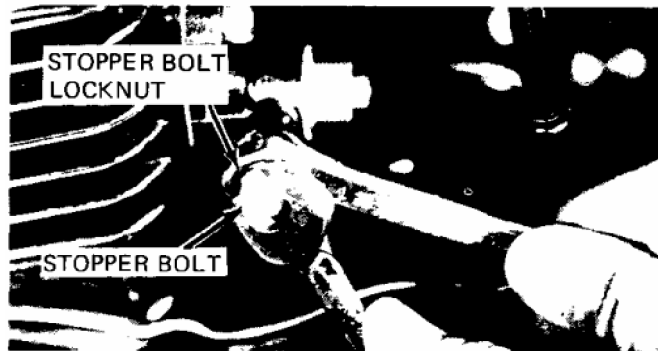
1. Remove the breaker cover



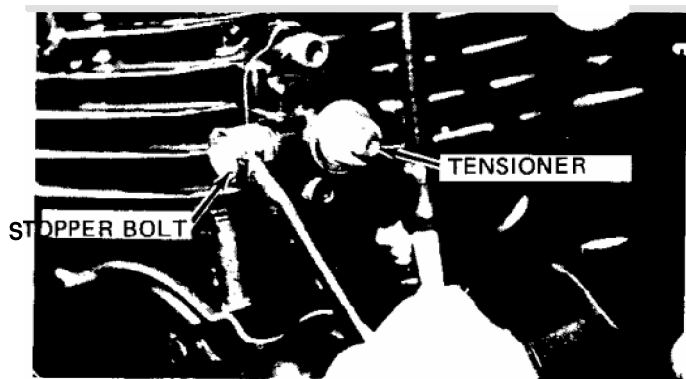
2. Remove the cam chain tensioner cover.



Loosen the tensioner stopper bolt lock nut and then loosen the stopper bolt.



4. Slowly rotate the crankshaft counterclockwise several turns. When the tensioner gets deepest into the tensioner holder, tighten the stopper bolt and secure it with the lock nut.

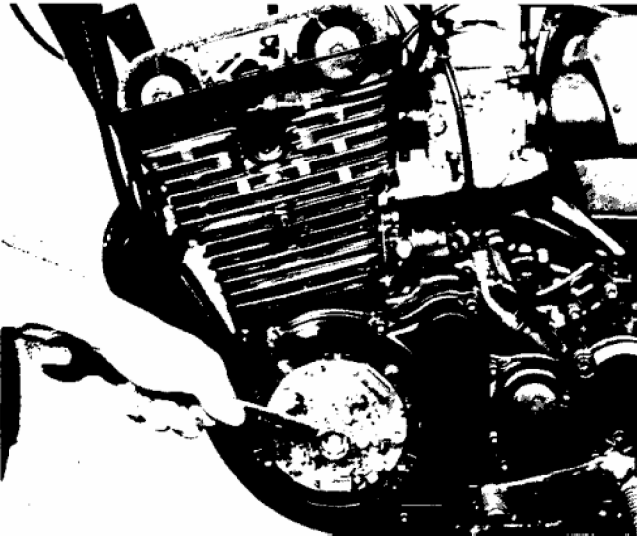


5. Reinstall the chain tensioner cap and the contact breaker cover.

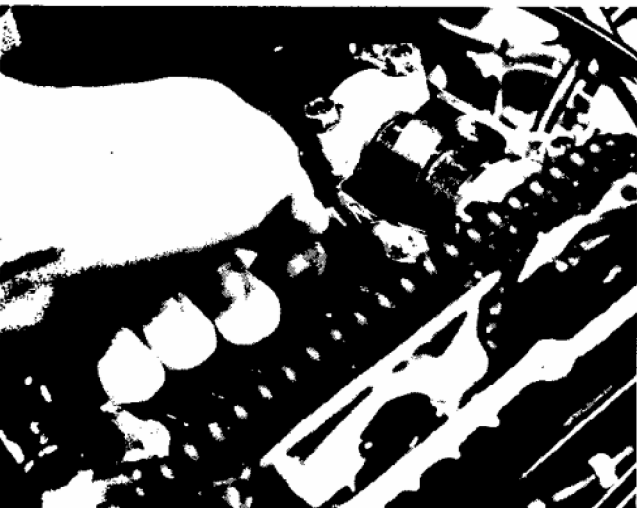
G. Valve Clearance Adjustment

NOTE: Valve clearance must be measured with the engine at room temperature.

1. Remove gas tank.
2. Remove air scoop on cylinder head
3. Remove cylinder head cover and breaker point cover. Care should be taken to not scratch or damage gasket sealing surfaces.
4. Turn crankshaft with nut on left end of crankshaft to turn cams. The proper position of the cam when measuring valve clearance is with the cam lobe directly opposite the valve lifter.



5. Insert a feeler gauge between the valve lifter and the cam heel.



Exhaust valve clearance (cold)
0.21 - 0.25mm (.008 - .010")

Intake valve clearance (cold)
0.16 - 0.20mm (.006 - .008")

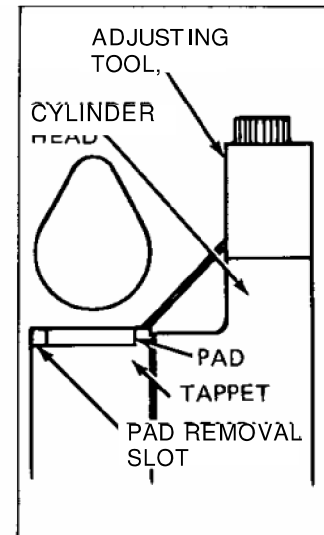
Adjustment

Valve clearance is adjusted by replacing the adjusting pad on the top of the valve lifter. Adjusting pads are available in 25 thicknesses ranging from No. 200 (2.00mm) to No. 320 (3.20mm) in steps of 0.05mm. The thickness of each pad is marked on the pad face that contacts the valve lifter (not the cam). Adjustment of valve clearance is accomplished as follows:

1. Determine valve clearance (feeler gauge measurement).
2. Remove adjusting pad and note number.
3. Select proper pad from appropriate chart (intake or exhaust chart).
4. Install new pad and check installed clearance.

Procedure

1. Measure valve clearance. If clearance is incorrect, record the measured amount of clearance. This must be measured carefully.
2. There is a slot in the valve lifter. This slot must be positioned opposite the blade of the tappet adjusting tool before the tool is installed.
3. Turn the cam until the lobe fully depresses the valve lifter and opens the valve. Install the tappet adjusting tool as shown to hold the lifter in this depressed position.



NOTE: The tappet adjusting tool is fastened to the cylinder head using one (1) allen screw such as one used to install the cylinder head cover. Make sure that the tool contacts the lifter only, and not the pad.

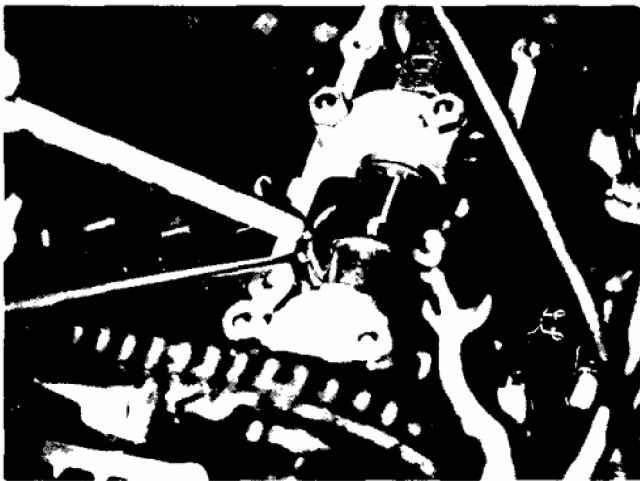
CAUTION: If the cam lobe touches the tappet adjusting tool, the stress may fracture the cylinder head. **DO NOT ALLOW THE CAM TO CONTACT THE TAPPET ADJUSTING TOOL.**

4. Carefully rotate the cam so that the pad can be removed. To avoid cam touching adjusting tool, turn cams as follows: (view from left side of machine)

Intake: Carefully rotate CLOCKWISE.

Exhaust: Carefully rotate COUNTERCLOCKWISE.

5. Remove the pad from the lifter. There is a slot in the lifter. Use a small screwdriver or other blade and a magnetic rod to remove the pad. Note the number on the pad.



6. Proper pad selection is made as follows: (Use appropriate chart for exhaust or intake valves.)
 - a. Find number of original (installed) pad number on chart. Read down on chart.
 - b. Find measured valve clearance (from step 1) on chart. Read across.
 - c. At the intersection of installed pad number (down) and measured clearance (across) is a new pad number.

EXAMPLE: Exhaust valve, installed pad:
No. 250 (read down)
Measured clearance: 0.32mm
(read across)
New pad number: No. 260
(intersection of down & across)

NOTE: The new pad number is to be used as a guide only. Verify the correctness of this choice in the following steps).

7. Install the new pad in the lifter. Install the pad with the number down.
8. Remove tappet adjusting tool.
9. Turn crankshaft to rotate cam several rotations. This will set the pad in the lifter.
10. Check valve clearance (step 3). If clearance is incorrect, repeat preceding steps until proper clearance is obtained.
11. Inspect head cover gasket. If bent or torn, replace gasket.
12. Reinstall removed parts in reverse order.

H. Compression Pressure Measurement

Insufficient compression pressure will result in performance **loss** and may indicate leaking valves or worn or damaged rings.

Procedure

1. Make sure valve clearance is correct.
2. Warm up engine 2-3 minutes. Stop engine.
3. Remove spark plugs.
4. Install compression check gauge.



Intake

MEASURED CLEARANCE	200	205	210	215	220	225	230	235	240	245	250	255	260	265	270	275	280	285	290	295	300	305	310	315	320
0.00 ~ 0.05				200	205	210	215	220	225	230	235	240	245	250	255	260	265	270	275	280	285	290	295	300	305
0.06 ~ 0.10			200	205	210	215	220	225	230	235	240	245	250	255	260	265	270	275	280	285	290	295	300	305	310
0.11 ~ 0.15		200	205	210	215	220	225	230	235	240	245	250	255	260	265	270	275	280	285	290	295	300	305	310	315
0.16 ~ 0.20																									
0.21 ~ 0.25	205	210	215	220	225	230	235	240	245	250	255	260	265	270	275	280	285	290	295	300	305	310	315	320	
0.26 ~ 0.30	210	215	220	225	230	235	240	245	250	255	260	265	270	275	280	285	290	295	300	305	310	315	320		
0.31 ~ 0.35	215	220	225	230	235	240	245	250	255	260	265	270	275	280	285	290	295	300	305	310	315	320			
0.36 ~ 0.40	220	225	230	235	240	245	250	255	260	265	270	275	280	285	290	295	300	305	310	315	320				
0.41 ~ 0.45	225	230	235	240	245	250	255	260	265	270	275	280	285	290	295	300	305	310	315	320					
0.46 ~ 0.50	230	235	240	245	250	255	260	265	270	275	280	285	290	295	300	305	310	315	320						
0.51 ~ 0.55	235	240	245	250	255	260	265	270	275	280	285	290	295	300	305	310	315	320							
0.56 ~ 0.60	240	245	250	255	260	265	270	275	280	285	290	295	300	305	310	315	320								
0.61 ~ 0.65	245	250	255	260	265	270	275	280	285	290	295	300	305	310	315	320									
0.66 ~ 0.70	250	255	260	265	270	275	280	285	290	295	300	305	310	315	320										
0.71 ~ 0.75	255	260	265	270	275	280	285	290	295	300	305	310	315	320											
0.76 ~ 0.80	260	265	270	275	280	285	290	295	300	305	310	315	320												
0.81 ~ 0.85	265	270	275	280	285	290	295	300	305	310	315	320													
0.86 ~ 0.90	270	275	280	285	290	295	300	305	310	315	320														
0.91 ~ 0.95	275	280	285	290	295	300	305	310	315	320															
0.96 ~ 1.00	280	285	290	295	300	305	310	315	320																
1.01 ~ 1.05	285	290	295	300	305	310	315	320																	
1.06 ~ 1.10	290	295	300	305	310	315	320																		
1.11 ~ 1.15	295	300	305	310	315	320																			
1.16 ~ 1.20	300	305	310	315	320																				
1.21 ~ 1.25	305	310	315	320																					
1.26 ~ 1.30	310	315	320																						
1.31 ~ 1.35	315	320																							
1.36 ~ 1.40	320																								

VALVE CLEARANCE (engine cold) 0.16 ~ 0.20mm

Example: Installed is 250
Measured clearance is 0.32mm
Replace 250 pad with 265

*Pad number: (example) Pad No. 250 = 2.50mm
Pad No. 255 = 2.55mm

Always install pad with number down.

VALVE CLEARANCE (engine cold) 0.16 ~ 0.20mm

Example: Installed is 250
Measured clearance is 0.32mm
Replace 250 pad with 265

*Pad number: (example) Pad No. 250 = 2.50mm
Pad No. 255 = 2.55mm

Always install pad with number down.

Exhaust

MEASURE! CLEARANC	INSTALLED PAD NUMBER*																											
	200	205	210	215	220	225	230	235	240	245	250	255	260	265	270	275	280	285	290	295	300	305	310	315	32			
0.00 ~ 0.05					200	205	210	215	220	225	230	235	240	245	250	255	260	265	270	275	280	285	290	295	300			
0.06 ~ 0.10				200	205	210	215	220	225	230	235	240	245	250	255	260	265	270	275	280	285	290	295	300	30			
0.11 ~ 0.15			200	205	210	215	220	225	230	235	240	245	250	255	260	265	270	275	280	285	290	295	300	305	31			
0.16 ~ 0.20		200	205	210	215	220	225	230	235	240	245	250	255	260	265	270	275	280	285	290	295	300	305	310	31			
0.21 ~ 0.25																												
0.26 ~ 0.30	205	210	215	220	225	230	235	240	245	250	255	260	265	270	275	280	285	290	295	300	305	310	315	320				
0.31 ~ 0.35	210	215	220	225	230	235	240	245	250	255	260	265	270	275	280	285	290	295	300	305	310	315	320					
0.36 ~ 0.40	215	220	225	230	235	240	245	250	255	260	265	270	275	280	285	290	295	300	305	310	315	320						
0.41 ~ 0.45	220	225	230	235	240	245	250	255	260	265	270	275	280	285	290	295	300	305	310	315	320							
0.46 ~ 0.50	225	230	235	240	245	250	255	260	265	270	275	280	285	290	295	300	305	310	315	320								
0.51 ~ 0.55	230	235	240	245	250	255	260	265	270	275	280	285	290	295	300	305	310	315	320									
0.56 ~ 0.60	235	240	245	250	255	260	265	270	275	280	285	290	295	300	305	310	315	320										
0.61 ~ 0.65	240	245	250	255	260	265	270	275	280	285	290	295	300	305	310	315	320											
0.66 ~ 0.70	245	250	255	260	265	270	275	280	285	290	295	300	305	310	315	320												
0.71 ~ 0.75	250	255	260	265	270	275	280	285	290	295	300	305	310	315	320													
0.76 ~ 0.80	255	260	265	270	275	280	285	290	295	300	305	310	315	320														
0.81 ~ 0.85	260	265	270	275	280	285	290	295	300	305	310	315	320															
0.86 ~ 0.90	265	270	275	280	285	290	295	300	305	310	315	320																
0.91 ~ 0.95	270	275	280	285	290	295	300	305	310	315	320																	
0.96 ~ 1.00	275	280	285	290	295	300	305	310	315	320																		
1.01 ~ 1.05	280	285	290	295	300	305	310	315	320																			
1.06 ~ 1.10	285	290	295	300	305	310	315	320																				
1.11 ~ 1.15	290	295	300	305	310	315	320																					
1.16 ~ 1.20	295	300	305	310	315	320																						
1.21 ~ 1.25	300	305	310	315	320																							
1.26 ~ 1.30	305	310	315	320																								
1.31 ~ 1.35	310	315	320																									
1.36 ~ 1.40	315	320																										
1.41 ~ 1.45	320																											

VALVE CLEARANCE (engine cold) 0.21 ~ 0.25mm

Example: Installed is 250
Measured clearance is 0.32mm
Replace 250 pad with 260

*Pad number: (example) Pad No. 250 = 2.50mm
Pad No. 255 = 2.55mm

Always install pad with number down.

VALVE CLEARANCE (engine cold) 0.21 ~ 0.25mm

Example: Installed is 250
Measured clearance is 0.32mm
Replace 250 pad with 260

*Pad number: (example) Pad No. 250 = 2.50mm
Pad No. 255 = 2.55mm

Always install pad with number down.

5. Turn over engine with kick or electric starter (make sure battery is fully charged) with throttle wide open until pressure indicated on the gauge does not increase further.

Compression pressure: (at sea level)

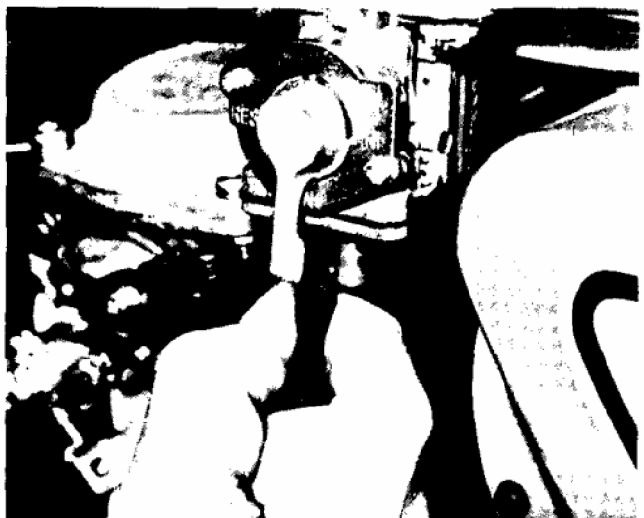
Standard: 10 kg/cm² (142 psi)
Minimum: 9 kg/cm² (128 psi)
Maximum: 11 kg/cm² (156 psi)

6. If pressure is too low, squirt a few drops of oil into the cylinder being measured. Measure compression again. If there is a higher reading than before (without oil), the piston rings may be worn or damaged. If the pressure remains the same after measuring with the oil, either or both the rings and valves may be the cause.
- 7 Check each cylinder. Compression pressure should not vary more than 1 kg/cm² (14 psi) from one cylinder to any other cylinder.

2 - 4 CHASSIS

A. Fuel Petcock Cleaning

1. Turn the petcock lever to the "ON" or "RES" position. Remove the fuel pipe.



2. Remove the drain cover and clean it with solvent.



B. Fuel Petcock Disassembly

If the fuel petcock is leaking or excessively contaminated, it should be removed from the fuel tank and inspected.

1. Remove fuel tank and position it so that fuel will not spill when the petcock is removed.
2. Remove petcock and inspect filter screen. Replace filter if seriously contaminated.
3. Remove 4 screws on front and rear of petcock and remove plate, gaskets, lever and diaphragm.
4. Inspect all components and replace any that are damaged. If the diaphragm is in any way damaged, or the petcock body gasket surfaces scratched or corroded, the petcock assembly must be replaced. If there is abrasive damage to any component, the fuel tank must be drained and flushed.
5. Reassemble petcock and install on fuel tank.

C. Front And Rear Brake

See pages 158–159 for adjustments

1. Brake adjustment

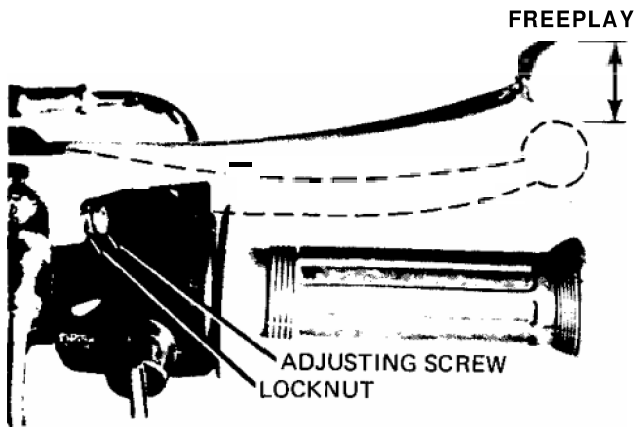
The brakes can be adjusted by simply adjusting the free play of the brake lever and pedal. piston in the caliper moves forward as the brake pad wears out, automatically adjusting the clearance between the brake pad and the brake disc.)

- a. Front brake lever free play

CAUTION: Proper lever free play is essential to avoid excessive brake drag.

1) Loosen the adjusting screw lock nut.

2) By turning the adjusting screw in or out, adjust the play of the brake lever and then tighten the lock nut. Measure free play at end of lever.



Free play: 5~8mm (0.2~0.3 in.)

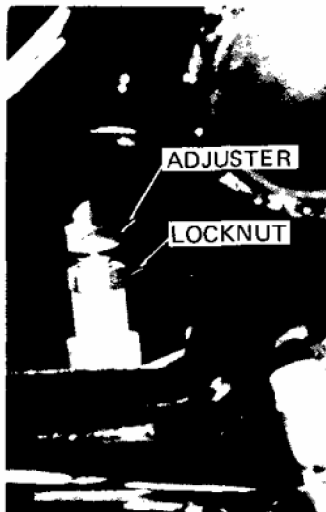
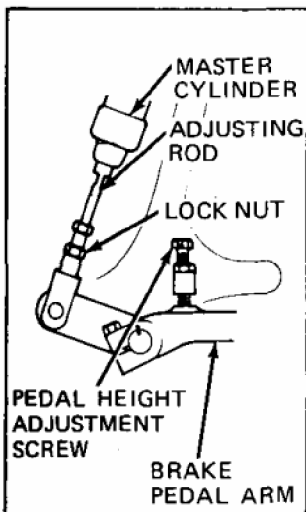
b. Rear brake pedal free play

CAUTION: Proper pedal free play is essential to avoid excessive brake drag.

FREE PLAY : 10mm (0.437 in.)

1) Loosen the adjuster lock nut at the push rod.

2) By turning the adjuster in or out, adjust the play of the brake pedal and then tighten the lock nut.



2. Brake pad check

To check pad wear, open the wear indicator cap. If any pad is worn to the red line, replace both pads in the caliper.



3 Check the brake fluid level

Insufficient brake fluid may allow air to enter the brake system, possibly causing the brake to become ineffective. Check the brake fluid level and replenish when necessary and observe these precautions:

a. **Use** only the designated quality brake fluid; otherwise, the rubber seals may deteriorate, causing leakage and poor brake performance.

Recommended brake fluids:
DOT No. 3 with 240°C (464°F)
boiling point

b. Refill with the same type and brand of brake fluid; mixing fluids may result in a harmful chemical reaction and lead to poor performance.

- c. Be careful that water or other contamination does not enter the master cylinder when re-filling. Water will significantly lower the boiling point and may result in vapor lock.



2. Front axle

- a. Check axle nuts.

Front axle nut torque:

7.0~10.0 m·kg
(50~72 ft·lb)

Rear axle nut torque:

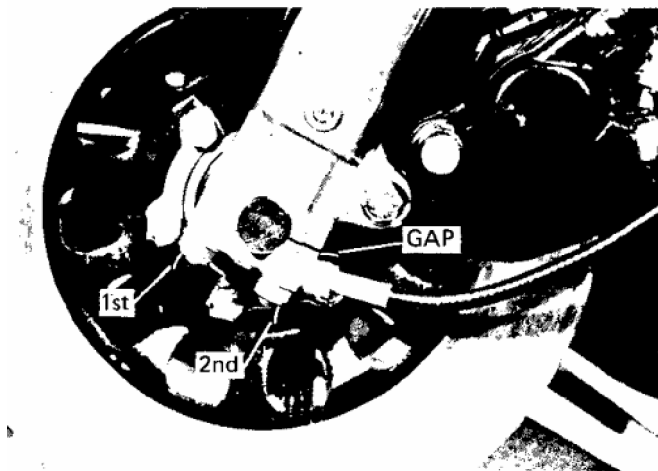
12~18 m·kg
(87~130 ft·lb)

- b. Check axle holder nuts (right side).

Front axle holder nuts:

1.3 - 2.3 m·kg (9-17 ft·lbs)

CAUTION: First tighten the nut on the front end **of the** axle holder, and then tighten the nut on the rear end.



Rear axle pinch bolt:

0.45 - 0.75 m·kg (3-5 ft·lbs)

D. Wheels And Tires

1. Checking the aluminum wheels.

- a. Check for cracks, bends or warpage of the wheels. If a wheel is deformed or cracked, it must be replaced.

NOTE: These aluminum wheels are NOT designed for use with tubeless tires.

- b. Raise the wheel off the ground. Spin.

Rim runout limits:

Vertical - 2mm (0.08 in.)

Lateral - 1mm (0.04 in.)

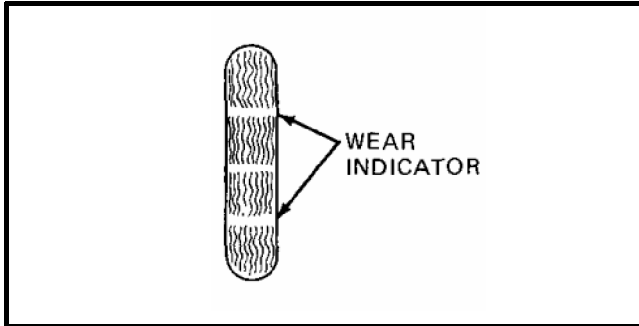
3. Tires

Tire pressure

Front	1.8 kg/cm ² (26 psi)	Normal riding
Rear	2.0 kg/cm ² (28 psi)	
Front	2.0 kg/cm ² (28 psi)	High speed riding (above 100 km/h or 60 mph)
Rear	2.3 kg/cm ² (33 psi)	

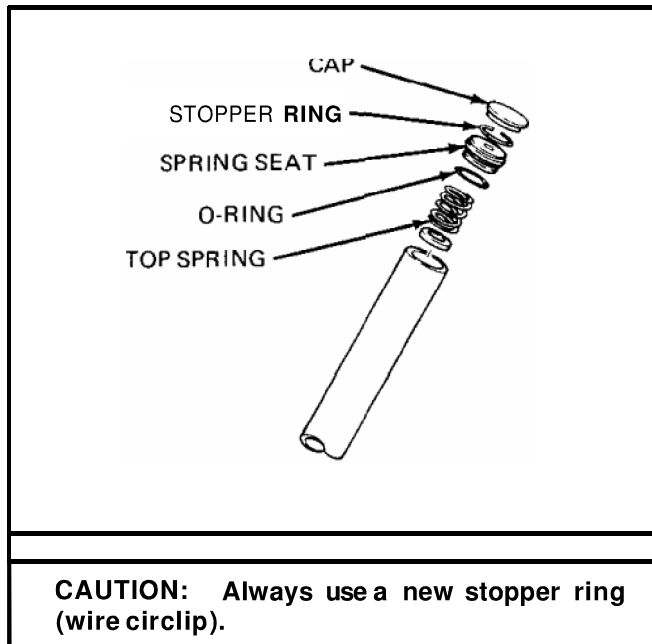
b. Check the tire wear

If a tire tread shows crosswise lines, it means that the tire is worn to its limit. Replace the tire.



9. Inspect the O-ring on the spring seat. Replace O-ring if damaged.

10. Reinstall top spring, O-ring, spring seat, stopper ring and rubber cap.



CAUTION: Always use a new stopper ring (wire circlip).

E. Front Fork Oil Change

1. Raise the machine or remove the front wheel so that there is no weight on the front end of the machine.
2. Remove the rubber cap from the top of each fork.
3. The spring seat and springs are retained by a stopper ring (spring wire circlip). It is necessary to depress the spring seat and fork springs to remove the stopper ring. Remove the stopper ring by carefully prying out one end with a small screwdriver.
4. Place open container under each drain hole. Remove drain screw from each outer tube.

CAUTION: Do not allow oil to contact disc brake components.

5. When most of the oil has drained, slowly raise and lower the outer tubes to pump the remaining oil. It may be necessary to remove the spring seat and top spring to keep them from falling out when raising fork tubes.
6. Inspect drain screw gasket. Replace if damaged. Reinstall drain screw.
7. Pour specified amount of oil into the fork inner tube.

Front fork oil (each fork): 170cc
20W Yamaha Fork Oil

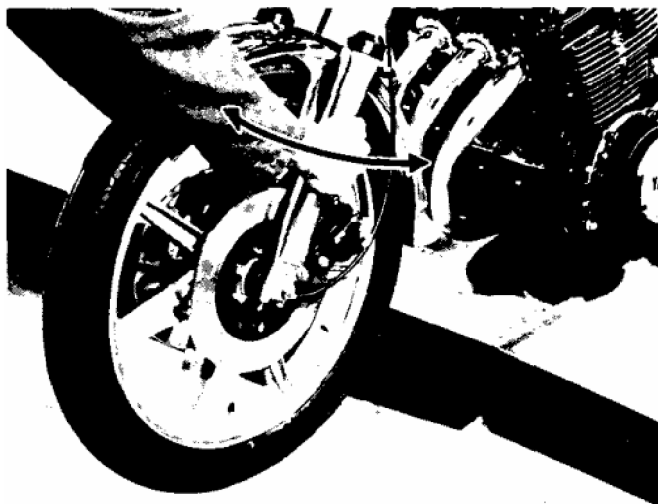
8. After filling, slowly pump the outer tubes up and down to distribute the oil.

F. Steering Head Adjustment

The XS750D steering head is fitted with tapered roller bearings. The steering assembly should be checked periodically for looseness.

Procedure

1. Raise front end of machine so that there is no weight on the front wheel.
2. Grasp bottom of forks and gently rock fork assembly backward and forward, checking for looseness in the steering assembly bearings.



3. If there is looseness in the steering head, loosen the crown pinch bolt and steering fitting bolt.
4. Use steering nut wrench to loosen top steering fitting nut. The top nut **serves** as a lock nut.
5. Tighten the lower steering fitting nut until the steering head is tight, but does not bind when forks are turned.
6. Retighten the top steering fitting nut, steering fitting bolt and crown pinch bolt, in that order.
7. Recheck steering adjustment to make sure there is no binding when the forks are moved from lock to lock. If necessary, repeat adjustment procedure.

G. Throttle Cable And Grip Lubrication

The throttle twist grip assembly should be greased at the time that the cable is lubricated since the grip must be removed to get at the end of the throttle cable. Two screws clamp the throttle housing to the handlebar. Once these two are removed, the end of the cable can be held high to pour in several drops of lubricant. With the throttle grip disassembled, coat the inside surface of the throttle grip guide tube with a suitable all-purpose grease to cut down friction.

H. Lubrication Of Levers, Pedals, Etc.

1. Lubricate the pivoting parts of the brake and clutch levers with motor oil (10W30).
2. Lubricate the shaft of the brake pedal with lithium soap grease.

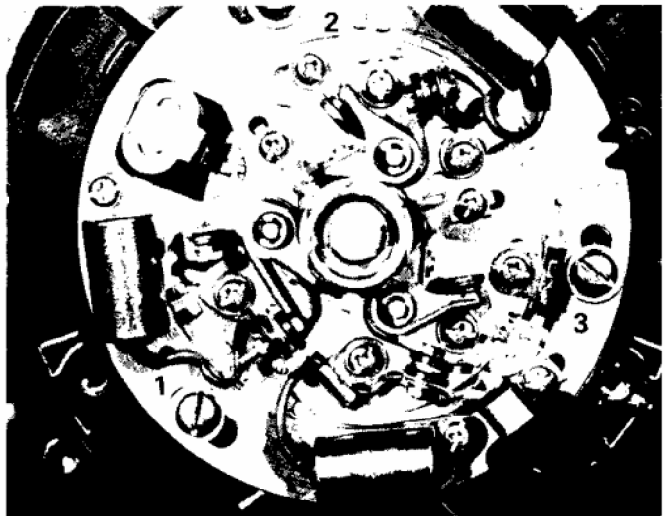
2-5 ELECTRICAL

A. Contact Breaker Point Adjustment

1. Remove breaker point cover.
2. Each cylinder has a set of breaker points. The No. 1 (left) cylinder set is marked with a "1" on the backing plate. The No. 2 (center) cylinder set is marked with a "2", and the No. 3 cylinder set is marked "3". The spark plug wires are also numbered.
3. Check contact breaker point gap (at largest gap) with feeler gauge.

Contact Breaker Gap:

0.3 - 0.4mm (.012~.016 in.)



If necessary, adjust by loosening securing screws and moving the adjustable contact point.

4. Tighten adjusting screws and recheck breaker point gap.

B. Contact Breaker Point Maintenance

1. Apply a few drops of lightweight lubricant to the point cam lubricators.
2. The points can be lightly sanded with fine emery paper to remove corrosion. Then place a piece of clean paper between the points and let them close. Remove the paper. Repeat until no residue shows. The paper may be dipped in lacquer thinner or contact point cleaning fluid to remove oil or sanding residue from the point surface.
3. Point replacement should be necessary only when point gap exceeds maximum tolerance, when the points become severely pitted, or if the points become shorted or show faulty operation. New points must be cleaned and adjusted when installed.

C. Ignition Timing

NOTE: Point gap must be set before setting timing.

1. Ignition timing is checked with a timing light by observing the position of the stationary pointer and the marks stamped on the governor assembly. The governor assembly is marked as follows:

"1F"	Retarded firing point for L.H. cylinder.
"2F"	Retarded firing point for center cylinder.
"3F"	Retarded firing point for R.H. cylinder.
"T"	Top dead center for each cylinder.

There are also three (3) pair of unmarked lines. They indicate the Full Advance firing range for each cylinder.

Connect timing light to No. 1 (left) cylinder.

2. Ignition timing of No. 1 cylinder must be set first. Connect timing light to No. 1 spark plug lead wire.
3. Start engine
4. The stationary pointer should line up with the "1F" timing mark on the governor. If it does not align, loosen 3 breaker backing plate screws and move the complete backing plate until "1F" and the pointer marks align.



5. Retighten screw. Check timing again for the No. 1 cylinder.
6. Rev the engine to above 3,000 rpm. The pointer should indicate the area of the two "full advance" marks on the governor.

NOTE: Retarded ignition: 1,100~1,550
Advance begins: 1,600'
Full Advance achieved: 2,900

7. Repeat procedure (steps 2-7) for remaining cylinders. Loosen each individual point assembly plate before adjusting. Retighten screws and recheck timing for each cylinder.

CAUTION: Never bend adjusting pointer.

8. The above procedure is recommended for setting ignition timing. However, the following information is provided so that the position of the static pointer can be verified using a degree wheel.

Retarded ignition: 10° BTDC
Fully Advanced Ignition: 38.5±1.5° BTDC

D. Battery

A poorly maintained battery will deteriorate quickly. The battery fluid should be checked at least once a month.

1. The level should be between the upper and lower level marks. **Use** only distilled water for refilling. Normal tap water contains minerals which are harmful to a battery; therefore, re-fill only with distilled water.
2. Always make sure the connections are correct when installing the battery. The red lead is for the (+) terminal and the black lead is for the (-) terminal. Make sure the breather pipe is properly connected, properly routed, and is not damaged or obstructed.

NOTE: The battery must be charged before using to insure maximum performance. Failure to properly charge the battery before first use, or a low electrolyte level, will cause premature failure of the battery.

Charging current: 1.4 Amps
Charging hours: 10 hrs.

E. Spark Plug

The spark plug indicates how the engine is operating. If the engine is operating correctly, and the machine is being ridden properly, the tip of the white insulator around the positive electrode of the spark plug will be a medium tan color. If the insulator is very dark brown or black color, then a plug with a hotter heat range might be required. This situation is quite common during the engine break-in period. If the insulator tip shows a very light tan or white color or is actually pure white and glazed, or if electrodes show signs of melting, then a spark plug with a colder heat range is required. Remember, the insulator area surrounding the positive electrode of the spark plug must be a medium tan color. If it is not, check carburetion, timing and ignition adjustments.

The spark plug must be removed and checked. Check electrode wear, insulator color, and electrode gap.

Spark plug gap:
0.6~0.7mm (0.02~0.03 in.)

Engine heat and combustion chamber deposits will cause any spark plug to slowly break down and erode. If the electrodes finally become too worn, or if for any reason you believe the spark plug is not functioning correctly, replace it. When installing the plug, always clean the gasket surface, use a new gasket, wipe off any grime that might be present on the surface of the spark plug, and torque the spark plug properly.

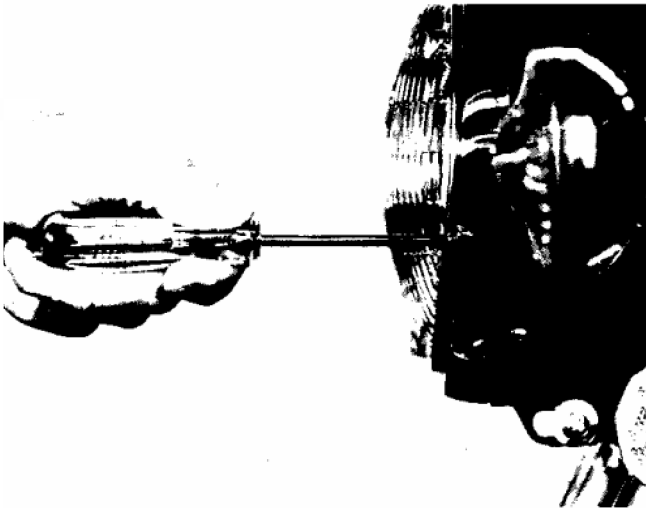
Standard Spark Plug: NGK BP-7ES
Champion N-7 Y
Tightening Torque: 1.5~2.5 m·kg
(10.8~18.1 ft·lb)

F. Headlight

1. Headlight beam adjustment.

When necessary, adjust the headlight beam as follows:

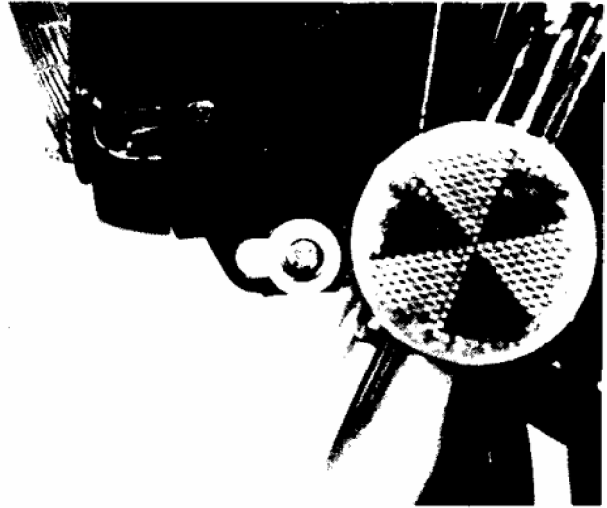
- Adjust horizontally by tightening or loosening the adjust screw.



To adjust to the right: Tighten the screw
To adjust to the left: Loosen the screw

b. Adjust vertically as follows:

- Loosen adjusting screw under headlight body.



Adjust vertically by moving the headlight body. When proper adjustment is determined, retighten adjusting screw.

2. Replacing the headlight bulb.



- Unhook springs and pull the defective unit out of the shell.
- Slip a new unit into position and install springs.
- Adjust headlight beam.

NOTE: Take care not to damage the headlight. It is very fragile.

ENGINE OVERHAUL

3-1 ENGINE REMOVAL

NOTE: It is not necessary to remove the engine to remove the cylinder head, cylinder, or pistons.

A. Preparation For Removal

1. All dirt, mud, dust and foreign material should be thoroughly removed from the exterior of the engine before removal and disassembly. This will help prevent any harmful foreign material from entering the engine.
2. Before engine removal and disassembly, be sure that you have the proper tools and cleaning equipment so that you can perform a clean and efficient job.
3. During disassembly of the engine, clean and place all parts in trays in order of disassembly. This will speed assembly time and help insure correct reinstallation of all engine parts.
4. Place machine on center stand. Start engine and allow it to warm up. Stop engine and drain engine/transmission oil.
5. Remove oil filter element to drain oil filter.
6. If middle gear case is to be removed, drain middle gear oil.
7. Remove air scoop from cylinder head cover.

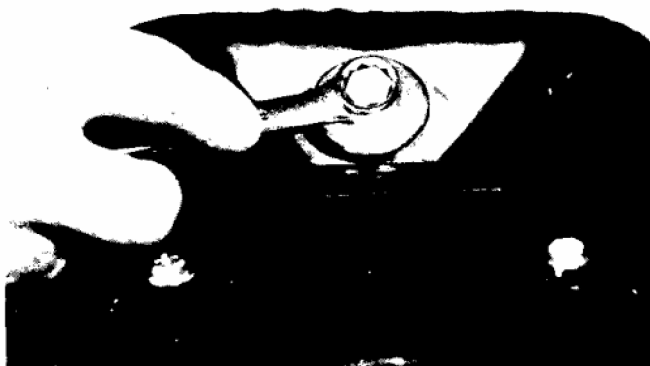


B. Fuel Tank Removal

1. Turn fuel petcocks to "on" (there is no "off" position—fuel will not flow from a petcock on

the "on" position unless the engine is operating). Disconnect fuel pipes and vacuum pipes from petcock.

2. Lift seat and remove fuel tank holding bolt. Remove fuel tank.



C. Muffler, Footrest, Brake Pedal

Remove rear brake pedal and passenger right footrest.

2. Remove exhaust pipe holding screws from cylinder head.



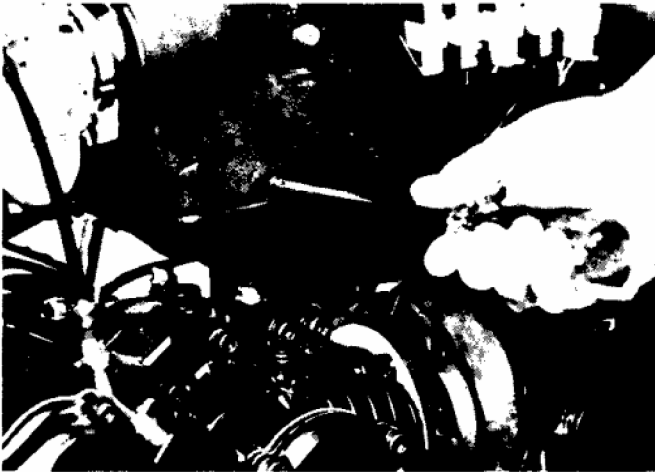
3. Remove exhaust pipes and muffler as an assembly.

D. Side Cover, Air Cleaner Case

1. Remove left and right side covers.



2. Remove screws holding intake silencers (left and right). Remove intake silencers.



3. Loosen clamps holding carburetors to air cleaner case and intake manifolds. Loosen breather hose clamp at air cleaner case junction.



4. Remove bolts holding air cleaner case to frame. Note ground wire connection on left frame bracket.



5. Pull air cleaner case to the rear. Remove clutch cable from holder attached to the left carburetor. Lift carburetors back and to the left. Remove throttle cable from carburetors.



6. Remove air cleaner case,

E. Wiring and Cables

1. Pull back rubber cover on clutch adjuster at engine. Disconnect clutch cable.



2. Remove spark plug wires and tachometer cable.

3. Remove two (2) screws holding starter motor cover. Remove starter motor cover. Disconnect electric starter cable.



4. Disconnect ground wire from top of engine case.

5. Disconnect wiring harness couplers on left side of machine. Remove ignition wiring (orange, yellow, grey, blue wires), generator wiring (white wires), and field wiring (green, black wires). Position wires so that they can be safely removed.



F. Drive Shaft Joint

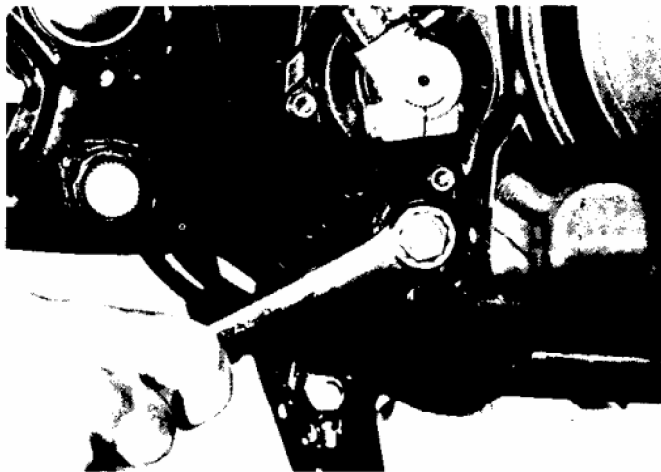
1. Pull rubber boot from drive shaft coupling to expose four (4) bolts.



2. Remove four (4) bolts on drive shaft coupling.

G. Removal

1. Remove three (3) engine mounting bolts from frame. Remove footrests with the two (2) rear engine mounting bolts.



2. Slide engine forward. Remove engine to the right. Position a box or other support to the right of the machine for assistance when removing the engine.

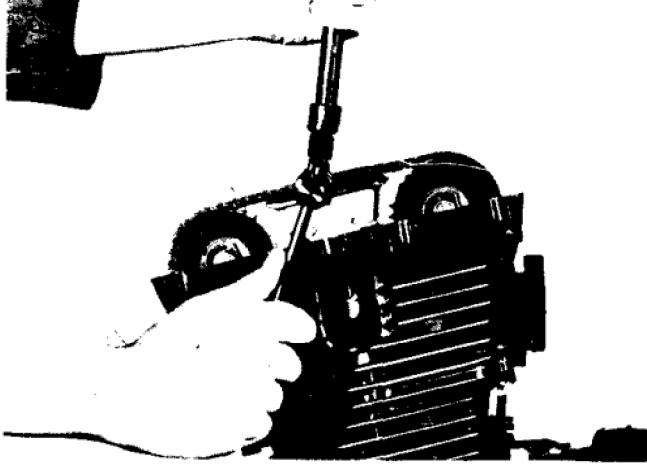
3-2 ENGINE DISASSEMBLY

A. Cylinder Head and Cylinder Removal

NOTE: Cylinder head and cylinder can be removed without removing engine.

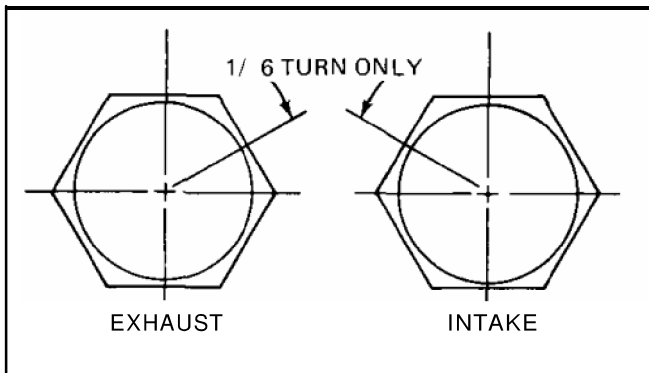
1. Remove cylinder head cover.

2. Remove points cover. Rotate the crankshaft to T.D.C. of the compression stroke on the NO. 1 (L.H.) cylinder. Tie each end of the cam chain to prevent it from falling into the crankcases when it is separated. Push out the master link pins with the cam chain cutter.



CAUTION: Whenever the cam chain is separated, valve and cylinder head damage can occur **by** random turning of the cam shafts.

3. Rotate intake cam 1/6 turn counterclockwise (from L.H. end) and rotate exhaust cam 1/6 turn clockwise (from L.H. end). See illustration.



4. Remove cam chain guide stopper.



5. Remove the cam caps

CAUTION: To avoid damage to the camshaft caps, observe the following:

- a. Position cams as described in step 3.
- b. The camshaft caps are numbered left to right 1, 2, 3, 4 and 'E' or 'I' for intake or exhaust. Damage will result if the caps are incorrectly removed or installed.
- c. Remove camshaft caps from right to left (4, 3, 2, 1). Notice that the arrows on the caps all point to the LEFT.
- d. Remove cams.

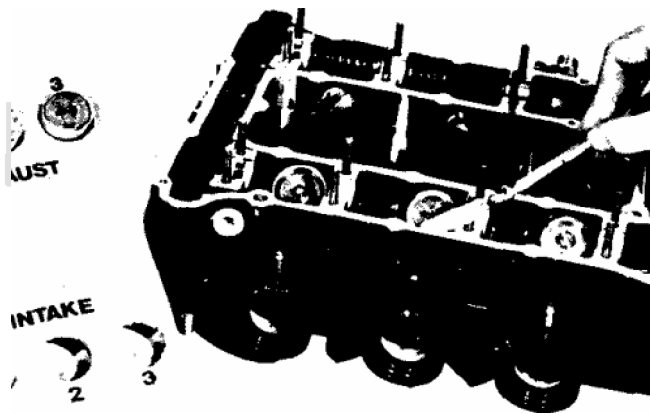
6. Remove two (2) cam chain tensioner securing bolts and remove tensioner assembly.



7. Remove cylinder head oil pipe union bolts and remove oil pipe. Note placement of copper gaskets.

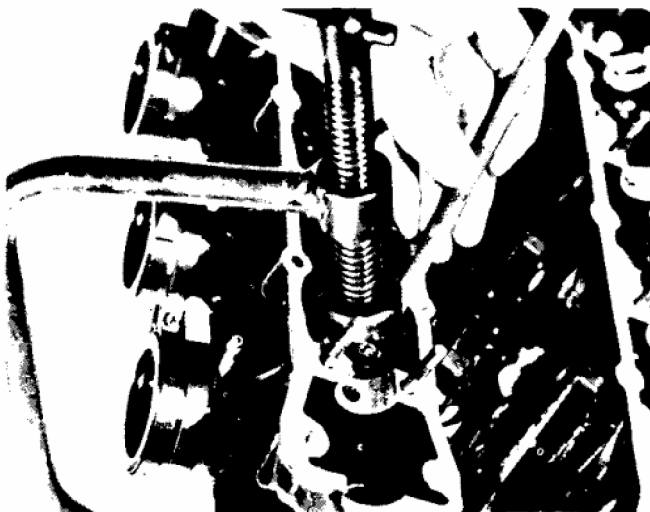


8. Remove spark plugs.
9. Remove cylinder head holding nuts and bolts as follows:
 - a. Loosen each nut and bolt $\frac{1}{2}$ turn, observing the torque sequence.
 - b. Remove the cylinder head holding nuts first.
 - c. Note location of larger washers on two (2) center exhaust studs.



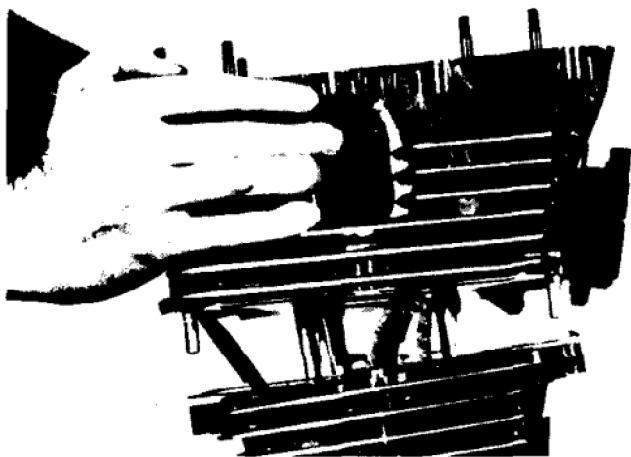
CAUTION: Lifters must always be installed in their original locations.

2. Install the valve spring compressor (special tool). Remove the valve keepers by using a magnet. Remove the retainer and valve springs.



NOTE: The valve springs are progressively wound. The more tightly wound end is placed down against the cylinder head.

10. Remove cylinder head. Remove cylinder. It **may** be necessary to tap each lightly with a soft hammer.



B. Cylinder Head Disassembly

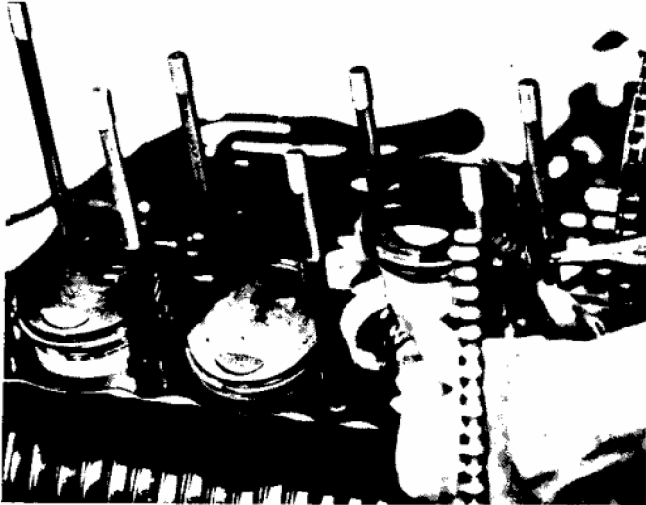
1. Remove valve lifters and pads. Place each lifter in a box that identifies the location of each lifter.

3. Remove valves.

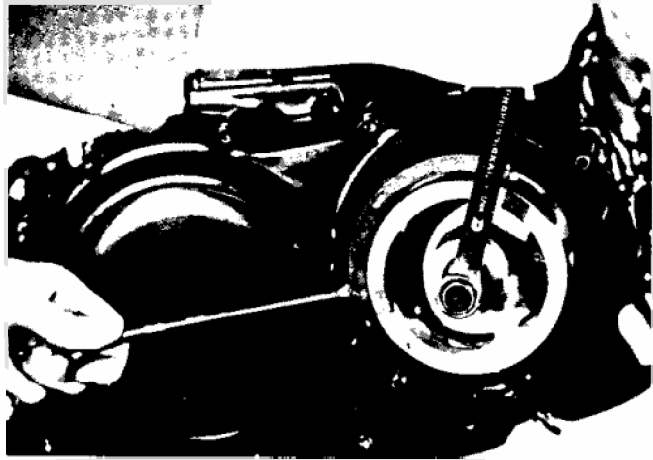
NOTE: Deburr any deformed valve stem end. Use an oil stone to smooth the stem end. This will help prevent damage to the valve guide during valve removal.

C. Piston Removal

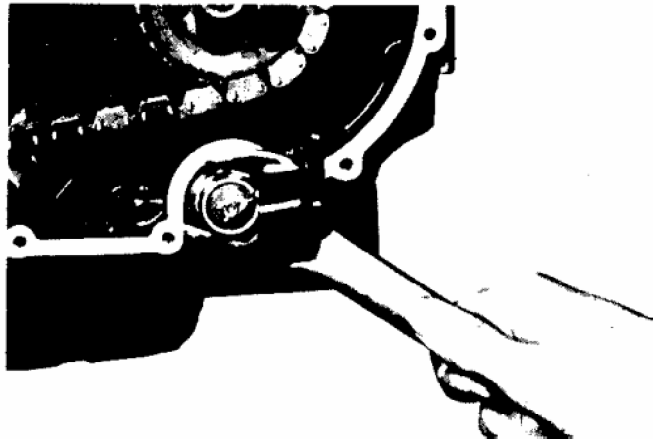
1. Mark each piston to aid in reassembly.
2. Place a clean towel or rag into the crankcase to keep circlips and material from falling into the engine.
3. Remove piston pin clips, piston pins, and pistons.



4. Remove the bolt, plate washer and lock washer from the rotor. Use the rotor holding tool and bolt (special tools) to remove rotor.

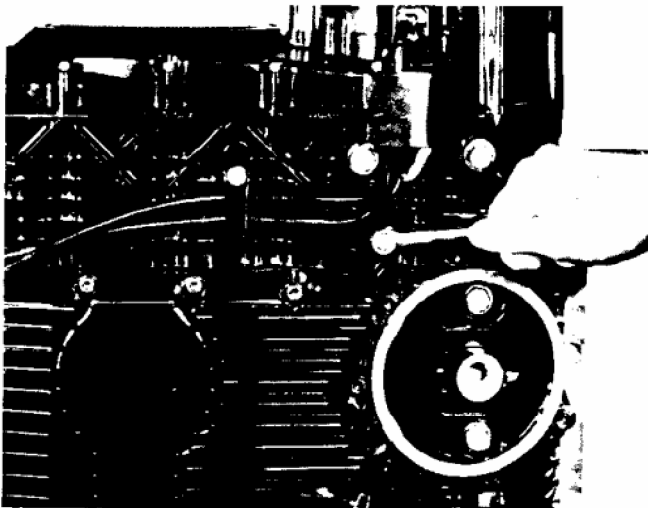


5. Remove the crankcase cover bolts and remove the cover.
6. Remove oil pressure warning switch.



D. Generator

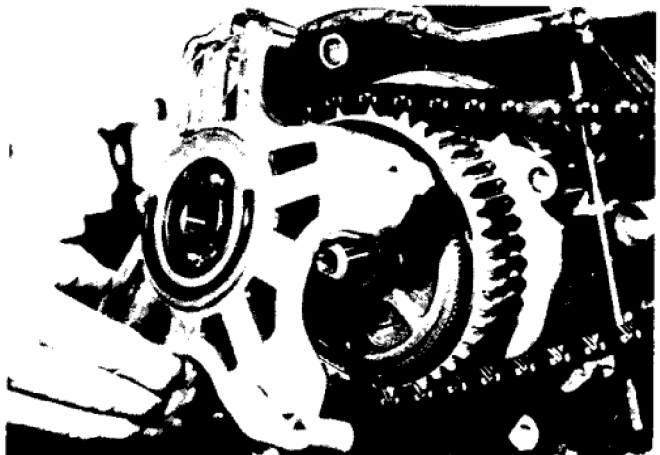
1. Remove generator wiring harness from mounting clips. Remove oil pressure warning switch wire.



2. Remove kick crank
3. Remove generator cover.

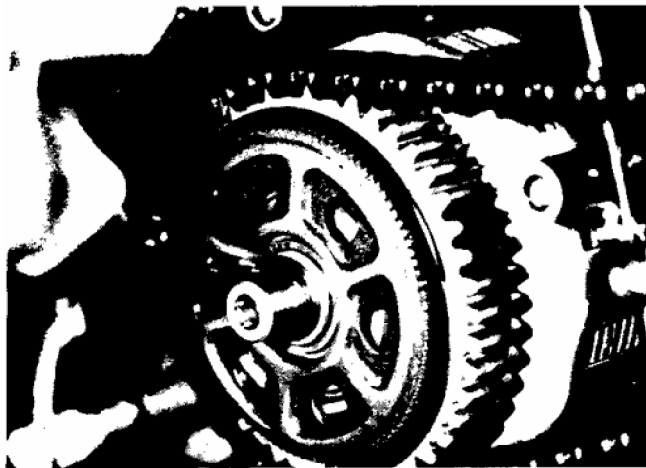
E. Bearing Housing

Remove four (4) bearing housing securing bolts and remove bearing housing.

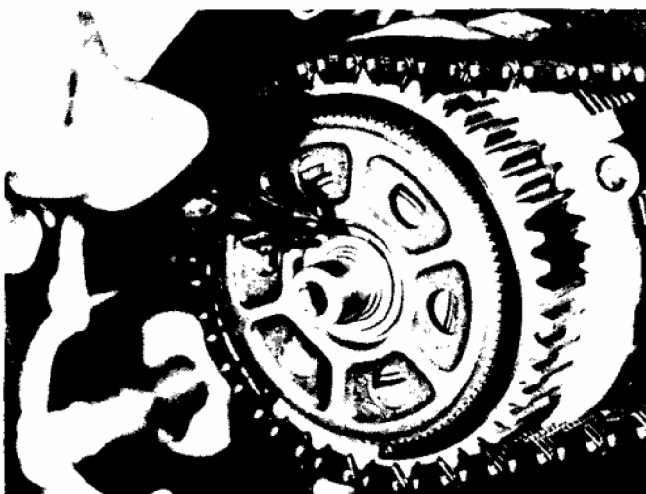


F. Clutch and Primary Driven Gear

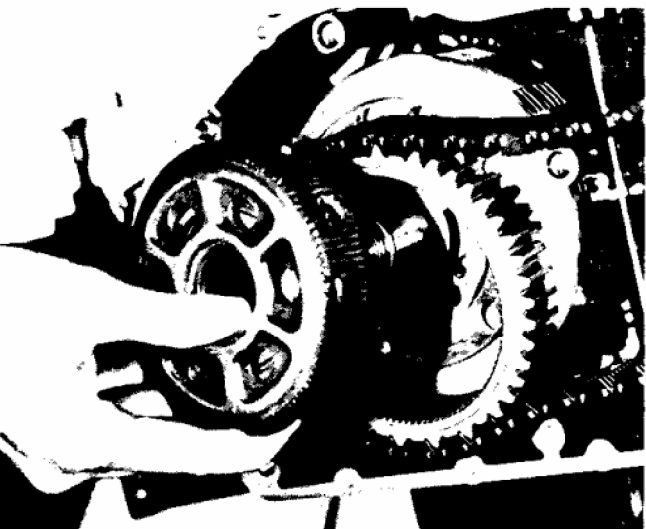
1. Remove small circlip and washer from R.H. end of transmission.



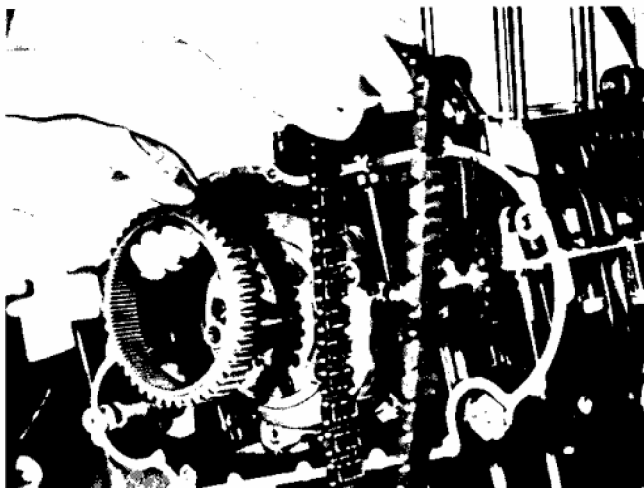
2. Remove larger circlip.



3. Remove clutch damper.

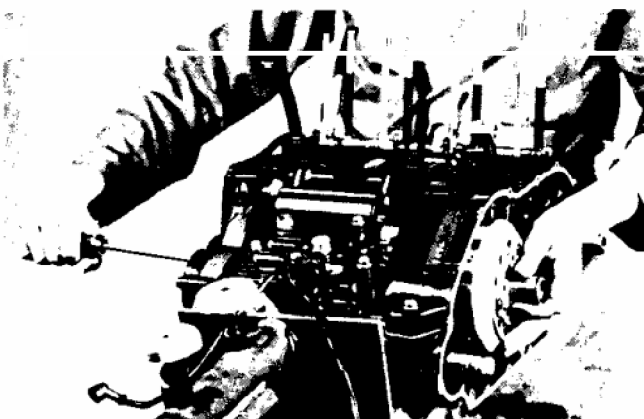


4. Remove primary driven gear and chain.

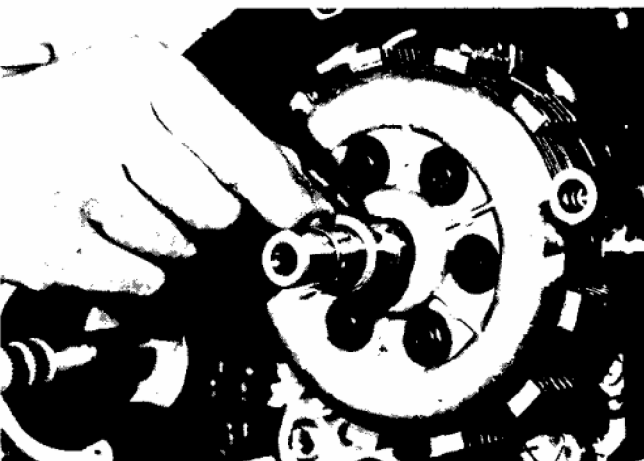


5. Remove clutch housing.

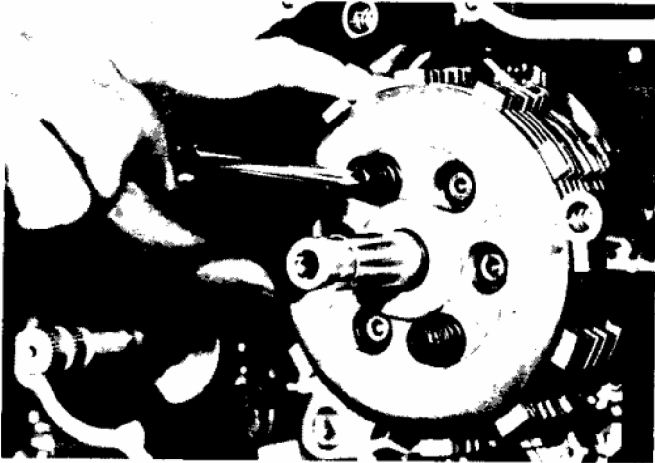
NOTE: If the clutch plates are stuck to the housing, thread in the clutch adjuster screw on the left side of the engine. This will push off the housing.



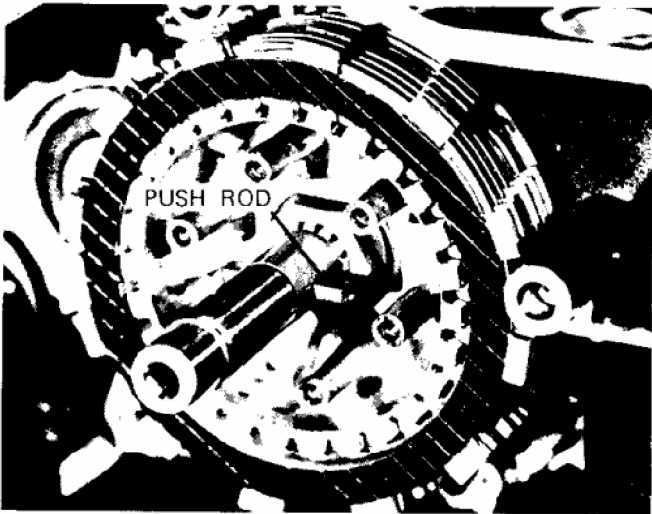
6. Remove washer and circlip in front of pressure plate.



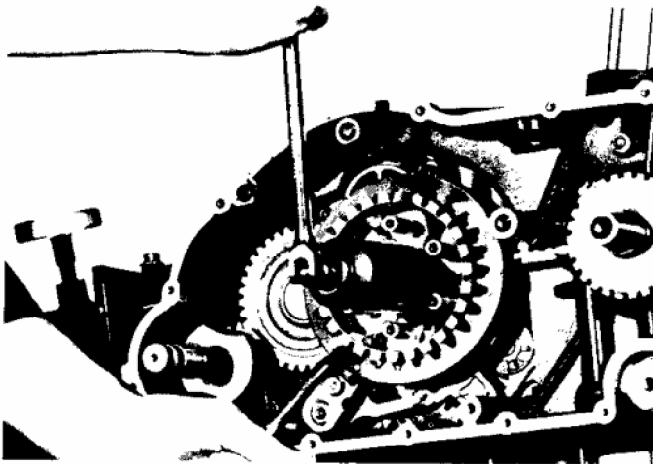
7. Remove pressure plate screws and clutch springs. Remove pressure plate.



8. Remove clutch plates, clutch push rod and ball bearing.

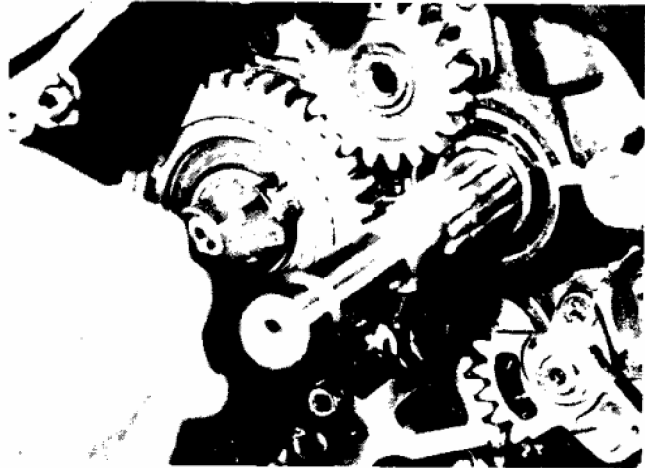


9. Use clutch holding tool (special tool) to hold clutch boss. Use deep 32mm socket to remove clutch boss nut. Remove nut, spring washer, clutch boss, plate washer, and spacer.

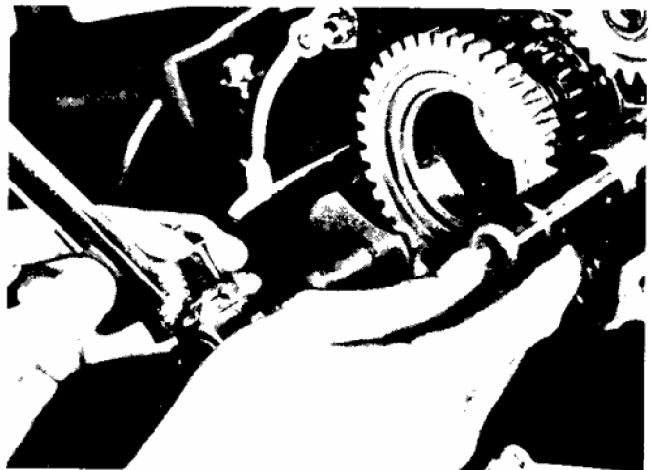


G. Kick Gear Removal

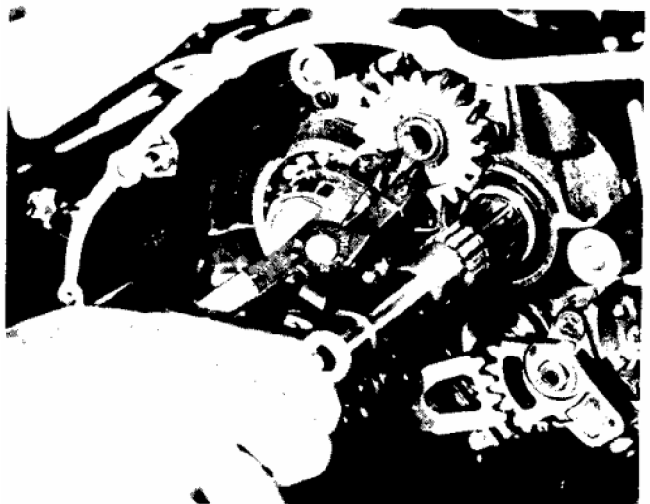
1. Remove circlip holding the kick idlegear.



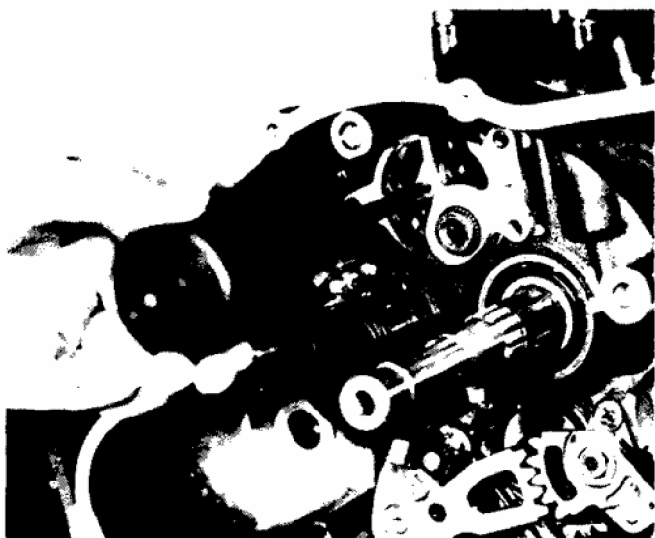
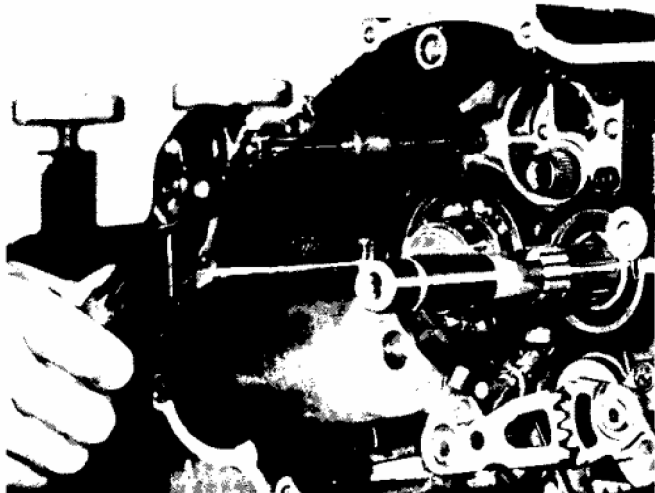
2. Install the kick crank on the kick shaft. Pull the kick starter assembly and the kick idlegear out together. Remove bearing and washer.



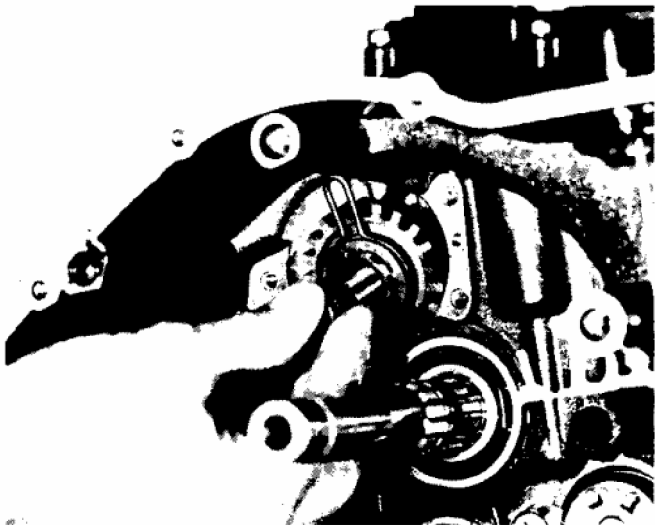
3. Remove the circlip holding kick gear 4. Remove the washer and gear.



4. Remove kick gear holder bolts. Use a slide hammer to remove the holder.



5. Remove the kick shaft assembly.

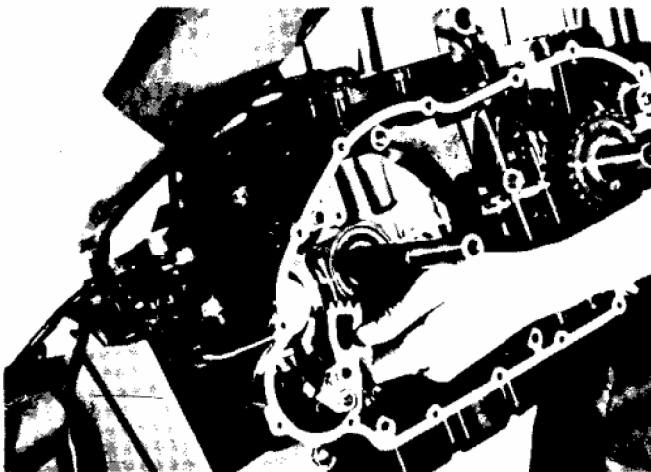


H. Shift Lever, Shift Shaft Removal

1. Remove clip holding shift lever two (2). Remove the lever.

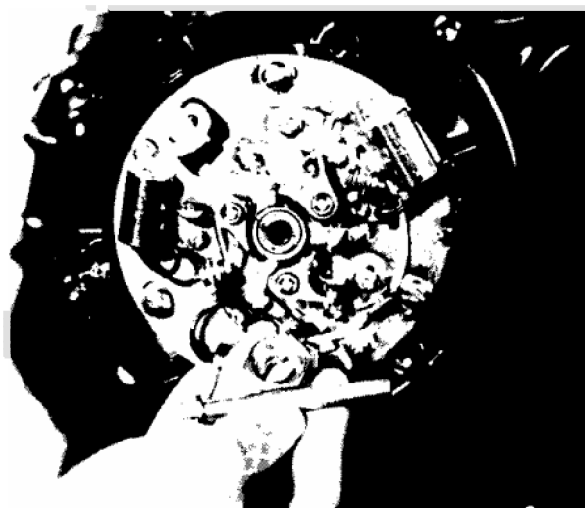


2. Remove clip holding shift shaft lever. Remove shift shaft.

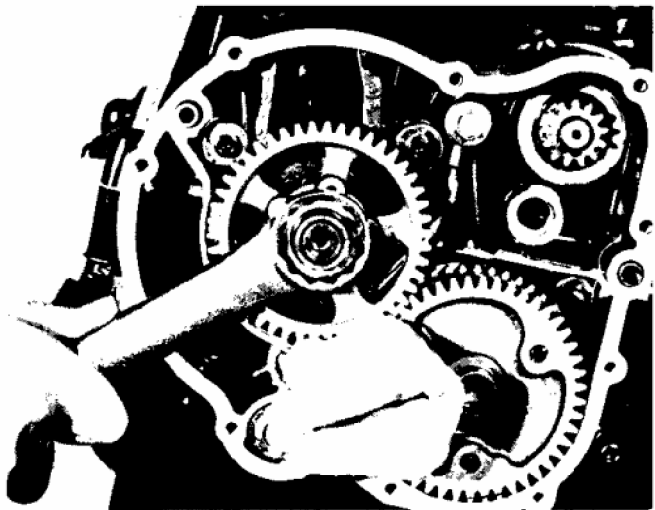
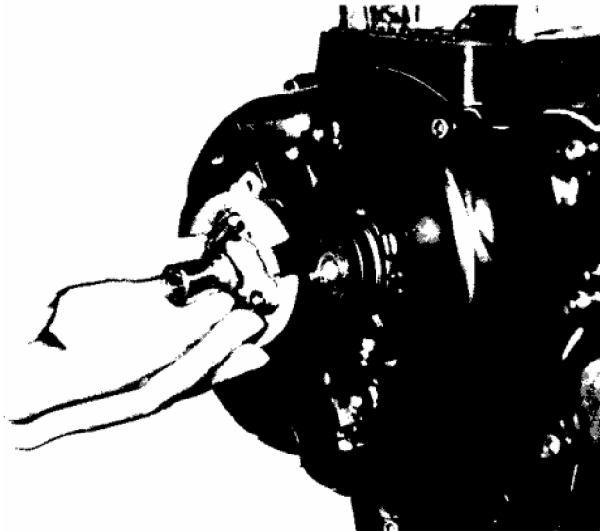


I. Governor Assembly Removal

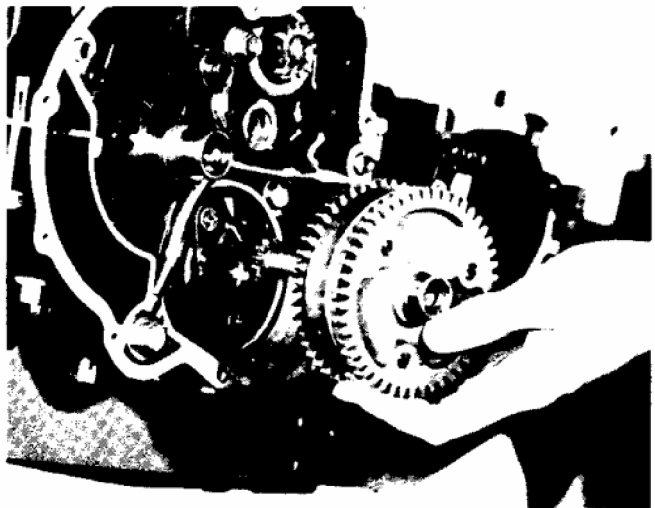
1. Remove bolt holding crankshaft turning nut from L.H. end of crankshaft.



2. Remove neutral light wire. Remove breaker assembly wiring harness from clamps on crankcase. Remove three (3) breaker plate holding screws and remove breaker assembly.
3. Remove governor assembly.



4. Remove starter clutch assembly



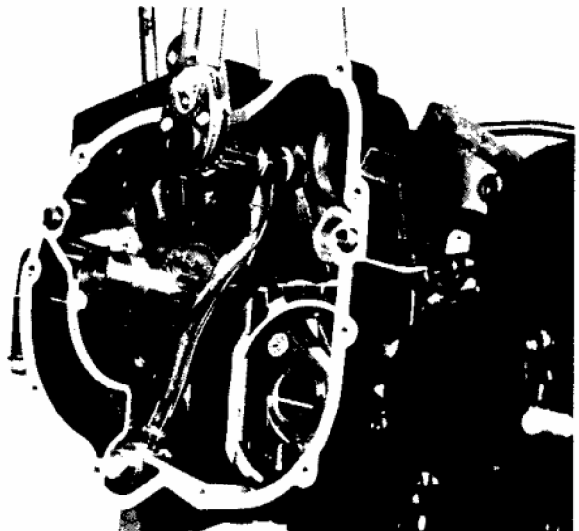
J. Electric Starter Removal

Remove L.H. crankcase cover.

2. Remove idler gear 1 and shaft.

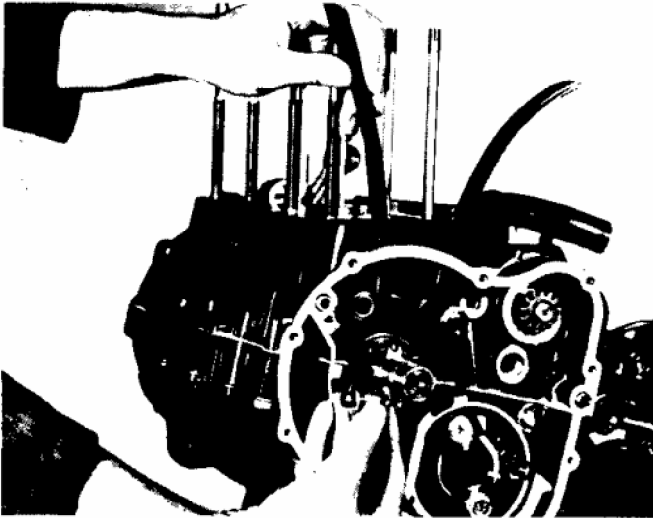


5. Remove oil delivery pipe,

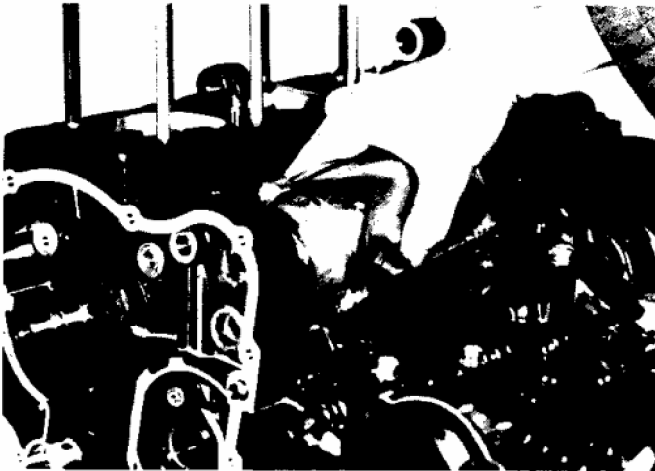


3. Place a folded rag between the kick idler gear two (2) and pump drive gear as shown. Remove pump drive gear nut and gear. Remove cam chain.

6. Remove cam chain dampers.

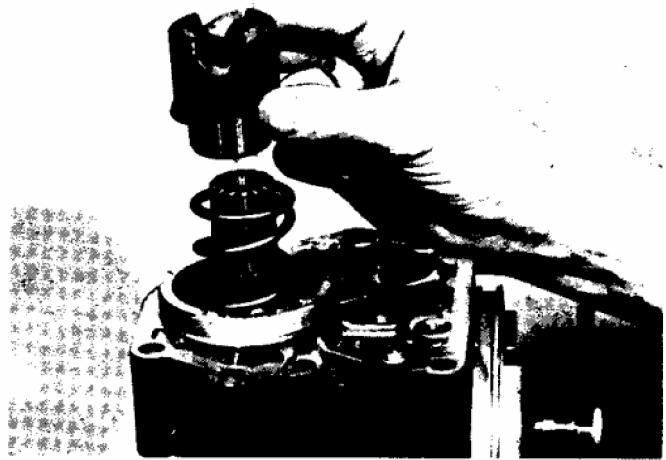
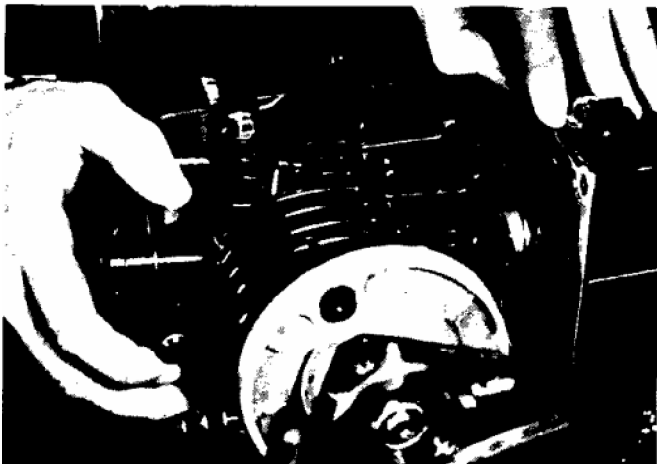


7. Remove two (2) starter motor securing bolts. Remove starter motor.



K. Middle Gear Removal

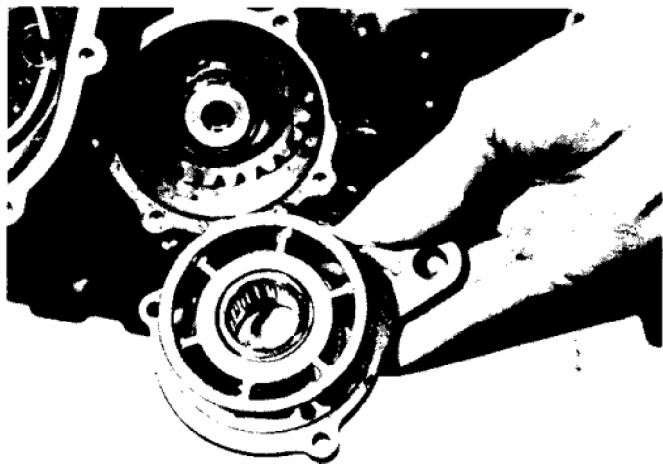
Remove seven (7) middle gear case securing bolts. Remove the middle gear case, drive cam and spring.



Middle Gear Case Disassembly is covered in the Shaft Drive, Section page 102.

L. Transmission Bearing Housing Removal

Remove the transmission bearing housing bolts. Remove housing.



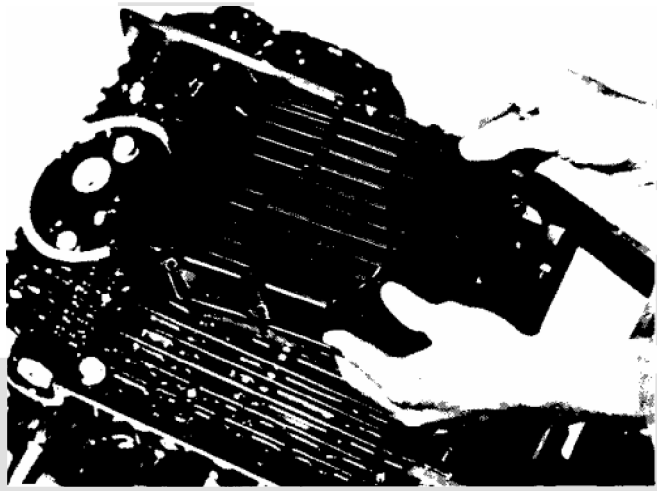
M. Breather Removal

Remove six (6) breather securing bolts. Remove breather.

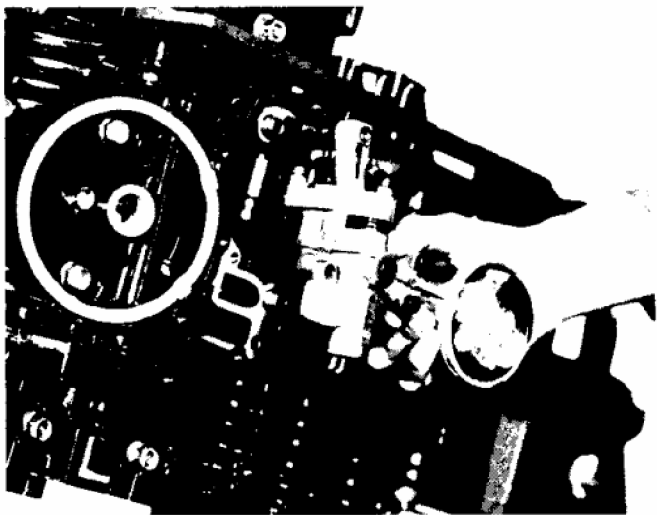


N. Oil Pump Removal and Disassembly

1. Remove strainer cover.



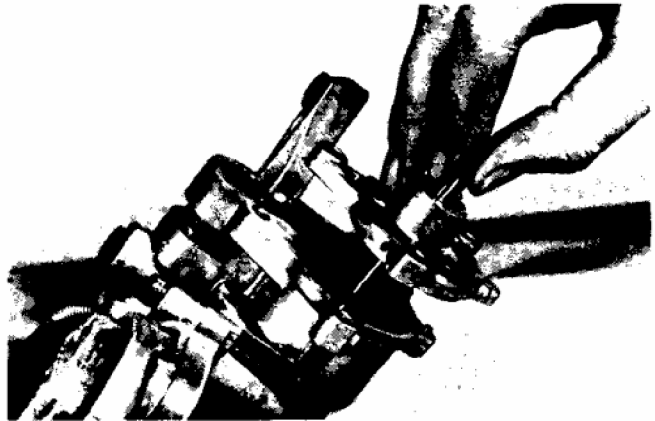
2. Remove oil pump.



3. Remove oil pump driven gear.

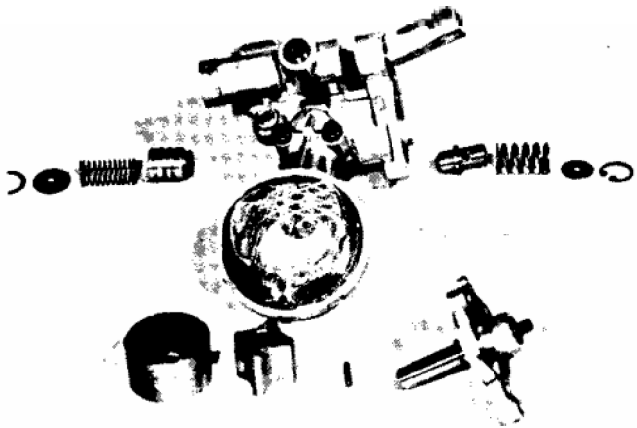


4. Remove oil pump cover and rotor assembly.



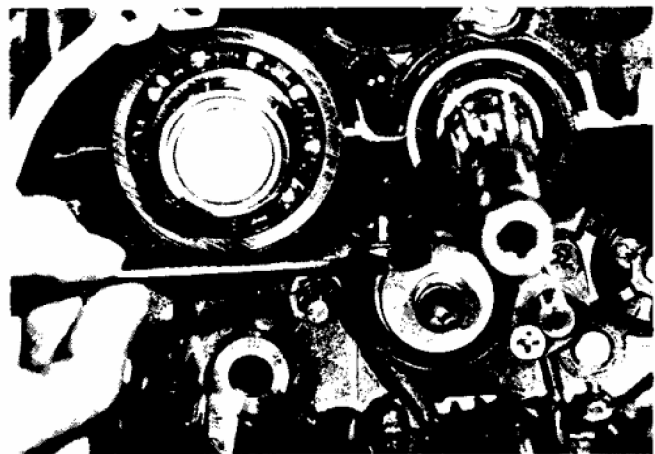
5. Remove pressure relief valve: remove circlip, washer, spring, and plunger.

6. Remove oil pump check valve: remove circlip, plug, spring, and plunger.

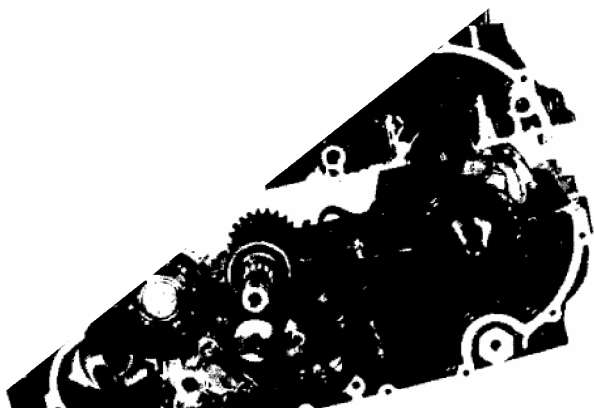


O. Crankcase Disassembly

CAUTION: There is one hidden crankcase holding bolt. This bolt is located near the transmission drive axle, as shown. This bolt must be located before proceeding with crankcase disassembly.



1. Loosen each bolt $\frac{1}{2}$ turn, starting with the unnumbered bolt. Continue by loosening the highest numbered bolts first. The numbers of the bolts are cast in the cases. Numbers 24~15 are on the top case. Numbers 14-1 are on the bottom case.
2. Remove all crankcase holding bolts. Use a soft rubber hammer to carefully separate the crankcases. The crankshaft and transmission shafts should stay in the bottom crankcase.



3. Remove crankshaft. Note location of special main bearing ('A' bearing). This is a combination side thrust bearing and main bearing.

P. Transmission Disassembly

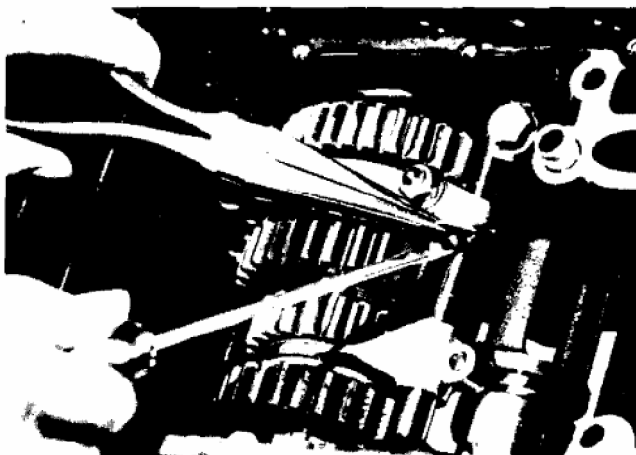
1. Remove middle driven gear.



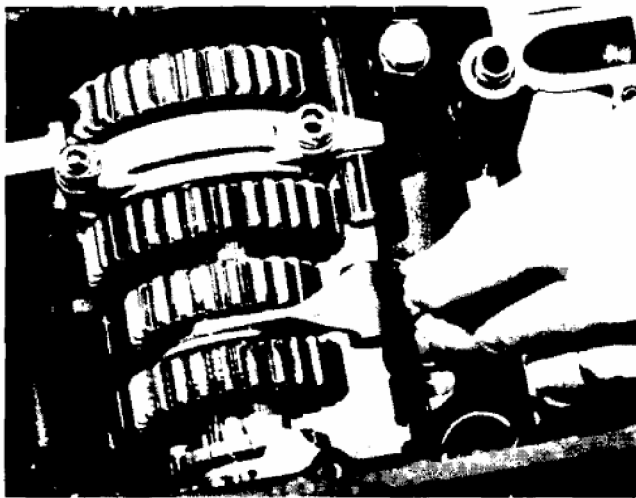
2. Remove shift fork guide bar circlip (E-clip). Remove guide bar.



3. Remove main axle assembly.
4. Remove circlip (E-clip) holding shift fork guide two



5. Remove guide bar, washer and both shift forks.



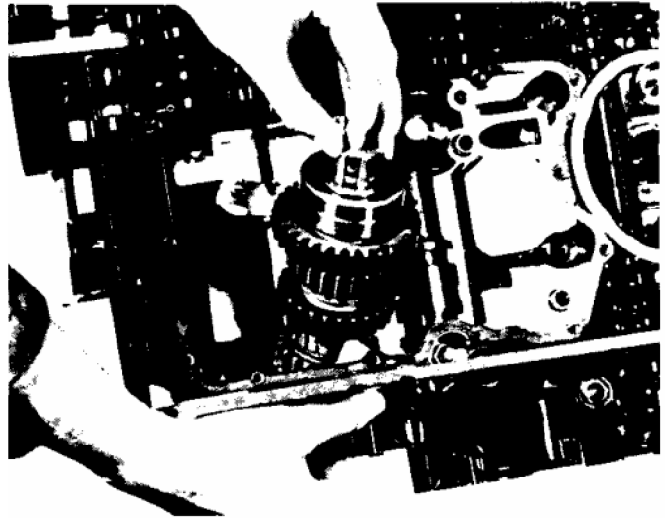
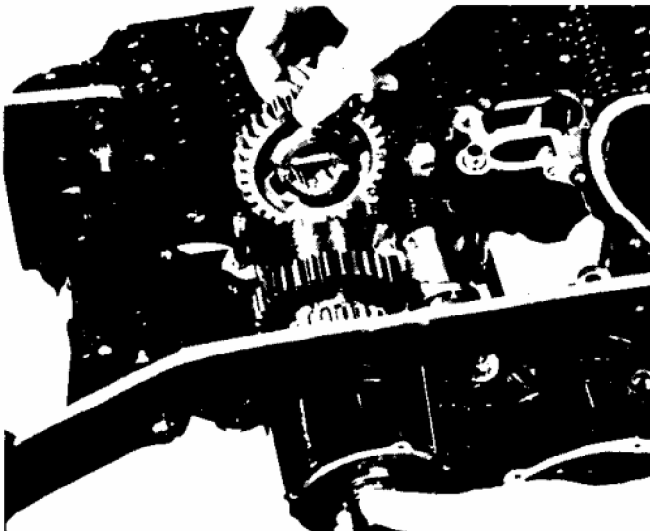
6. Remove bolt holding middle drive gear to drive axle. Remove spacer.



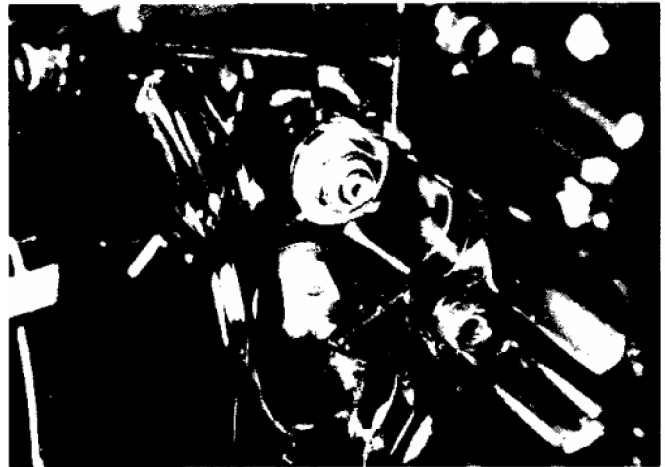
7. Loosen transmission bearing cap nuts $\frac{1}{2}$ turn. Remove nuts and cap.



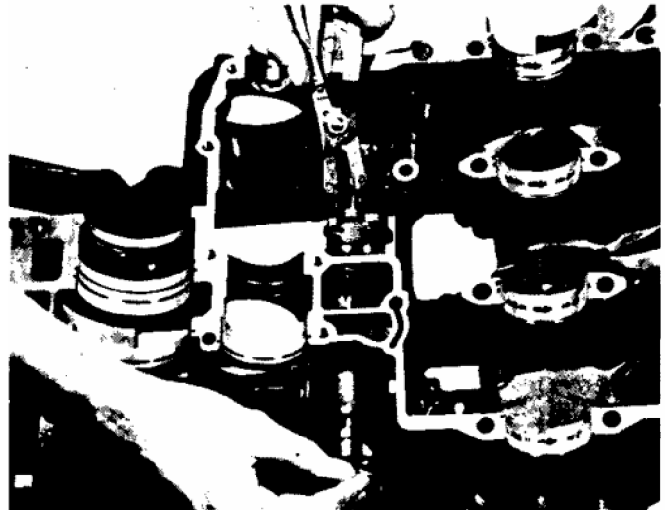
8. Remove middle drive gear. Push drive axle up at the bearing and out so that the middle drive gear can be removed. Remove drive axle.



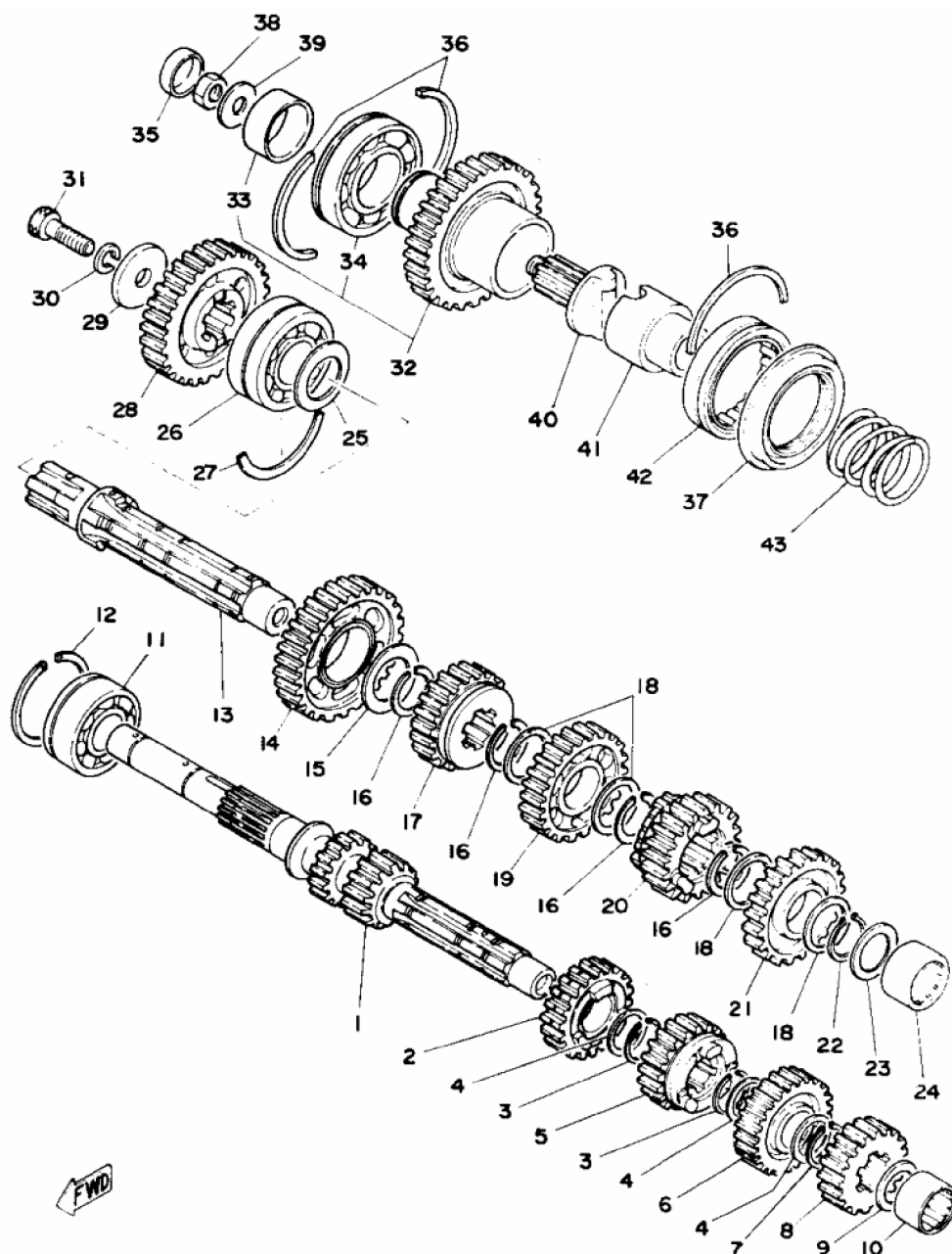
9. Remove shift cam detent and shaft cam securing bolt.



10. Remove circlip on shift cam stopper plate. Remove stopper plate and shift cam.



Further disassembly of the transmission shafts can be undertaken after study of the transmission illustration.



- | | | | | | |
|----|--------------------------------------|----|--------------------------------|----|---------------------------|
| 1 | AXLE, main (13T) | 15 | WASHER, plate (30.2-40-2.0) | 30 | WASHER, spring |
| 2 | GEAR, 4th pinion (21T) | 16 | CIRCLIP | 31 | BOLT, hexagon socket head |
| 3 | CIRCLIP | 17 | GEAR 4th wheel (23T) | 32 | MIDDLE DRIVEN GEAR |
| 4 | WASHER, gear hold 5
(25.2-30-1.0) | 18 | SHIM | 32 | COMP. (34T) |
| 5 | GEAR, 3rd pinion (20T) | 19 | GEAR, 3rd wheel (26T) | 33 | COLLAR (35-40-16) |
| 6 | GEAR, 5th pinion (23T) | 20 | GEAR, 5th wheel (22T) | 34 | BEARING (B6207 special) |
| 7 | CIRCLIP (S-25) | 21 | GEAR, 2nd wheel (27T) | 35 | PLUG |
| 8 | GEAR, 2nd pinion (17T) | 22 | CIRCLIP (S-30) | 36 | CIRCLIP |
| 9 | SHIM, drive axle | 23 | SHIM, drive axle (24.2-33-1.6) | 37 | OIL SEAL (SW-48.8-72-9) |
| 10 | BEARING | 24 | BEARING | 38 | NUT, hexagon |
| 11 | BEARING (B5205 special) | 25 | WASHER, plate (30.2-40-2.0) | 39 | WASHER, plate |
| 12 | CIRCLIP | 26 | BEARING (B5206 special) | 40 | CAM, driven |
| 13 | AXLE, drive | 27 | CIRCLIP | 41 | CAM, drive |
| 14 | GEAR, 1st wheel (32T) | 28 | GEAR, middle drive (32T) | 42 | BEARING |
| | | 29 | WASHER, plate | 43 | SPRING, compression |



- | | | | | | |
|----|------------------------|----|---------------------------|----|-------------------------|
| 1 | CAM, shift | 11 | SPRING, compression | 21 | BAR, shift fork guide 2 |
| 2 | PIN, dowel (4-8) | 12 | GASKET, drain plug | 22 | FORK, shift 1 |
| 3 | PIN, dowel (4-17.8) | 13 | SCREW | 23 | SHAFT, shift lever |
| 4 | BEARING | 14 | BOLT | 24 | SCREW, flat head |
| 5 | CIRCLIP (34 ø special) | 15 | WASHER, lock | 25 | LEVER, shift 2 |
| 6 | PLATE, side | 16 | BAR, shift fork guide 1 | 26 | CIRCLIP (E-9) |
| 7 | SCREW, flat head | 17 | FORK, shift 2 | 27 | SPRING, torsion |
| 8 | PLATE, stopper | 18 | PIN, cam follower | 28 | LEVER, shift 3 |
| 9 | CIRCLIP (S-30) | 19 | WASHER, plate (12-22-1.0) | 29 | CIRCLIP (E-7) |
| 10 | STOPPER, cam | 20 | CIRCLIP (E-10) | | |

3-3 INSPECTION AND REPAIR

A. Cylinder Head Cover

Place head cover on a surface plate. There should be no warpage. Correct by re-surfacing as follows:

Place #400 or #600 grit wet sandpaper on surface plate and re-surface head cover using a figure-eight sanding pattern. Rotate head cover several times to avoid removing too much material from one side.

B. Cylinder Head

1. Remove spark plugs.
2. Remove valves.
3. Using a rounded scraper, remove carbon deposits from combustion chamber. Take care to avoid damaging spark plug threads and valve seats. Do not **use** a sharp instrument. Avoid scratching the aluminum.
4. Place on a surface plate. There should be no warpage. Correct by re-surfacing as follows:

Place #400 or #600 grit wet sandpaper on surface plate and re-surface head using a figure-eight sanding pattern. Rotate head several times to avoid removing too much material from one side.

C. Valve, Valve Guide and Valve Seat

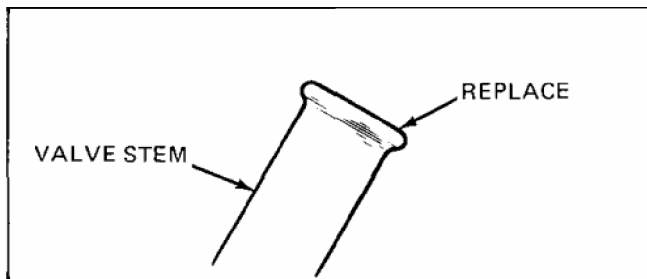
1. Valve stem wear must be measured and then combined with valve guide measurements to guide clearance. This clearance must be within tolerances. If it exceeds the maximum limit, then replace either or both valve and guide, as necessary.



Valve Stem Clearance		Maximum
Intake	.020-.041mm (.0008~.0016")	0.10mm (.004")
Exhaust	.035-.059mm (.0014~.0023")	0.12mm (.005")

2. Valve stem end

Inspect end of valve stem. If the end appears to be "mushroomed" or has a larger diameter than the rest of the stem, the valve, valve guide, and oil seal should be replaced.



3. Turn valve on a "V" block and measure the amount of stem runout with a dial gauge. If it exceeds the maximum limit, replace the valve.

Maximum Valve Stem Runout:
.03mm (.0012")

4. Valve guide and valve oil seal replacement

If oil leaks into the cylinder through a valve due to a worn valve guide, or if a valve is replaced, the valve guide should also be replaced.

NOTE: The valve oil seal should be replaced whenever a valve is removed or replaced.

- a. Measure valve guide inside diameter with a small bore gauge. If it exceeds the limit, replace with an oversize valve guide.

Guide diameter (I.D.): 7.01-7.02mm 7.10mm
(.276-.277") (0.280")

- b. To ease guide removal and reinstallation, and to maintain the correct interference fit, heat the head to 100°C (212°F). Use an oven to avoid any possibility of head warpage due to uneven heating.
- c. Use the appropriate shouldered punch (special tool) to drive the old guide out and drive the new guide in.

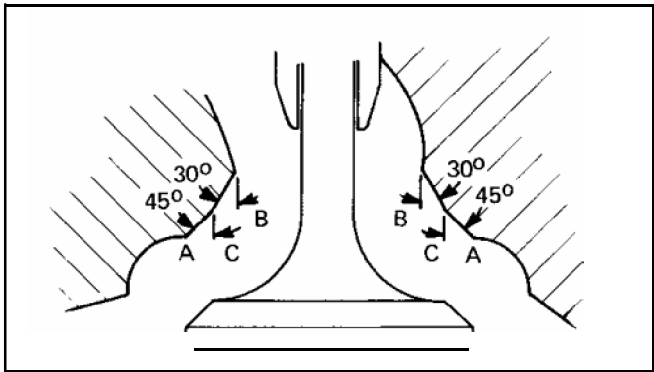
NOTE: When a valve guide **is** replaced, the o-ring should also be replaced.

- d. After installing the valve guide, use 7mm reamer (special tool) to obtain the proper valve clearance.

After fitting the valve guide into the cylinder head, be sure to grind the valve seat, and perform valve lapping. The valve must be replaced with a new one.

5. Grinding the valve seat

- a. The valve seat is subject to severe wear similar to valve face. Whenever the valve face is re-surfaced, the valve seat should also be re-surfaced at a 45° angle. In addition, if a new valve guide has been installed (without any valve repair), the valve seat should be checked to guarantee complete sealing between the valve face and seat.



CAUTION: If the valve seat is obviously pitted or worn, it should be cleaned with a valve seat cutter. Use the 45° cutter, and when twisting the cutter, keep an even downward pressure to prevent chatter marks.

If cutting section "A" of the intake valve seat, use "FLAT" cutter (radius cutter). If cutting section "A" of the exhaust valve seat, use "FLAT" cutter (also: radiused). If cutting section "B", use the 45° cutter.

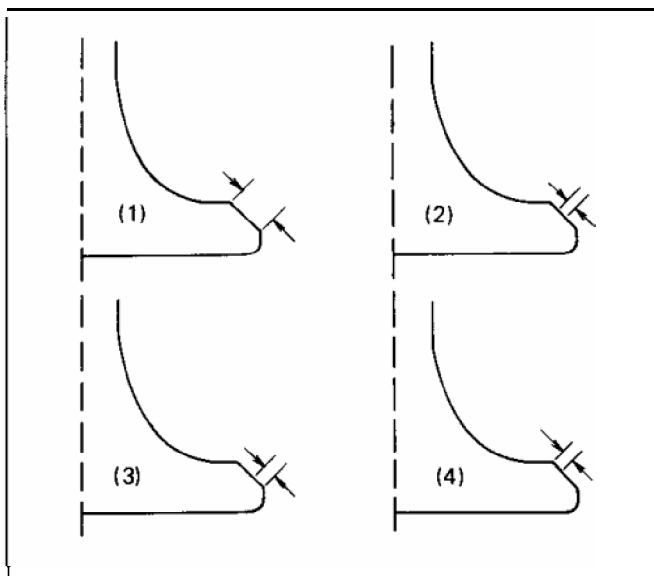
- b. Measure valve seat width. Apply mechanic's bluing dye (such as Dykem) to the valve face, apply a very small amount of fine grinding compound around the surface of the valve seat, insert the valve into position, and spin the valve quickly back and forth. Lift the valve, clean off all grinding compound, and check valve seat width. The valve seat will have removed the bluing wherever it contacted the valve face. Measure the seat width with vernier calipers. It should measure approximately 1.3mm (.05"). Also, the seat should be uniform in contact area. If valve seat width varies, or if

pits still exist, then continue to cut with the 45° cutter. Remove just enough material to achieve a satisfactory seat.

	Standard Width	Wear Limit
Seat width	1.3mm (.050")	2.0mm (.080)

- c. If the valve seat is uniform around the perimeter of the valve face, but is too wide or not centered on the valve face, it must be altered. Use either the "FLAT", 45° or 30° cutters to correct the improper seat location in the manner described below:

- 1) If the valve face shows that the valve seat is centered on the valve face, but too wide, then lightly use both the "FLAT" and the 30° cutters to reduce the seat width to 1.3mm (.05").
- 2) If the seat shows to be in the middle of the valve face, but too narrow, use the 45° cutter until the width equals 1.3mm (.05").
- 3) If the seat is too narrow and right up near the valve margin, then first use the "FLAT" cutter and then the 45° cutter to get the correct seat width.
- 4) If the seat is too narrow and down near the bottom edge of the valve face, then first use the 30° cutter and then the 45° cutter.



6. Lapping the valve/valve seat assembly

- a. The valve/valve seat assembly should be lapped if (1) neither the seat nor the valve face are severely worn, or (2) if the valve face and valve

seat have been re-surfaced and now require a final light grinding operation for perfect sealing.

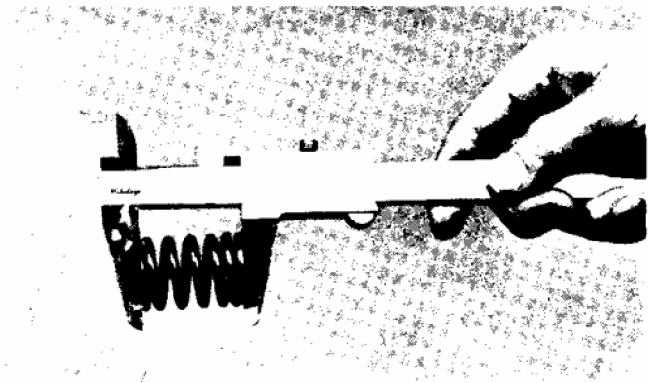
- b. Apply a small amount of coarse lapping compound to valve face. Insert the valve into the head. Rotate the valve until the valve and valve seat are evenly polished. Clean off the coarse compound, then follow the same procedure with fine compound,

Continue lapping until the valve face shows a complete and smooth surface all the way around. Clean off the compound material. Apply bluing dye to the valve face and rotate the valve face for full seat contact which is indicated by a shiny surface all around the valve face where the bluing has been rubbed away.

c. Valve leakage check

After all work has been performed on the valve and valve seat, and all head parts have been assembled, check for proper valve/valve seat sealing by pouring solvent into each of the intake ports, then the exhaust ports. There should be no leakage past the seat. If fluid leaks, disassemble and continue to lap with fine lapping compound. Clean all parts thoroughly, reassemble and check again with solvent. Repeat this procedure as often as necessary to obtain a satisfactory seal.

measure spring free length. If the free length of any spring has decreased more than 2mm (.080") from its specification, replace it.



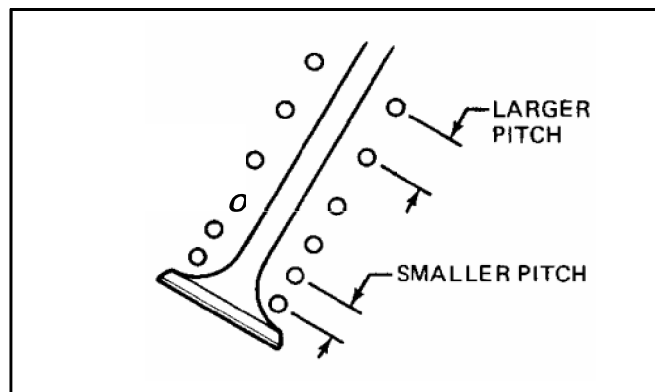
- c. Another symptom of a fatigued spring is insufficient spring pressure when compressed. This can be checked using a valve spring compression rate gauge. Test each spring individually. Place it in the gauge and compress the spring first to the specified compressed length with the valve closed (all spring specifications can be found in the previous section, Valve Spring), then to the length with the valve open. Note the poundage indicated on the scale at each setting. Use this procedure with the outer springs, then the inner springs.

NOTE: All valve springs must be installed with greater pitch upward as shown.

D. Valve Spring and Lifters

1. Checking the valve springs

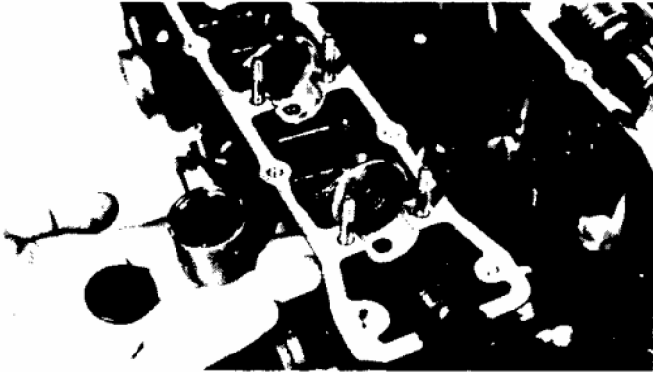
- a. This engine uses two springs of different sizes to prevent valve float or surging. The chart below shows the basic valve characteristics.
- b. Even though the spring is constructed of durable spring steel, it gradually loses some of its tension. This is evidenced by a gradual shortening of free length. Use a vernier caliper to



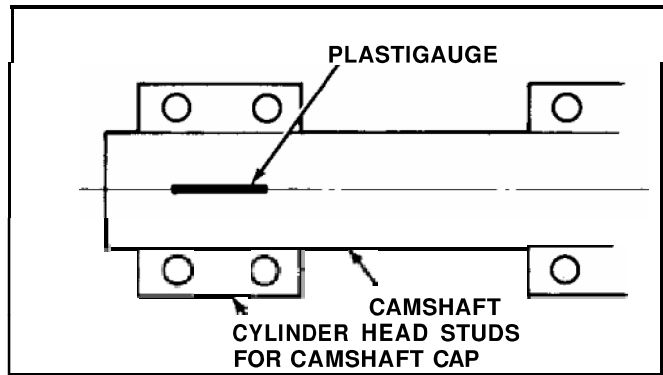
	OUTER	INNER
Free length	39.9mm (1.571")	35.6mm (1.402")
Installed length (valve closed)	34.5mm (1.358")	31.5mm (1.240")
Installed pressure	16.27~18.73 kg (35.9~41.3 lb)	6.75~8.25 kg (14.9~18.2 lb)
Compressed length (valve open)	26.0mm (1.024")	23.0mm (.908")
Compressed pressure	49.29~56.71 kg (108.7~125 lb)	25.57~29.43 kg. (56.4~64.9 lb)
Allowable tilt from vertical	1.6mm (.063") or 2.5°	

2. Valve lifter

- a. Check each valve lifter for scratches or other damage. If the lifter is damaged in any way, the cylinder head surface in which it rides is probably also damaged. If the damage is severe, it may be necessary to replace both the lifter and the cylinder head.



NOTE: For proper valve lifter-to-head clearance, always install lifters on their original valves.



Cap Nut Tightening Torque:

0.8~1.0 m·kg (5.8~7.2 ft·lbs)

NOTE: Do not turn camshaft when measuring clearance with Plastigauge.

Camshaft-to-cap Clearance:

Standard: .020~.054mm (.0008~.0021")

Maximum: 0.160mm (.006")

E. Camshafts, Cam Chain and Cam Sprockets

1. Camshaft

- a. The cam lobe metal surface may have a blue discoloration due to excessive friction. The metal surface could also start to flake off or become pitted.

NOTE: The exhaust cam appears darker than the intake cam. This is due to a special hardening process and is not due to excessive engine heat.

- b. If any of the above wear conditions are readily visible, the camshaft should be replaced.
- c. Even though the cam lobe surface appears to be in satisfactory condition, the lobes should be measured with a micrometer. Cam lobe wear can occur without scarring the surface. If this wear exceeds a pre-determined amount, valve timing and lift are affected. Replace the camshaft if wear exceeds the limits.
- d. Install the camshaft on the cylinder head. Place a strip of Plastigauge between camshaft and camshaft cap as illustrated (lengthwise along camshaft). Tighten the nuts with specified torque. Remove the camshaft cap and determine the clearance by measuring the width of the flattened Plastigauge.

If camshaft-to-cap clearance exceeds specification, measure camshaft bearing surface diameter.

Bearing Surface Diameter:

Standard: 24.97~24.98mm (0.9830~0.9835")

1) If camshaft diameter is less than specification, causing excessive clearance, replace camshaft.

2) If camshaft is within specification and camshaft-to-cap clearance is excessive, replace cylinder head.

2. Cam Chain

Except in cases of oil starvation, the cam chain wears very little. If the cam chain has stretched excessively and it is difficult to keep the proper cam chain tension, the chain should be replaced.

3. Cam Sprockets

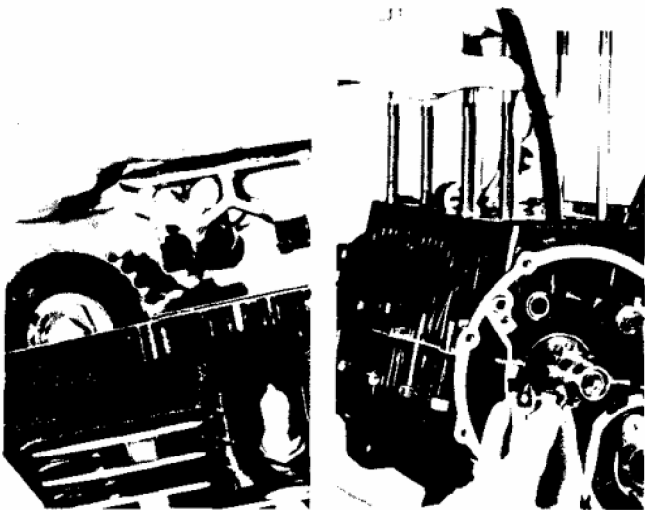
Check cam sprockets for obvious wear. Examine damping rubber on sides of cam sprockets. If the damping rubber is disintegrating, the sprocket should be replaced. Damaged

or disintegrating damping rubber will contaminate the engine oil and will lead to excessive engine noise.



4. Cam Chain Dampers

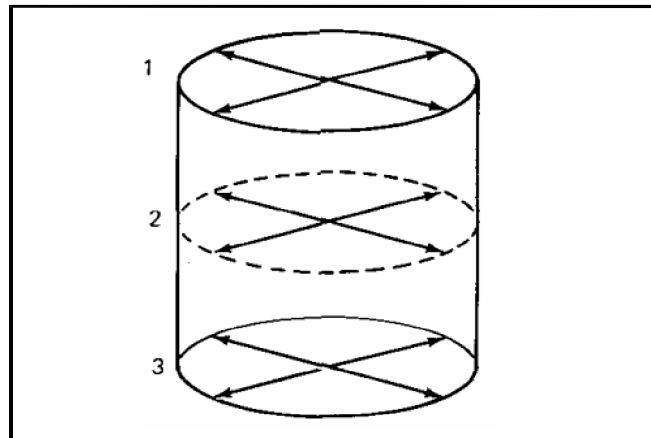
Inspect the top cam chain damper (stopper guide) and two (2) vertical (slipper-type) dampers for excessive wear. Any that shows excessive wear should be replaced. Worn dampers may indicate an improperly adjusted or worn-out cam chain.



F. Cylinder

1. Inspect the cylinder walls for scratches. If vertical scratches are evident, the cylinder wall should be rebored or the cylinder should be replaced.
2. Measure cylinder wall wear as shown. If wear is excessive, compression pressure will decrease. Rebore the cylinder wall and replace the piston and piston rings.

Cylinder wear should be measured at three depths with a cylinder bore gauge. (See illustration.)



	Standard	Wear Limit
Cylinder bore	68.00~68.02mm (2.677~2.678 in.)	68.10mm (2.681 in.)
Cylinder taper	-----	0.05mm (0.002 in.)
Cylinder out-of-round	-----	0.05mm (0.002 in.)

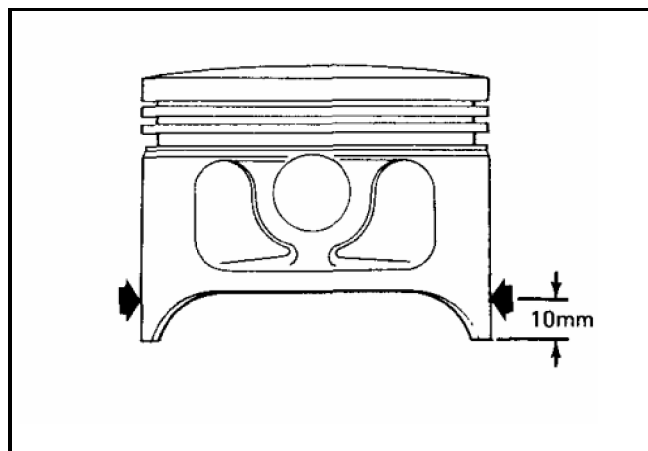
If the cylinder wall is worn more than wear limit, it should be rebored.

G. Piston And Piston Rings

1. Piston

- a. Measure the outside diameter of the piston at the piston skirt.

Measurement should be made at a point 10mm (in.) above the bottom edge of the piston. Place the micrometer at right angles to the piston pin.



	Size
Standard	67.96mm 67.97mm
Oversize 1	68.25mm
Oversize 2	68.50mm
Oversize 3	68.75mm
Oversize 4	69.00mm

b. Determine piston clearance as follows:

Minimum bore measurement – <u>Maximum Piston measurement</u> = Piston clearance

EXAMPLE:

$$\begin{array}{r}
68.02\text{mm} \\
- \underline{67.97\text{mm}} \\
= .05\text{mm piston clearance}
\end{array}$$

c. Piston ring/ring groove fit must have correct clearance. If the piston and ring have already been used, the ring must be removed and the ring groove cleaned of carbon. The rings should then be reinstalled. Use a feeler gauge to measure the gap between the ring and the land.

Side clearance	Top	0.04-0.08mm (0.0016—0.003 in.)
	2nd	0.03-0.07mm (0.0012—0.0028 in.)

2. Piston Ring

a. The oversize top and middle ring sizes are stamped on top of the ring.

Oversize 1	0.25mm
Oversize 2	0.50mm
Oversize 3	0.75mm
Oversize 4	1.00mm

b. The expander spacer of the bottom ring (oil control ring) is color-coded to identify sizes.

The color mark is painted on the expander spacer.

Size	Color
Oversize 1	Brown
Oversize 2	Blue
Oversize 3	Black
Oversize 4	Yellow

c. Push the ring into the bore and check end gap clearance with a feeler gauge.

NOTE: The end gap on the expander spacer of the oil control ring is unmeasurable. If the oil control ring rails show excessive gap, all three components should be replaced.

	Standard	Limit
Top/2nd ring	0.2~0.4mm (.008~.016 in.)	0.80mm (0.03 in.)
Oil control (Rails)	0.2~0.9mm (0.008~0.035 in.)	Visual inspection

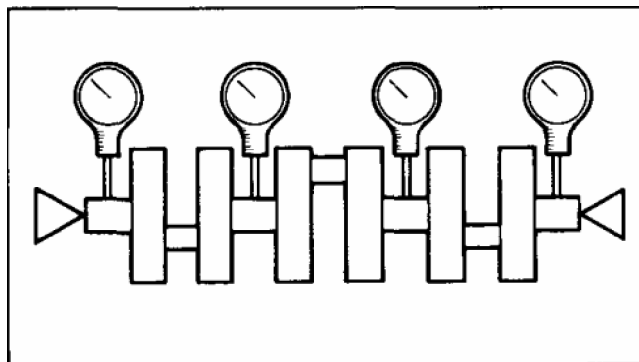
H. Piston Pin

1. Apply a light film of oil to pin. Install in connecting rod small end. Check for play. There should be no noticeable vertical play. If play exists, check connecting rod small end for wear. Replace pin and connecting rod as required.
2. The piston pin should have no noticeable free play in piston. If the piston pin is loose, replace the pin and/or the piston.

I. Crankshaft

1. Crankshaft Run-Out

Support the crankshaft at both ends on V-blocks. Measure the amount of crankshaft run-out on the main bearing journals with a dial gauge while rotating crankshaft.



Run-out limit: .03mm (.001 in.)

If run-out exceeds limit, replace crank.

2. Inspection Of Inserts

Check the bearing inserts. If the inner or outer surface is burned, flaked, rough, scratched or worn, the insert should be replaced.

3. Measuring Main Bearing Oil Clearance

- Clean all crankshaft and crankcase journal surfaces.
- Place upper crankcase half upside-down on a bench. Install bearing inserts into top crankcase.
- Install crankshaft into upper crankcase.
- Place Plastigauge on crankshaft journal surface to be inspected.

NOTE: Do not move crankshaft until clearance check has been completed.

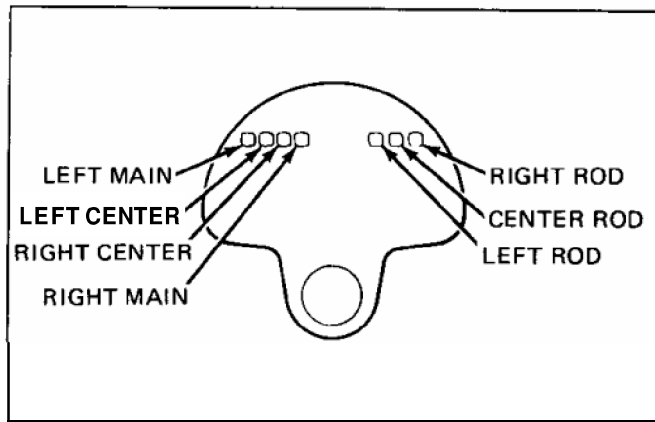
- Install bearing inserts into bottom crankcase. Carefully, place lower crankcase onto upper crankcase.
- Install crankcase holding bolts 1 through 10. Tighten to full torque in torque sequence cast on crankcase.
- Remove bolts in reverse assembly order (10,9,8.. .etc.)
- Carefully remove lower crankcase. Measure width of Plastigauge on crankshaft journals to determine clearance.

Main bearing oil clearance:

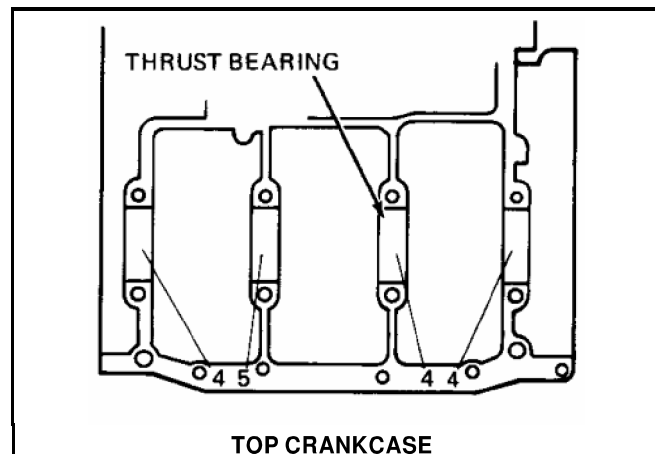
.022~.044mm
(.0008~.0017 in.)

4. Crankshaft Main Bearing Selection

- Numbers used to indicate crankshaft journal sizes are stamped on the L.H. crank web. The first four (4) are main bearing journal numbers, starting with the left journal and proceeding to left center, right center, and right. The three (3) rod bearing journal numbers follow in the same sequence.



- Each main bearing journal is numbered 1, 2 or 3. Each crankcase bearing housing is numbered 4, 5 or 6. The proper insert selection is made by subtracting the crankcase number from the crankshaft journal number. The result is the insert size (number).



Use the color code table to choose the proper insert.

INSERT COLOR CODE

No. 1	Blue
No. 2	Black
No. 3	Brown
No. 4	Green
No. 5	Yellow

EXAMPLE:

Case No. (Minus) Journal No. = Insert No.

4 - 2

No. 2 insert is Black. Use a black main bearing insert.

NOTE: There is a special thrust bearing (insert) located in the No. 3 main bearing housing in the upper crankcase. The function of this insert is to provide a bearing surface for crankshaft side thrust.

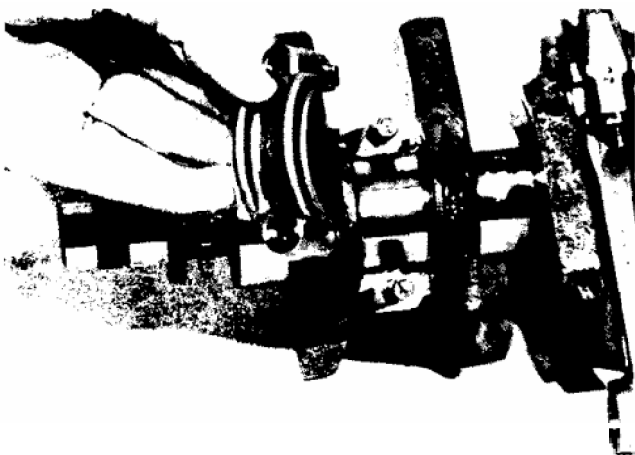
- c. When assembling, apply a liberal coat of motor oil to all bearing surfaces.
- d. Observe normal crankcase holding bolt torque sequence.

J. Connecting Rod

1. Remove rod cap securing nuts, rod cap and inserts.
2. Inspection
 - a. Examine bearing inserts for scratches, flaking or other obvious signs of wear or damage. If the inner or outer surfaces are worn or damaged, the inserts should be replaced.
 - b. Examine the connecting rods and crankshaft.
3. Measure Rod Bearing Clearance

Measurement of rod bearing clearance is similar to main bearing clearance measurement.

- a. Clean all bearing surfaces.
- b. Place a piece of Plastigauge on connecting rod cap. Place cap on crankshaft journal. Do not allow the cap to move. Install special bolts and apply molybdenum grease to the threads. Install rod cap and nuts. Tighten rod caps evenly to specified torque:



Rod cap torque: 3.8 kg-m (27 ft-lbs)

- c. Remove connecting rod and cap. Measure width of Plastigauge to determine oil clearance.

Oil clearance (rod):
.032~.054mm (.001~.002 in.)

- d. Remove Plastigauge from bearing surfaces.

4. Selecting Rod Bearing Inserts

- a. Connecting rod size numbers are indicated by 4, 5 or 6 and are marked in ink on the connecting rods and caps.



- b. The rod bearing journal size numbers are indicated by 1, 2 or 3 and are stamped on the left end of the crankshaft,



- c. The proper insert selection is made by subtracting the rod size number from the crankshaft journal number. Use the color code to choose the proper insert.

Rod No. (Minus) Journal No. = Insert No.

5 - 2 = 3

No. 3 insert is Brown. Use brown bearing inserts.

EXAMPLE:

INSERT COLOR CODE

No. 1	Blue
No. 2	Black
No. 3	Brown
No. 4	Green
No. 5	Yellow

- d. When assembling, apply a liberal coat of motor oil to all bearing surfaces.

NOTE: When applying final torque to the rod caps. Observe the following procedures:

Apply molybdenum disulfide grease to connecting rod bolt threads. Apply torque evenly to both ends of the cap. While tightening, if a torque of 3.3 m-kG (24 ft-lbs) or more is reached, DO NOT STOP tightening until final torque is reached. If tightening is interrupted between 3.3 m-kG and 3.8 m-kG, loosen the nut to less than 3.3 m-kG and start again. Tighten to full torque specification without pausing.

K. OIL PUMP

1. Check the clearance between housing and outer rotor.

Standard clearance:

0.09~0.015mm
(0.0035~0.0059 in.)

2. Check the clearance between outer rotor and inner rotor.

Standard clearance:

0.03~0.09mm
(0.0011~0.0035 in.)

3. Remove the relief valve and check valve plungers from oil pump assembly. Check the plungers for scratches and wear.

L. PRIMARY DRIVE

1. "Hy-Vo" Chain And Primary Gears

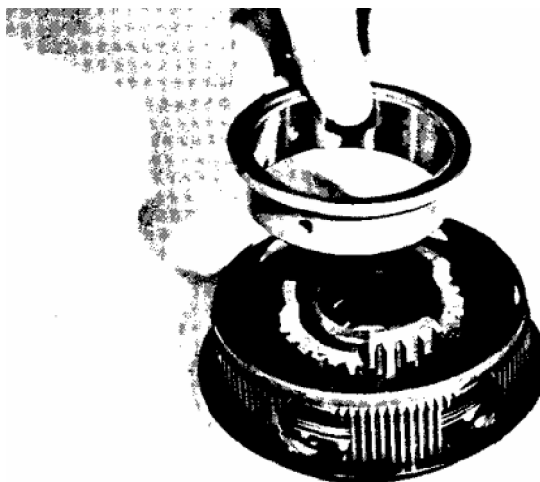
The "Hy-Vo" primary chain is a plate-and-pin type that does not use rollers as in the case of

a conventional motorcycle drive chain. The plates of the chain form a mating surface for the primary gear teeth. That is, the primary gears actually mesh with the chain plates. This chain is extremely durable and, under normal conditions, can be expected to last the life of the motorcycle engine. However, if obvious damage is caused through serious oil starvation or abrasive oil contamination, the chain should be replaced.

2. Clutch Damper

- a. Remove circlip using a press and special tool. Press tool on collar no more than necessary to remove circlip. Damper springs may be damaged if excessive pressure is applied.

- b. Inspect damper cam and pin surfaces. Check for smooth cam action (as illustrated by arrows). Check for excessive wear on cam and pin surfaces. If operation is not smooth or cam surfaces are severely worn, replace damper assembly.



- c. Inspect plate washer and thrust bearing for wear or damage. Replace as necessary.





NOTE: Galling on clutch plate splines will cause erratic clutch operation.

d. Damper Reassembly

- 1) Install thin plate washer, thrust bearing and thick plate washer in that order.
- 2) Install damper springs.
- 3) Install collar.
- 4) Use press and special tool to install circlip.

CAUTION: When installing circlip, the damper pin must be positioned in the center of the damper cam. Damage to the damper assembly could result from improper positioning.

3. Clutch Housing

- a. Check dogs on clutch housing. Look for cracks and signs of galling on edges. If damage is moderate, deburr. If severe, replace clutch housing.

NOTE: Galling on the friction plate dogs of the clutch housing will cause erratic clutch operation.

- b. Apply a thin film of oil to transmission main shaft and inside surface of clutch housing. Slip clutch housing over main shaft.

4. Clutch Boss

- b. The clutch boss contains a built-in damper beneath the first clutch plate (clutch plate 2). It is not normally necessary to remove the circlip and disassemble the built-in damper unless there is serious clutch chattering.

- b. Check splines on clutch boss for galling. If damage is slight to moderate, deburr. If it is severe, replace clutch boss.

5. Friction and Clutch Plates

Check clutch steel plates and friction plates for heat damage. Measure friction plate thickness at 3 or 4 points. Measure clutch plates for warpage with a dial gauge and stand. Replace clutch plate or friction plates as a set if any is faulty or beyond wear limits.

	Standard	Wear Limit
Friction plate thickness	3.0mm (0.12 in.)	2.8mm (0.11 in.)
Clutch plate warp limit		0.05mm (0.002 in.)

6. Clutch Push Rod

Check ends of clutch push rod for indentation. If severe, clutch adjustment may be difficult. Check for looseness of the steel ends of the push rod. If ends are loose or indented, replace push rod.

7. Clutch Springs

Measure clutch spring free length. Replace springs as a set if any is less than minimum free length.

Clutch spring minimum length:
4.15mm (1.63 in.)

M. Transmission

1. Inspect each shift fork for signs of galling on gear contact surfaces. Check for bending. Make sure each fork slides freely on its guide bar.
2. Roll the guide bars across a surface plate. If any bar is bent, replace.
3. Check the shift cam grooves for signs of wear or damage. If any profile has excessive wear and/or damage, replace cam.
4. Check the cam followers on each shift fork for wear. The follower should fit snugly into its seat in the shift fork, but should not be overly tight. Check the ends that ride in the grooves in the shift cam. If they are worn or damaged, replace followers.

5. Check shift cam dowel pins and side plate for looseness, damage or wear. Replace as required.
6. Check the shift cam stopper plate and circlip and stopper for wear. Replace as required.
7. Check the transmission shafts using a centering device and dial gauge. If any shaft is bent beyond specified limit, replace shaft.

Maximum run-out: .03mm (.001")

8. Carefully inspect each gear. Look for signs of obvious heat damage (blue discoloration). Check the gear teeth for signs of pitting, galling or other extreme wear. Replace as required.
9. Check to see that each gear moves freely on its shaft.
10. Check to see that all washers and clips are properly installed and undamaged. Replace bent or loose clips and bent washers.
11. Check to see that each gear properly engages its counterpart on the shaft. Check the mating dogs for rounded edges, cracks, or missing portions. Replace as required.

N. Starter Drives

1. Electric Starter Clutch And Gears
 - a. Check pin contact surface of idle gear (2) for pitting or other damage. If severe, replace gear.
 - b. Check spring caps and springs for deformation or damage. If severe, replace as necessary.
 - c. Check starter clutch bolt (allen screw) for looseness. If loose, remove bolt and replace with new bolt. Apply Loctite to threads and tighten to specified torque. Stake over end of bolts in oil pump driven gear (1).

Starter clutch bolt torque: 2.8~3.2 m·kg (20~23 ft·lbs)
--

2. Kick Starter
 - a. Kick Gears
 - 1) Check the kick gears for wear or scratches on teeth, particularly in the chamfered area of each gear.

b. Kick Clip Spring

- 1) The kick clip is fitted to kick gear (5) and slides in the groove. A too-tight or loose-fitting clip may result in improper operation. If too loose, bend the kick clip so that the friction increases, or replace clip.

O. Crankcases and Strainer Cover

1. Check crankcases for cracks or other damage.
2. Clean all oil passages and blow out with compressed air.
3. Strainer cover: Apply Loctite to strainer cover bolts during reassembly.

P. Bearings and Oil Seals

1. After cleaning and lubricating bearings, rotate inner race with a finger. If rough spots are felt, replace the bearing.

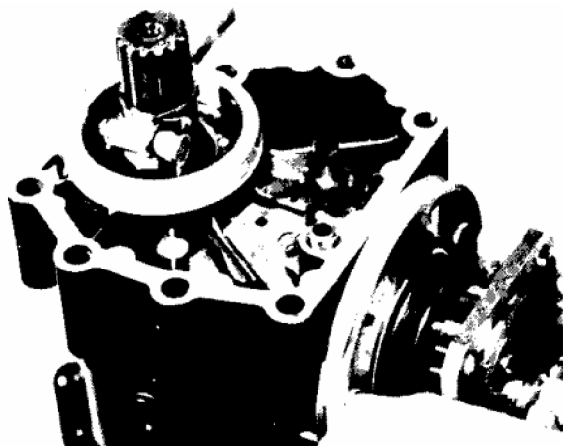
NOTE: Bearings are most easily removed or installed if the housings are first heated to approximately 95°~125°C (200°~250°F). Bring the case up to proper temperature slowly. Use an oven to avoid distortion.

2. Check oil seal lips for damage and wear. Replace as required.

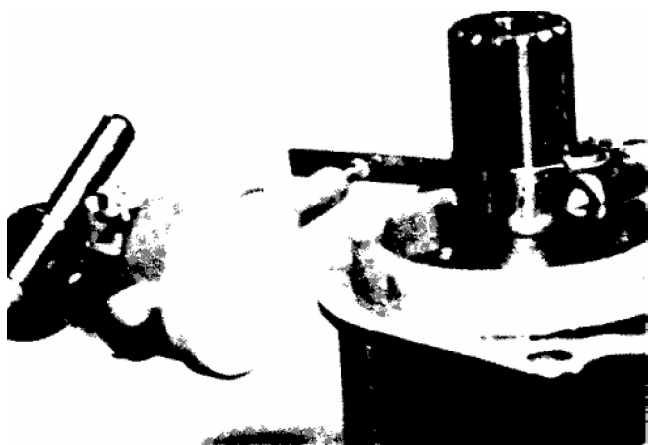
Q. Middle Gear Case

NOTE: This section involves external inspection only. For middle gear case overhaul and adjustment, refer to the Shaft Drive Section page 102.

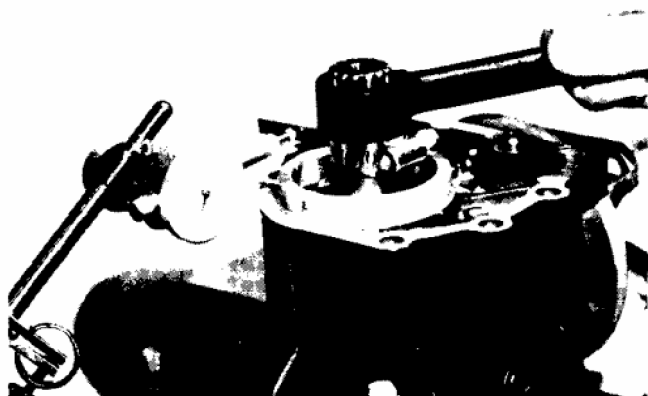
1. Inspect entire exterior for leakage. If leakage is found, the unit should be disassembled.
2. Check middle gear lash as follows:
 - a. Support gear case in a vise by the output shaft flange. Connect the lash measurement tool to the input shaft as shown.



- b. Mount a dial gauge against the lash measurement tool at the scribed mark (34mm from the center of the shaft).



- c. Hold the gear case and rotate the input shaft back and forth using the special wrench. Read the gear lash on the dial gauge.



Middle gear case lash:

0.1~0.2mm
(.004~.008")

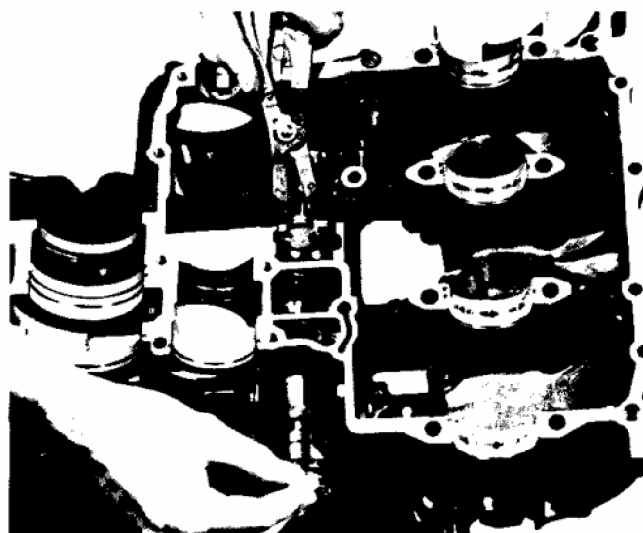
If lash is not within tolerance, refer to Drive Shaft Section page 102

3-4 ENGINE ASSEMBLY AND ADJUSTMENT

NOTES: 1) All gaskets and seals should be replaced when an engine is overhauled. All gasket surfaces must be cleaned. 2) Properly oil all mating engine and transmission parts during assembly. 3) **All** circlips should be inspected before assembly. Replace distorted circlips. Always replace cotter pins and piston pin clips after one **use**.

A. Shift Cam

Install shift cam, stopper plate, and circlip. Tighten shift cam locating bolt and bend over the lock tab. Install and tighten detent assembly.



Shift cam locating bolt torque:

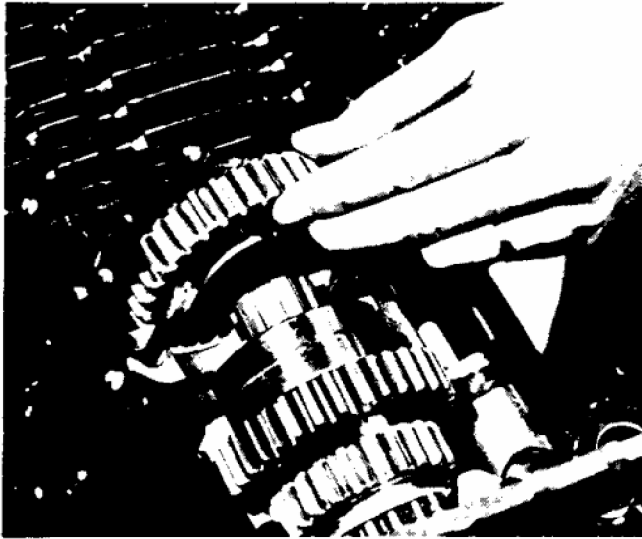
1.3~2.1 m·kg (9~15 ft·lbs)

Detent assembly torque:

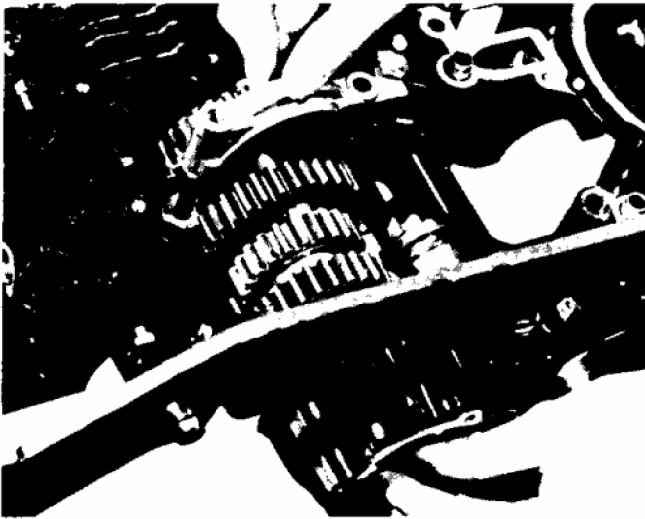
4.0~4.5 m·kg (29~32 ft·lbs)

B. Transmission

1. Place 2nd gear wheel end of drive axle into crankcase. Install middle drive gear. Make sure circlip half is positioned properly.



2. Install bearing cap, washers, and nuts. Tighten bearing cap.



Bearing cap torque:
1.8~2.2 m·kg (13~16 ft·lbs)

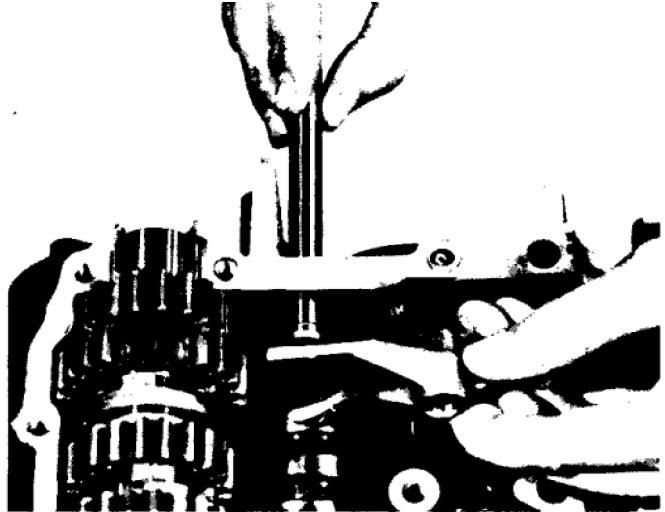
3. Install plate washer, spring washer, and bolt holding drive axle.
4. Place shift fork guide bar into crankcase. Place plate washer and shift forks on the guide bar. The washer must be positioned next to the bearing cap. Install the circlip (E-clip) on the shaft to hold the plate washer next to the bearing cap.

NOTE: When installing shift forks, make sure cam follower pins are correctly positioned in the shift cam.

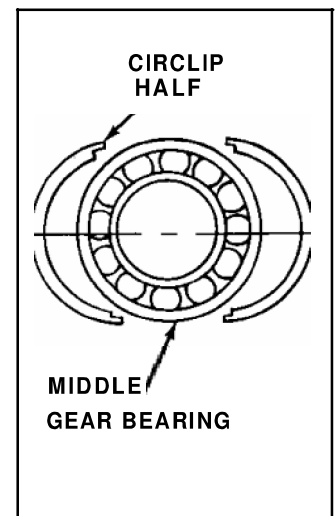


5. Install main shaft and clutch push rod seal.

6. Install shift fork guide bar and shift fork 1. Install circlips (E-clips).



7. Install middle driven gear. Make sure circlip halves are properly installed. Each circlip half fits into both crankcases.



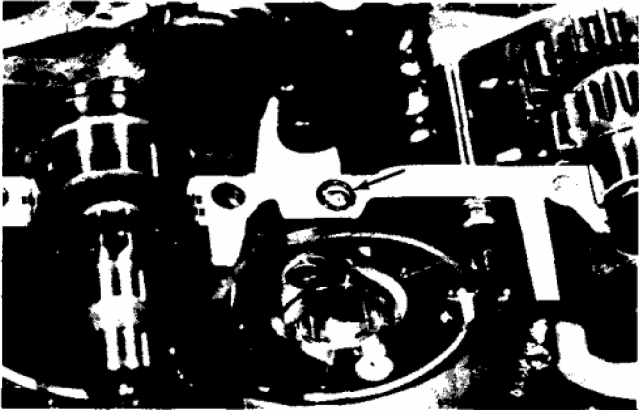
NOTE: When a new seal is installed, grease the lips of the seal before installation. Inspect the seal after installation.

C. Crankshaft and Crankcases

1. Install crankshaft into bottom crankcase. Crankcase bearings must be well oiled.
2. Apply Yamabond No. 4 sealant to crankcase mating surfaces.

CAUTION: DO not allow sealant to contact bearing inserts.

3. Make sure the o-ring is installed. Make sure all shafts and seals are positioned properly.



4. Install crankcase top and bolts. Install bolts as follows:
 - a. Use copper washers on bolts 5, 6, 7, 8.
 - b. Bolt threads must be oiled.
 - c. Tighten bolts in two stages in proper torque sequence. Start with bolt number one. Tighten the unnumbered bolt as number 24.

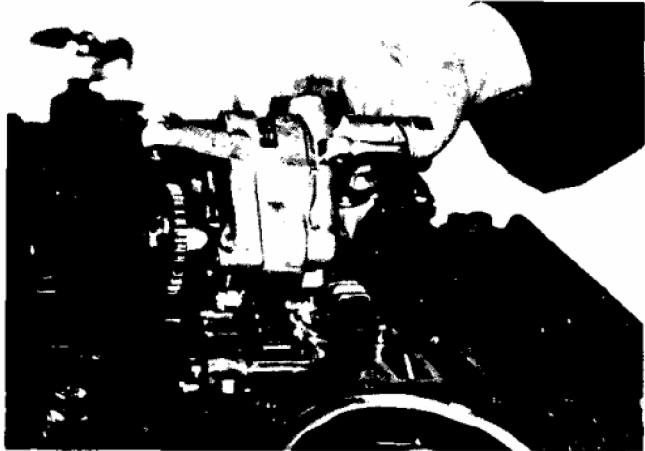
Stage 1: 8mm bolts 1.0 m-kG (7 ft-lb)
10mm bolts 2.0 m-kG (14 ft-lb)

Stage 2: 8mm bolts 2.0 m-kG (14 ft-lb)
10mm bolts 3.7 m-kG (27 ft-lb)

D. Oil Pump

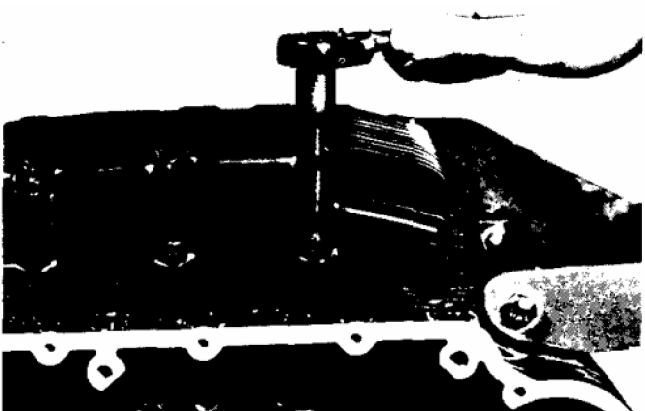
1. Reassemble oil pump in reverse disassembly order. Lubricate the oil pump well during assembly.

2. Install oil pump. Make sure rotor housing seal is positioned correctly.



NOTE: The oil pump must be full of oil when installed.

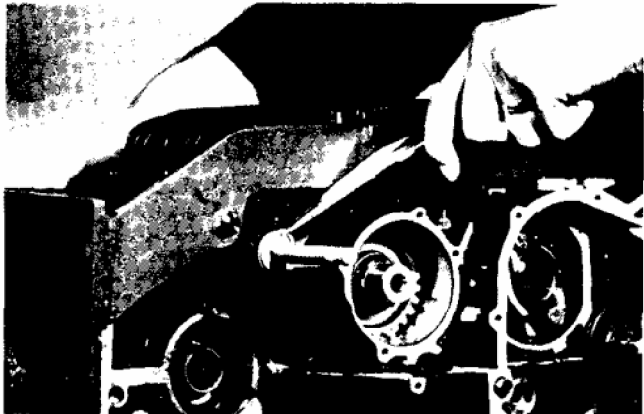
3. Install strainer cover. Use a new gasket.

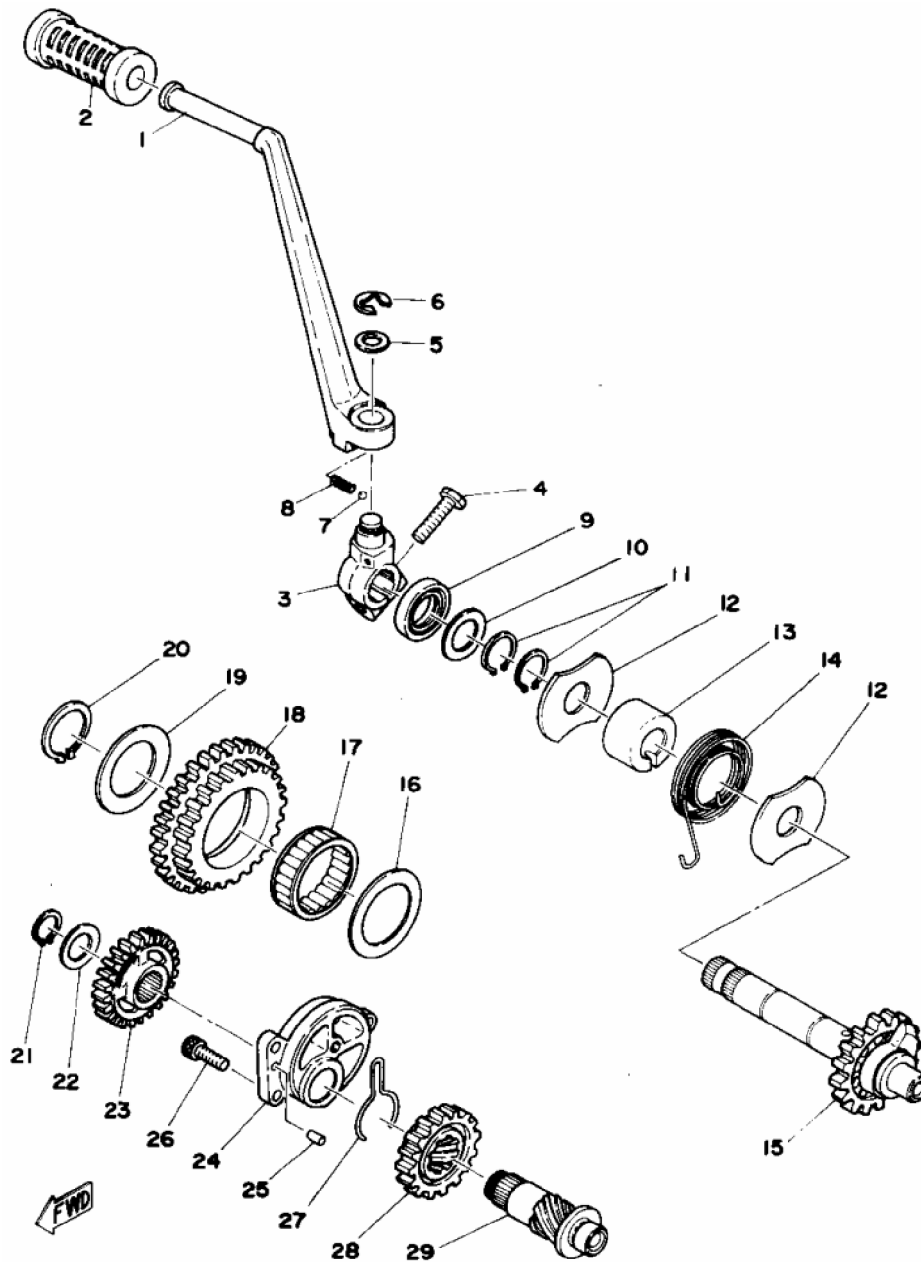


Strainer cover torque: 1.0 m-kG (7 ft-lb)

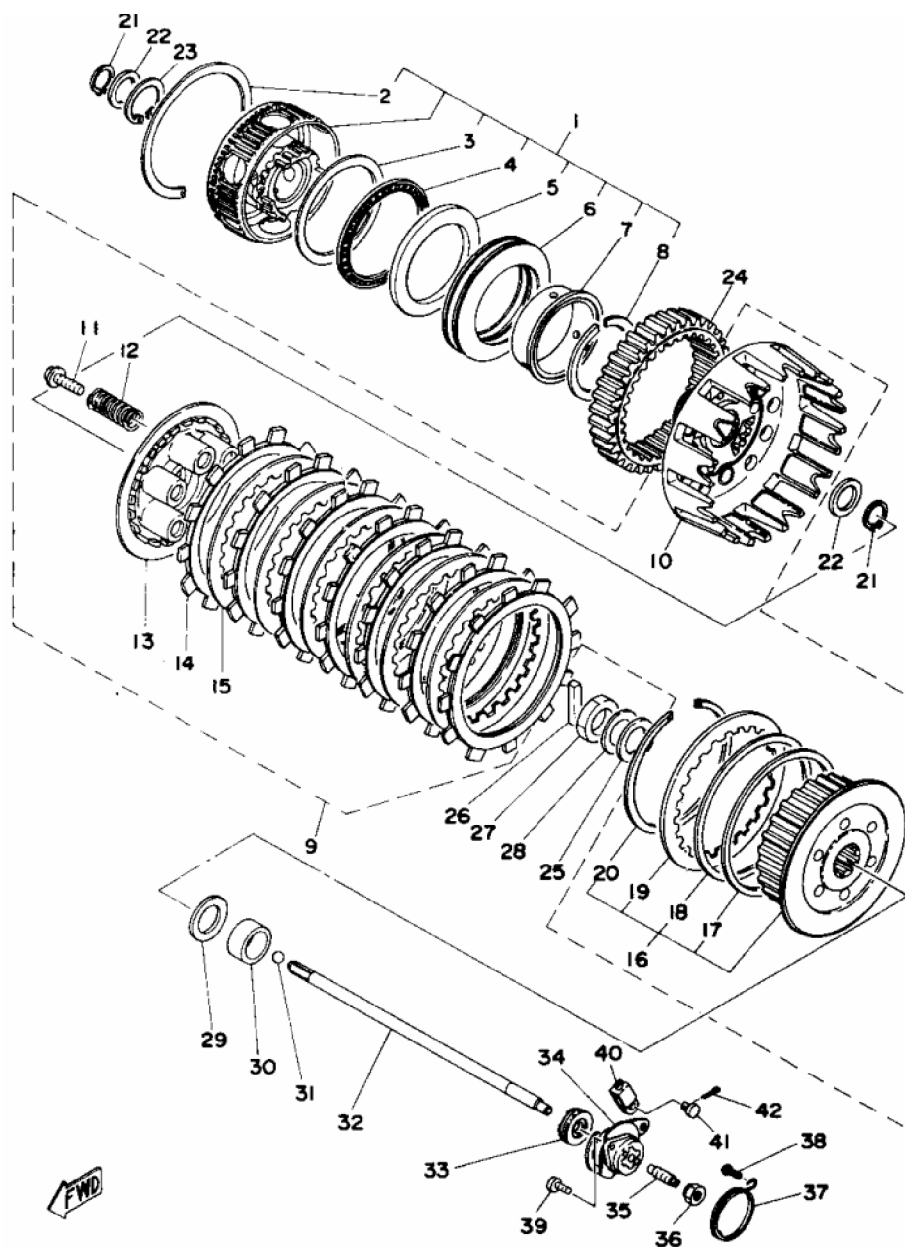
E. Shifter Assembly

1. Install shift shaft. Install circlip (E-clip) on left side of crankcases.



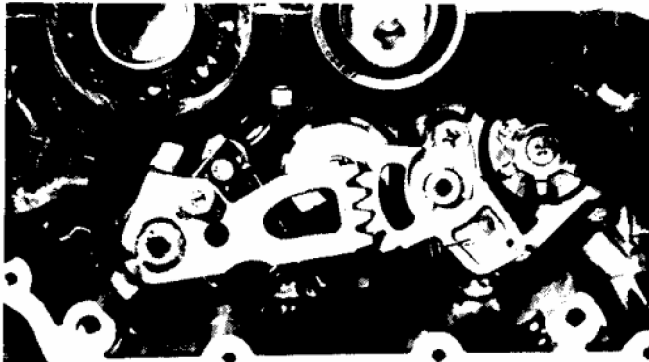


- | | | | |
|----|-----------------------------|----|----------------------------------|
| 1 | CRANK, kick | 16 | SHIM, kick shaft 1 (40.3-54-0.8) |
| 2 | COVER, kick lever | 17 | BEARING |
| 3 | BOSS, kick crank | 18 | KICK IDLE GEAR ASS'Y (38/30T) |
| 4 | BOLT | 19 | SHIM, kick shaft 2 (35.3-54-0.8) |
| 5 | WASHER, plate (15.5-24-1.5) | 20 | CIRCLIP (S-35) |
| 6 | CIRCLIP (E-10) | 21 | CIRCLIP (S-17) |
| 7 | BALL (7/32 inch) | 22 | SHIM |
| 8 | SPRING, compression | 23 | GEAR, kick 4 (20T) |
| 9 | OIL SEAL (SD-20-30-7) | 24 | HOLDER, kick gear |
| 10 | WASHER, plate (20.2-30-1.0) | 25 | PIN, dowel (4-10) |
| 11 | CIRCLIP (S-20) | 26 | BOLT, hexagon socket head |
| 12 | COVER, kick spring | 27 | CLIP, special |
| 13 | SPACER | 28 | GEAR, kick 5 (21T) |
| 14 | SPRING, torsion | 29 | SHAFT, kick 2 |
| 15 | KICK SHAFT ASS'Y (22T) | | |

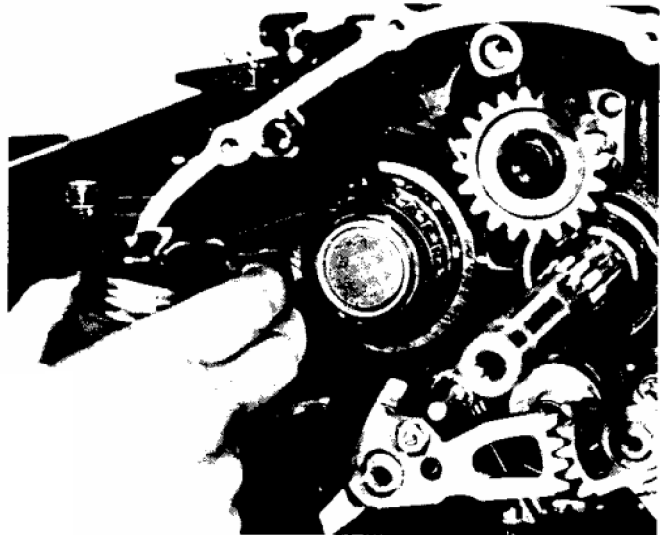


- | | | | | | |
|----|---------------------------|----|----------------------------|----|-----------------------------|
| 1 | DAMPER ASS'Y | 15 | PLATE, clutch 1 | 29 | WASHER, plate (25.2-39-1.0) |
| 2 | CIRCLIP | 16 | CLUTCH BOSS ASS'Y | 30 | SPACER |
| 3 | WASHER, plate (76-95-0.8) | 17 | PLATE, seat | 31 | BALL (5/16 inch) |
| 4 | BEARING | 18 | SPRING, clutch boss | 32 | ROD, push |
| 5 | WASHER, plate (69-95-5.4) | 19 | PLATE, clutch 2 | 33 | OIL SEAL (SD-8-25-8) |
| 6 | SPRING, damper | 20 | CIRCLIP | 34 | BALL SCREW ASS'Y |
| 7 | COLLAR | 21 | CIRCLIP (S-20) | 35 | SCREW, adjusting |
| 8 | CIRCLIP | 22 | WASHER, plate (21.2-29-2) | 36 | NUT, adjusting |
| 9 | CLUTCH ASS'Y | 23 | CIRCLIP | 37 | SPRING, torsion |
| 10 | CLUTCH HOUSING COMP. | 24 | GEAR, primary driven (45T) | 38 | HOOK, spring |
| 11 | SCREW | 25 | WASHER, plate (22-36-2.6) | 39 | SCREW, pan head |
| 12 | SPRING, compression | 26 | ROD, push 1 | 40 | JOINT |
| 13 | PLATE, pressure | 27 | NUT, hexagon | 41 | PIN |
| 14 | PLATE, friction 1 | 28 | WASHER, conical spring | 42 | PIN, cotter |

2. Install shift lever 2. The dot on shift lever 2 must align with the dot on the shaft.
3. Shift transmission into second gear. The line on the shift cam must align with the line on shift lever 2. If not aligned, adjust by turning the adjusting screw.

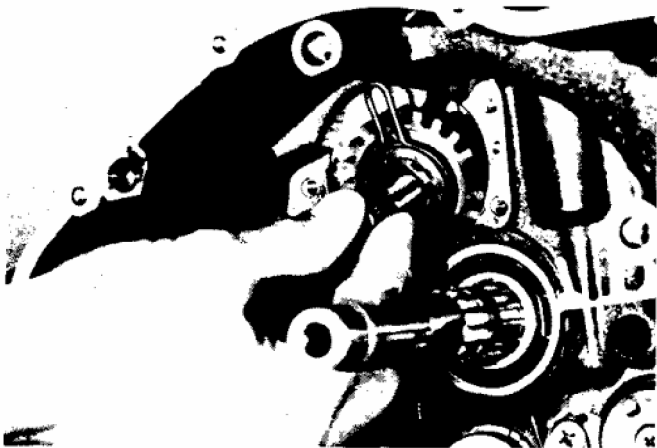


4. Install shim and bearing onto idler shaft. Oil the bearing.

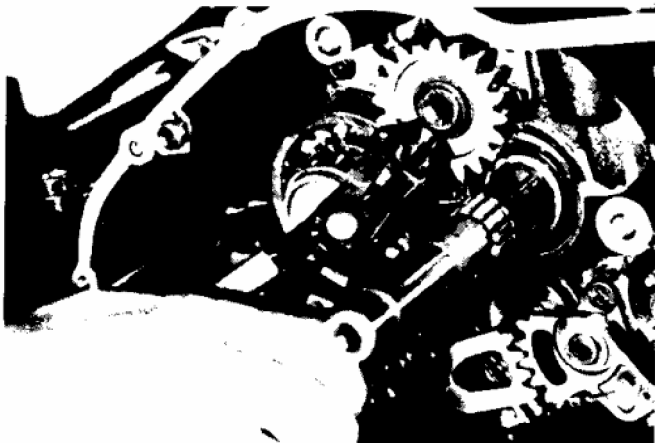


F. Kick Starter Assembly

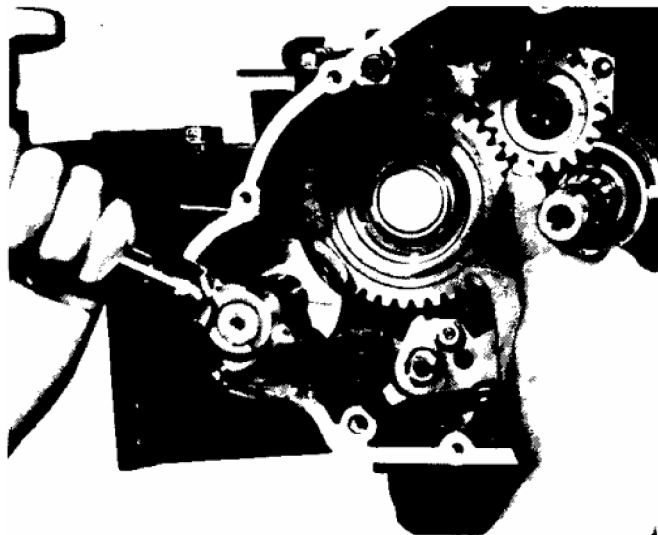
1. Install kick gear 5 assembly into crankcases. The kick clip (special clip) must be positioned in the groove.



2. Install kick gear holder.
3. Install kick gear 4, shim, and circlip.



5. Install the kick starter shaft and kick idle gear assembly together. Use the kick crank to help install the kick shaft assembly. Install the torsion spring on the boss. Install the washer and circlip on the kick shaft. Check the movement of the kick shaft with the kick crank. Remove the kick crank.

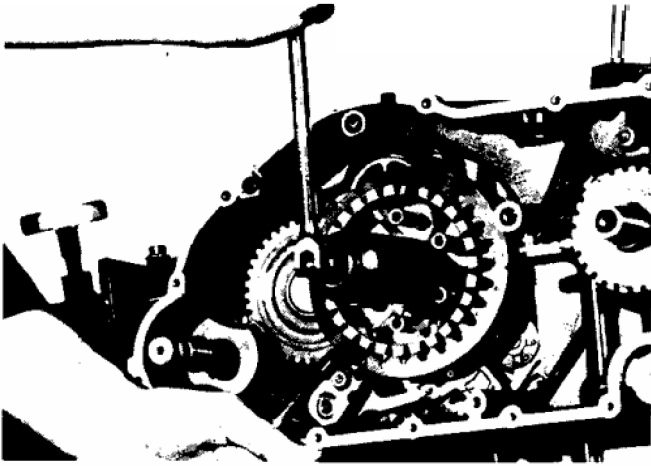


G. Clutch and Primary Drive

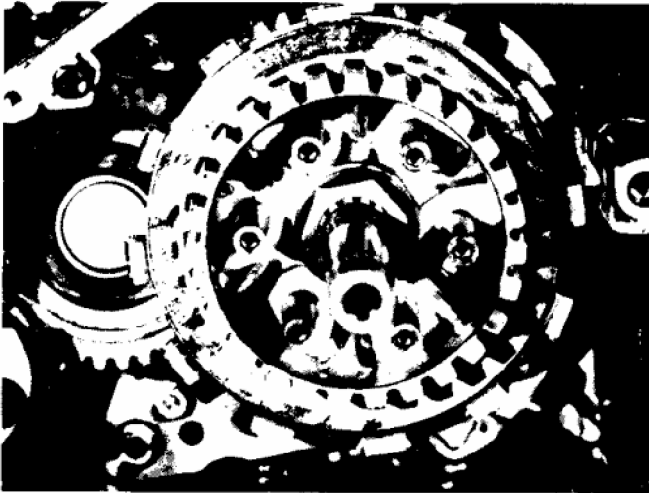
1. Install clutch spacer, plate washer, and clutch boss. Install the spring washer and lock nut. Use the clutch holding tool and special 32mm deep socket (special tool) to tighten the clutch nut.

Clutch nut torque:

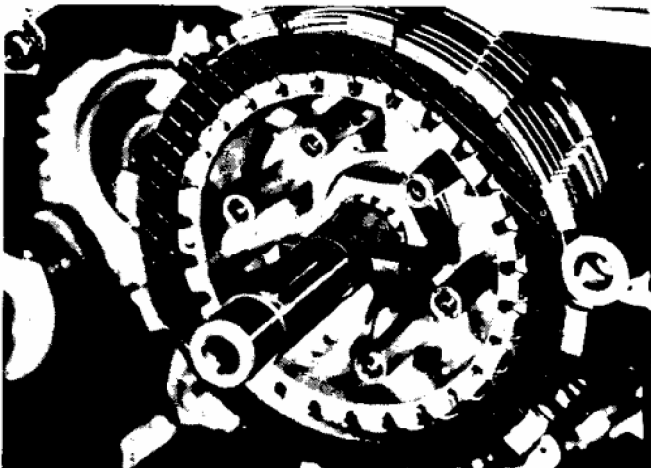
8m·kg (58 ft·lbs)



2. Install a clutch friction plate, then a steel clutch plate. Install clutch friction plates and steel plates alternately.

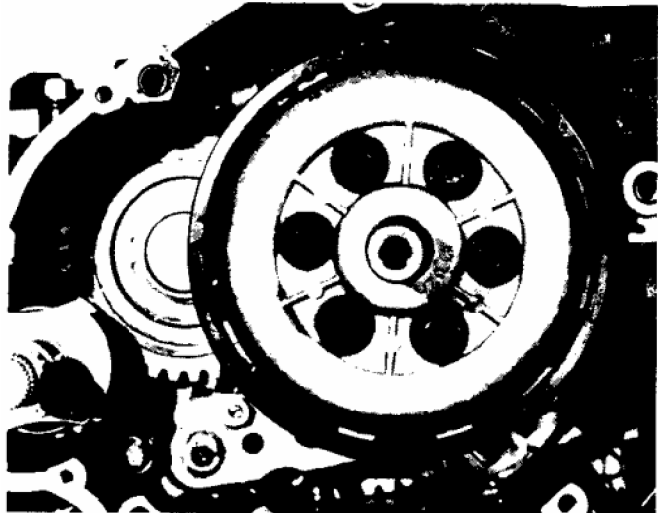


NOTE: Each steel clutch plate has a tab. There is a dot on the clutch boss to correspond to each tab. Install a clutch plate tab next to one dot. Position the next steel plate next to the

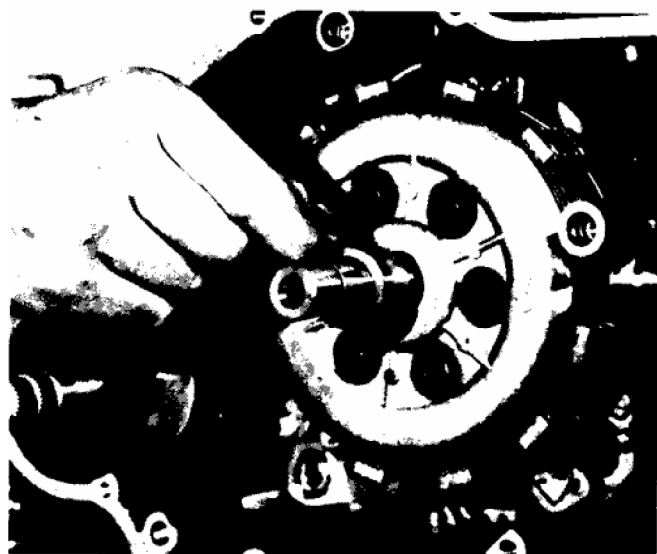


next dot on the clutch boss. Follow this pattern clockwise around the clutch boss until all friction and steel clutch plates are installed.

3. Install push rod 1 into the slot in the main axle.
4. Install plate washer onto main axle. Install pressure plate with the arrows matching the arrows on the clutch boss.



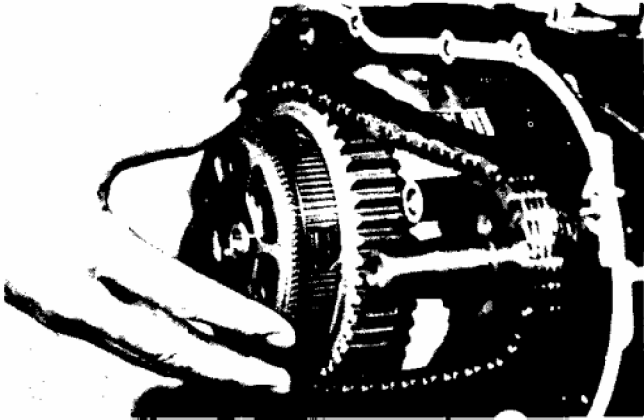
5. Install two clutch springs and screws lightly so that the clutch plates can be moved.
6. Install the clutch alignment tool (special tool) to align the clutch friction plates. The tool must be centered on the clutch pressure plate.
7. Install remaining clutch springs and screws. Tighten all clutch screws. Remove clutch alignment tool. Install circlip. Install plate washer.



Clutch screw torque:

0.8~1.0 m·kg (6~7 ft·lbs)

8. Carefully install spacer and clutch housing. Use care to avoid damaging friction plates.
9. Place drive chain on drive gear. Install damper assembly into primary driven gear and install this assembly into the clutch assembly.



10. Install plate washer and circlip on main axle. Install large circlip on clutch damper.

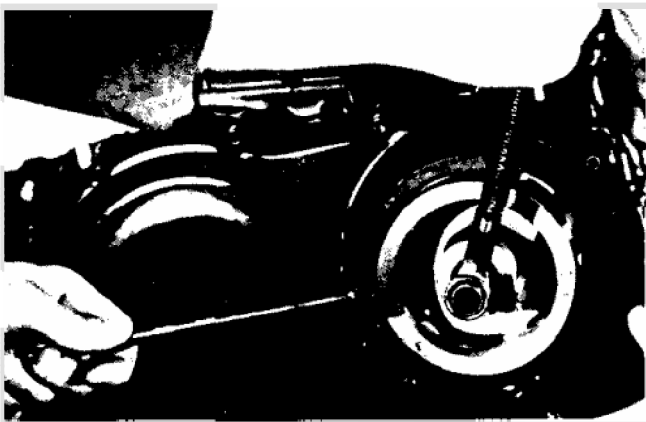
H. Bearing Housing

Install bearing housing. Tighten bearing housing bolts.

Bearing housing bolt torque:
2.0~2.4 m·kg (14~17 ft·lbs)

I. Right Crankcase Cover

1. Install oil pressure sending switch.
2. Place plate washer on kick shaft. Install a new gasket and the right crankcase cover. Do not use all cover screws until rotor and generator cover are installed.
3. Install rotor, plate washer, spring washer and bolt. Hold rotor with special rotor holding tool and tighten bolt.



Rotor bolt torque:
3.0~4.0 m·kg (22~29 ft·lbs)

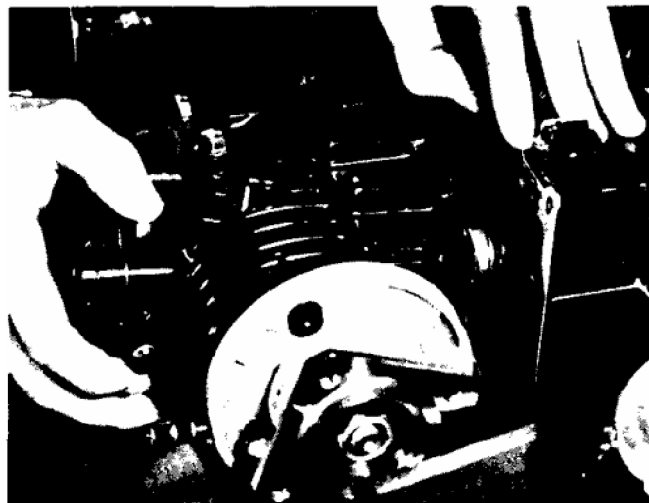
4. Install generator assembly. Connect oil pressure warning wire to the switch. Install all generator cover and right crankcase cover screws. Route the wiring harness and install generator cover screw with wire harness clamp.
5. Install breather cover.

J. Middle Gear

1. Install drive cam and spring onto middlegear shaft.



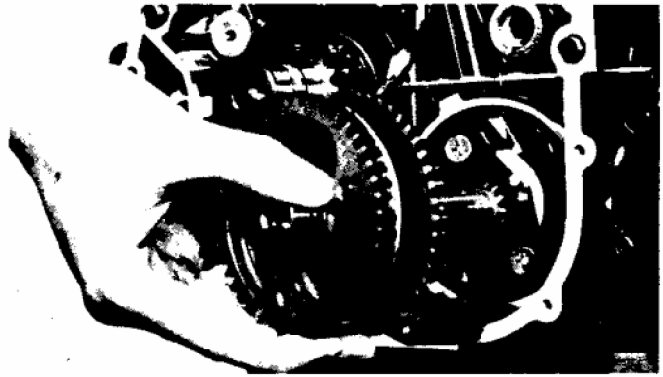
2. Install a new gasket and install middle gear case.



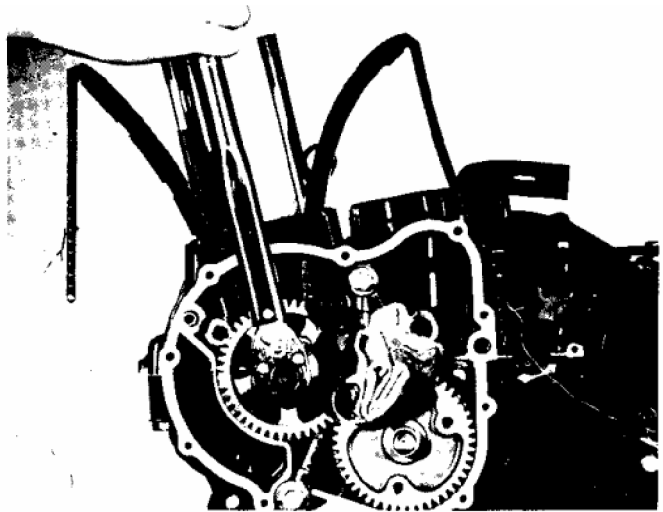
Middle gear case bolt torque:
2.0~2.5 m·kg (14~18 ft·lbs)

K. Drive Axle Bearing Housing

1. Oil drive axle bearing.
2. Install drive axle shim on drive axle.
3. Oil the o-ring on the bearing housing. Install bearing housing. Attach wire harness clamp to lower securing screw.



3. Install cam chain dampers. Install the damper with the three (3) raised blocks to the front.
4. Install cam chain onto drive sprocket. Connect wire to each end of cam chain.
5. Install oil pump drive gear. Place a rag between oil pump drive gear and driven gear to lock the gears. Install plate washer and nut. Tighten nut.

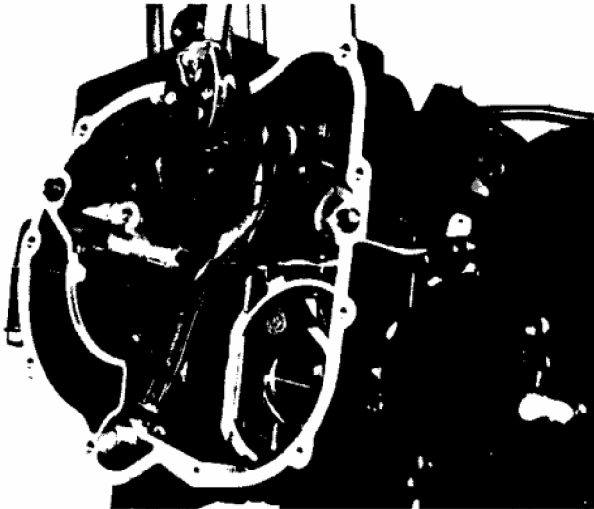


Oil pump drive gear nut torque:
8.0~12.0 m·kg (58~87 ft·lbs)

L. Left Crankcase Cover

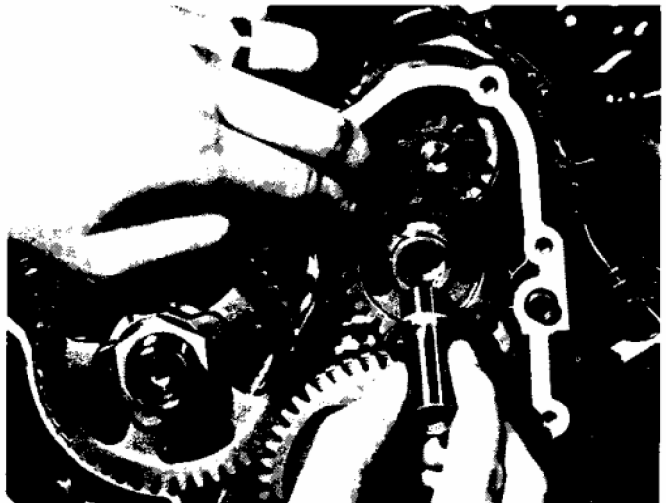
1. Oil Delivery Pipe

Oil the threads of the oil delivery pipe union bolts. Install new washers on each side of each bolt and tighten bolts.

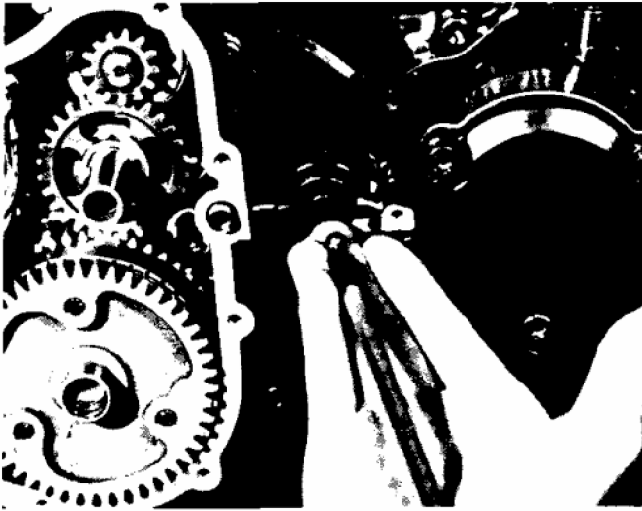


Oil delivery pipe torque:
2.0~2.2 m·kg (14~16 ft·lbs)

2. Install plate washer on oil pump driven gear shaft. Install starter clutch assembly.



6. Install starter motor
7. Install starter motor idler gear and kick idler gear. Install the idler gear shaft.
8. Install clutch ball bearing and clutch push rod.

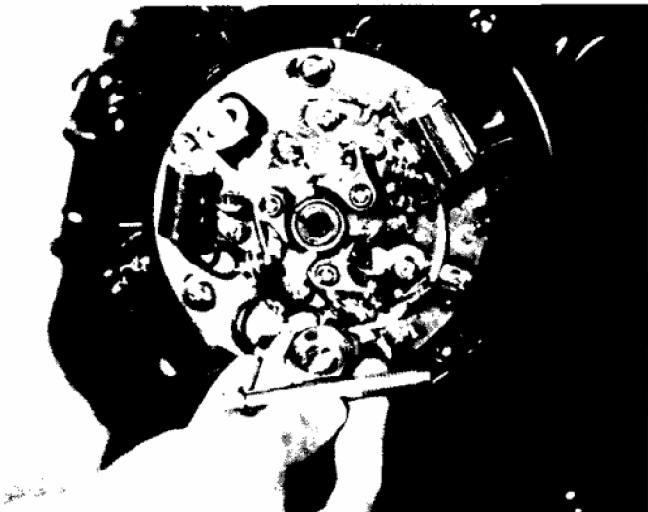


9. Install plate washer on starter clutch shaft. Install left crankcase cover.

NOTE: Install two wiring harness clamps on lower cover screws.

M. Ignition Assembly

1. Install governor assembly.
2. Install contact breaker plate assembly. Route the assembly wires using the clamps provided.
3. Attach neutral light wire.
4. Install crankshaft turning nut on crankshaft. Tighten securing bolt.



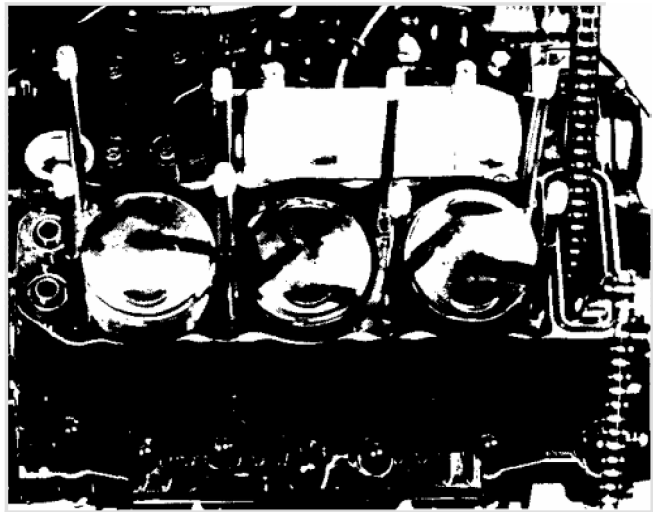
Crankshaft turning nut (bolt) torque:
1.5~2.9 m·kg (11~21 ft·lb)

N. Pistons and Cylinder

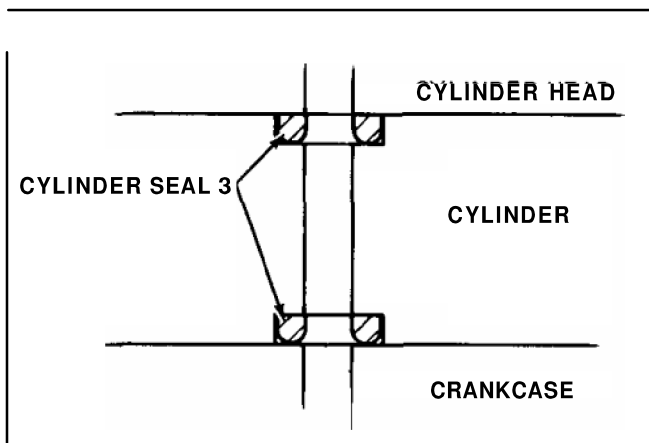
1. Install pistons on rods. The arrow on the pistons must point to the front of the engine.

NOTE: Always install new piston pin circlips.

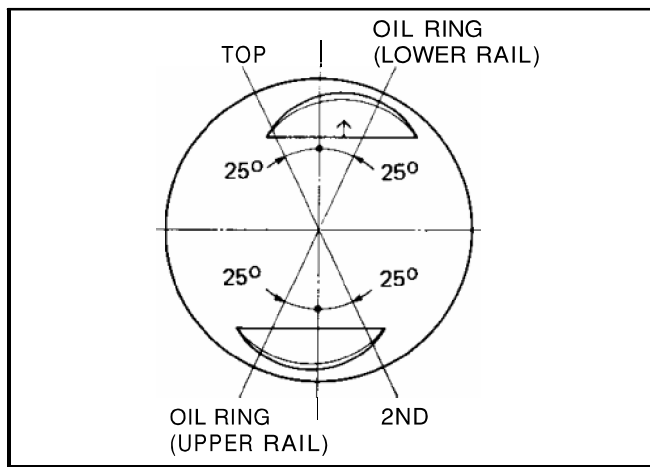
2. Install a new cylinder base gasket. Install new cylinder seal 2, with flat side into crankcase. Install three cylinder base o-rings.



3. Install two round cylinder seals (cylinder seal 3). The flat side of the seal is the top and fits into the cylinder.



4. Position piston rings as shown.

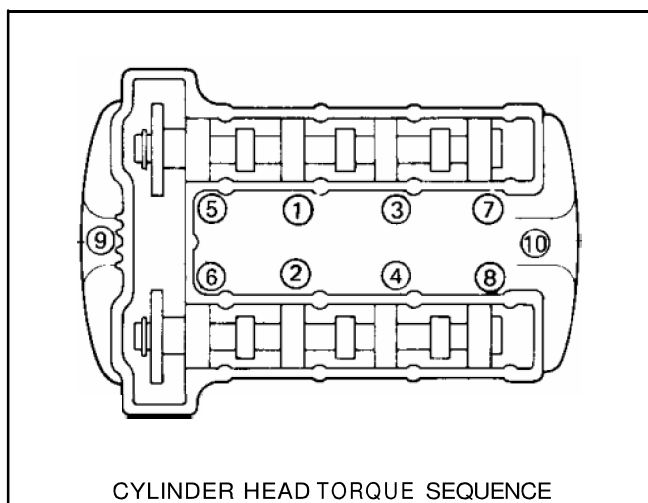


NOTE: Make sure ends of oil ring expanders are not overlapped.

O. Cylinder Head Installation

NOTE: The assembly of the cylinder head is the reverse of the disassembly procedure. Install valve springs with tighter windings (smaller pitch) down. Install each valve lifter in its original location.

1. Install new cylinder head gasket. Place the gasket with the tab forward. Install a new cylinder seal 1.
2. Install **two** new cylinder seals (cylinder seal 3) with the rounded side into the cylinder.
3. Install cylinder head. Place two (2) thicker plate washers on two (2) center exhaust studs. Install remaining washers and nuts.
4. Tighten ten (10) top cylinder head nuts and bolts. Oil the threads before tightening. Tighten in two (2) stages of one-half torque each. Tighten according to the proper sequence (No. 1, 2, 3, etc.)



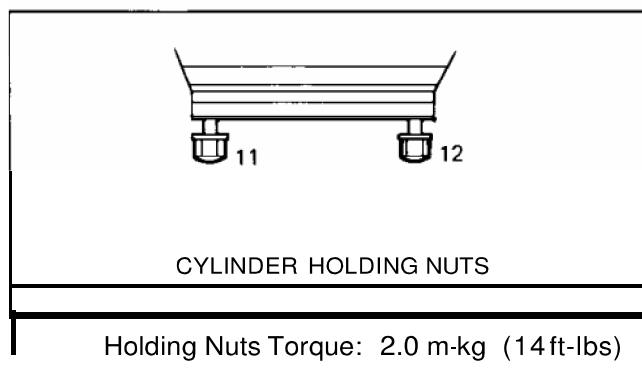
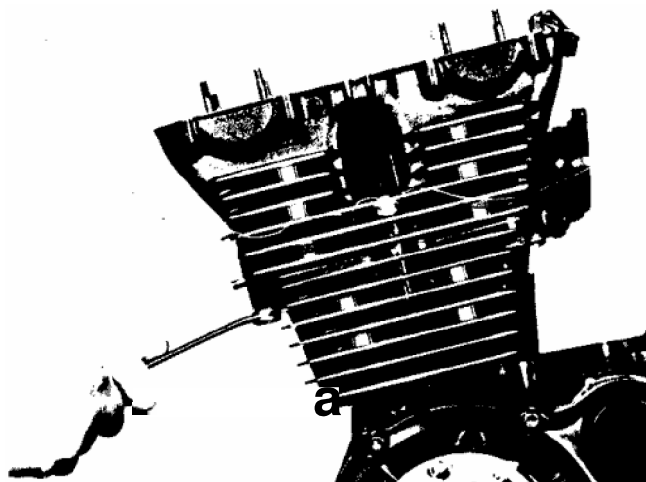
Stage 1 :

10mm nut (No. 1-8): 1.5 m-kg (11 ft-lbs)
8mm bolt (No. 9, 10): 1 m-kg (7 ft-lbs)

Stage 2:

10mm nut (No. 1-8) 3.5 m-kg (25 ft-lbs)
8mm bolt (No. 9, 10) 2.0 m-kg (14 ft-lbs)

5. Install two (2) cylinder head holding nuts with washers on left side of cylinder.



6. Install oil delivery pipe. Use a copper washer on each side of each end of the pipe. Install the shorter union bolt into the crankcase.

P. Camshaft Installation

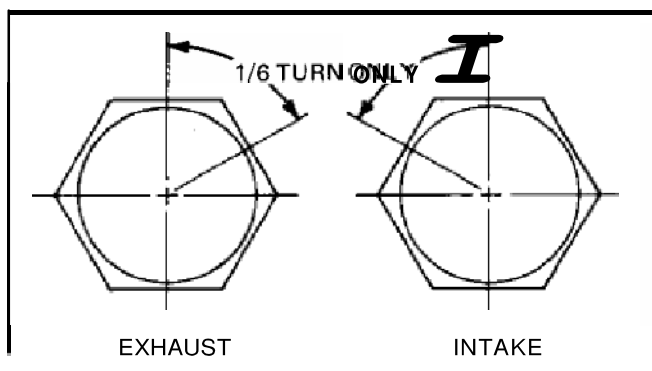
1. Position cylinder No. 1 (left) at T.D.C.
2. Oil the exhaust cam bearing surfaces. Oil the cam caps. Install the exhaust cam and caps. The dot on the cam must align with the arrow on the No. 1 cap. The caps are numbered from left to right: 1, 2, 3, 4. The arrows on the caps point to the left.
3. Place washers and nuts on cam shaft cap studs.

NOTE: Manufacturer's marks or numbers stamped on the rings are on the top side of the rings. Coat pistons and rings well with oil.

5. Install the cylinder. A ring compressor is usually not necessary.

CAUTION: Do not turn camshaft except as noted in Step 4. Damage to valves could result.

4. Turn exhaust cam only 1/6 turn (one flat) clockwise, and back to arrow-to-dot alignment. This will help seat the camshaft on the bearing surfaces. Gradually tighten caps from left to right. No 1-4 in that order.



Camshaft Cap Torque: 1 m-kp (7 ft-lbs)

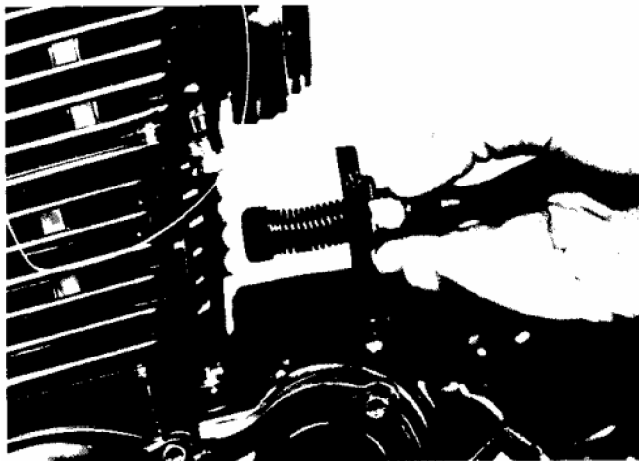
5. Install intake cam using procedures 1-4. Turn intake cam 1/6 turn counterclockwise.

Q. Cam Chain Installation

1. Install guide stopper



2. Place cam chain on cam sprockets. The dots on the cams must be aligned with the arrows on the No. 1 cam caps. The No. 1 cylinder must be at T.D.C. (The No. 1 "T" mark on the governor aligned with the stationary timing mark.)
3. Install a new cam chain tensioner. Remove the tensioner cover. Loosen the adjuster bolt. Turn the crankshaft until the cam chain tensioner rod moves to its inner most position. Tighten the adjuster bolt and lock nut. Install tensioner cover.



R. Cylinder Head Cover

1. Install new cylinder head cover gasket. Install cylinder head cover.
2. Install air scoop brackets.

3-5 REMOUNTING ENGINE

See page 106 sections 3-6 timing plate setting.

A. Remounting Engine

1. Refer to Chapter 3-1 for engine removal. Reverse the applicable removal steps.
2. Install and tighten engine mounting bolts.

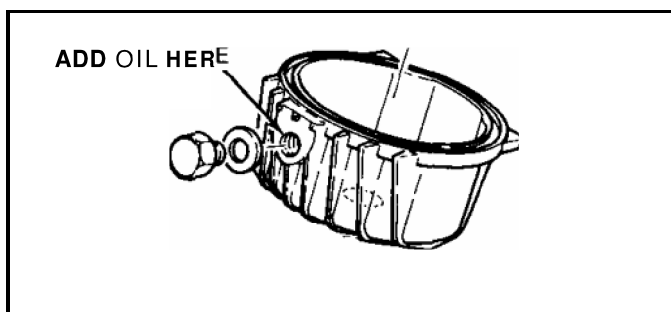
Engine mounting bolt torque:

10mm bolt: 5.0~6.0 m-kp (36~43 ft-lbs)

12mm bolt: 8.0~11.0 m-kp (58~80 ft-lbs)

3. Install oil filter. Remove oil filter filler bolt. Fill oil filter with 0.5 lit (0.5 qt.) engine oil.

NOTE: See sections 3-6 on page 106 – Timing plate setting.



CAUTION: The filter must be filled with the specified amount of oil to prime the oil pump of an overhauled engine.

4. Tighten engine oil drain plug, oil filter mounting bolt, and middle drain plug.

Torque:

Engine oil drain plug:

3.9~4.7 m-kG (28~34 ft-lbs)

Oil filter mounting bolt:

3.0~3.4 m-kG (22~25 ft-lbs)

Middle gear drain plug:

3.9~4.7 m-kG (28~34 ft-lbs)

5. Add oil to engine and middle gear case

Engine oil: 3.0 lit (3.2 US qt.)
Middle gear oil: 360cc (12 oz)

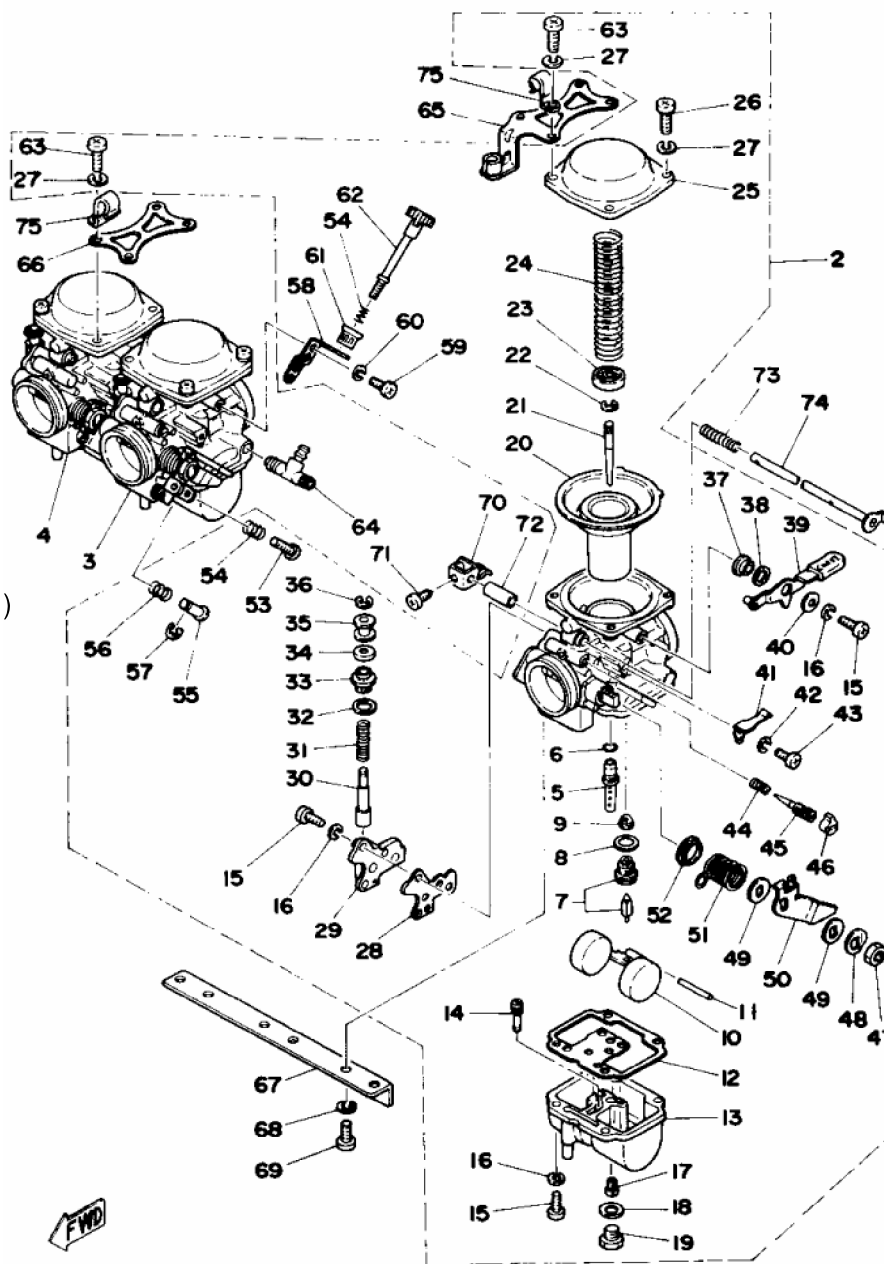
NOTE: These oil quantities are for an overhauled engine. Observe oil filter filling procedure.

CAUTION: If oil pressure warning light (red light) stays on after starting engine, stop engine immediately. Fill oil filter with oil as in step 3 above. Check for proper operation of the warning light.

- 1 CARBURETOR ASS'Y
- 2 CARBURETOR ASS'Y 1
- 3 CARBURETOR ASS'Y 2
- 4 CARBURETOR ASS'Y 3
- 5 NOZZLE, main (Y-2)
- 6 O-RING
- 7 VALVE SEAT ASS'Y (2.0 ø)
- 8 WASHER, valve seat
- 9 NET, filter
- 10 FLOAT
- 11 PIN, float
- 12 GASKET, float chamber
- 13 BODY, float chamber
- 14 JET, pilot (No. 17.5)
- 15 SCREW, pan head
- 16 WASHER, spring
- 17 JET, main
- 18 WASHER
- 19 SCREW, plug
- 20 DIAPHRAGM ASS'Y
- 21 NEEDLE (4H11-3)
- 22 CLIP, needle
- 23 PLATE, needle fitting
- 24 SPRING, diaphragm
- 25 COVER, diaphragm
- 26 SCREW, pan head
- 27 WASHER, spring
- 28 GASKET, starter body
- 29 BODY, starter
- 30 PLUNGER, starter
- 31 SPRING, plunger
- 32 WASHER
- 33 CAP, plunger
- 34 COVER, plunger cap
- 35 BUSHING, starter plunger
- 36 CLIP
- 37 RING
- 38 WASHER
- 39 LEVER, starter 1
- 40 WASHER
- 41 SPRING, starter lever
- 42 WASHER, spring
- 43 SCREW, pan head
- 44 SPRING, pilot screw
- 45 SCREW, pilot

- 46 CAP, pilot screw
- 47 NUT
- 48 WASHER
- 49 COLLAR, spring
- 50 LEVER, throttle
- 51 SPRING, throttle
- 52 SEAL (8ø)
- 53 SCREW, throttle stop
- 54 SPRING, throttle stop
- 55 ROD, push
- 56 SPRING, adjuster
- 57 CLIP
- 58 BRACKET
- 59 SCREW, pan head
- 60 WASHER, spring

- 61 BUSHING
- 62 ADJUSTER
- 63 SCREW, pan head
- 64 NIPPLE
- 65 THROTTLE BRACKET ASS'Y
- 66 PLATE, upper
- 67 PLATE, lower
- 68 WASHER, spring
- 69 SCREW, pan head
- 70 LEVER, starter 2
- 71 SCREW
- 72 PIPE, starter lever shaft
- 73 SPRING, starter lever shaft
- 74 SHAFT, starter lever
- 75 CLIP



CARBURETION

4-1 CARBURETOR

A. Description

The XS750D is equipped with three "constant velocity" (CV) carburetors mounted on rubber intake manifolds. Air flow through the venturi is controlled by a throttle slide (vacuum piston). The slide is raised and lowered by engine vacuum rather than a cable linked directly to the throttle grip. This type of carburetor Compensates automatically for atmospheric pressure changes such as those encountered when riding to high altitudes.

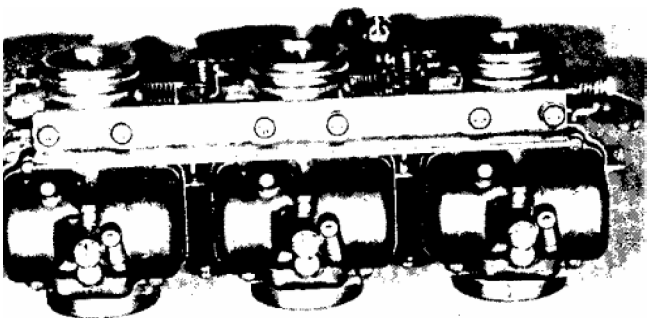
B. Specifications

Main jet	#145
Jet needle	4 H 1 1 - 3
Needle jet	Y-2
Starter jet	#45
Float height	26.6mm (above gasket surface)
Pilot jet	#17.5
Low speed screw	preset
Fuel valve seat	2.0mm

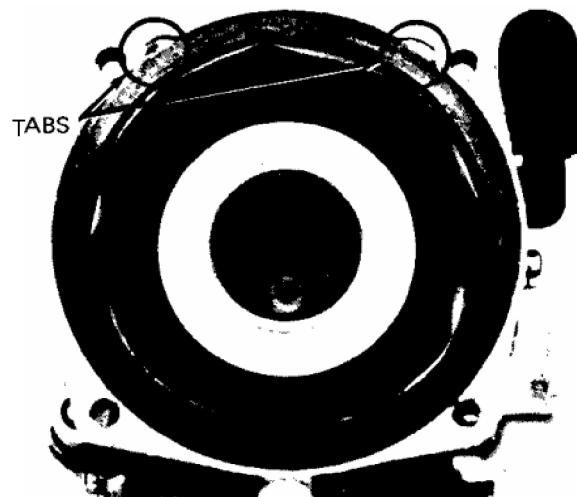
NOTE: The low speed mixture screw settings are adjusted at the factory with the use of specialized equipment. Do not attempt to change these settings.

C. Disassembly

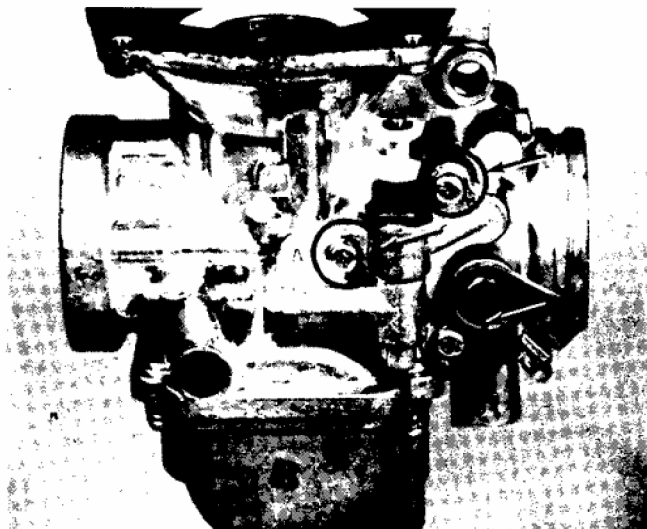
1. Prepare to separate carburetors (separation not necessary if only float level adjustment or throttle slide inspection is to be done). Remove starter lever (1). Loosen starter lever (2) securing screws and remove starter lever rod.
2. Remove upper and lower brackets. Note position of synchronizing screws for guidance in reassembly. Separate carburetors.



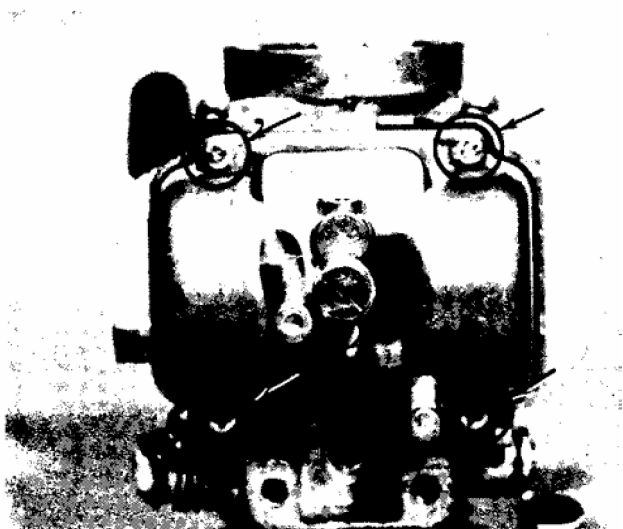
3. Remove vacuum chamber cover. Remove the spring, needle fitting plate, needle, and diaphragm (vacuum piston).
4. Note that there are tabs on the rubber diaphragm. There are matching recesses in the carburetor body for the diaphragm tabs.



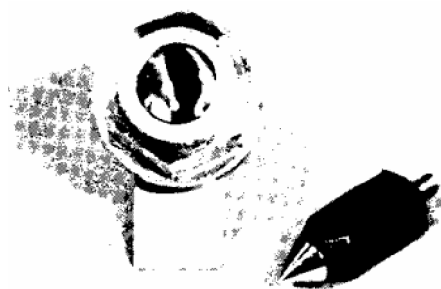
5. To inspect starter jet, remove three (3) screws holding the starter body to the left side of the carburetor.



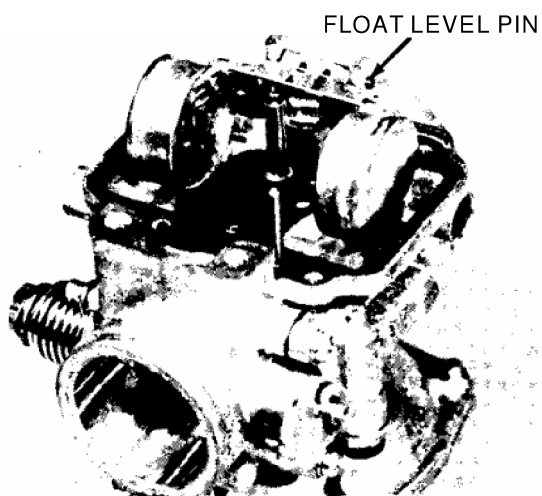
6. Remove the four (4) screws holding the float bowl cover. Remove float bowl cover. The main jet is located under a cover in the float bowl.



3. Inspect inlet needle valve and seat for wear or contamination. Replace these components as a set.



7. Pull out float pivot pin. Remove the float assembly. Be careful to not lose the float valve needle located under the float level adjustment tang. Remove the needle jet.



4. Inspect vacuum piston and rubber diaphragm. If the piston is scratched or the diaphragm is torn, the assembly must be replaced.



8. Reassemble in reverse order. Pay close attention to the installation of the vacuum piston diaphragm.

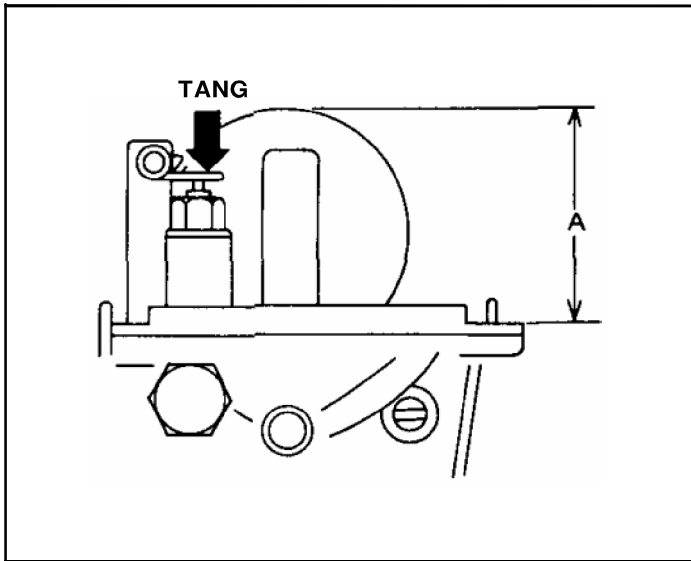
D. Inspection

1. Examine carburetor body and fuel passages. If contaminated, wash carburetor in petroleum-based solvent. Do not use caustic carburetor cleaning solutions. Blow out all passages and jets with compressed air.
2. Examine condition of floats. If floats are leaking or damaged, they should be replaced.

E. Adjustments

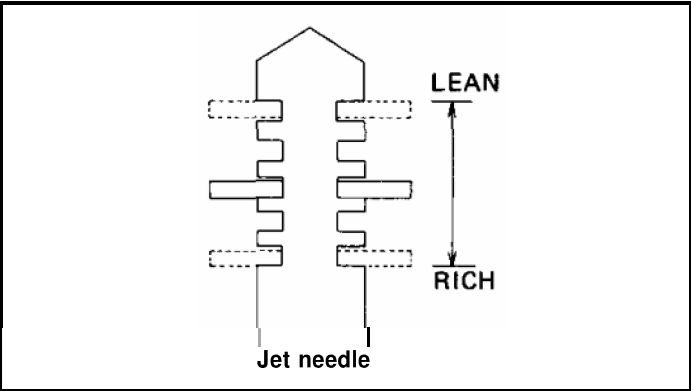
1. Float level adjustment

Measure the distance from the bottom of the float to the float bowl gasket surface. Bend the tang on the float arm if any float level adjustment is necessary. Both floats must be at the same height. If the fuel level is too high, a rich air/fuel mixture will occur. If too low, a lean mixture will result.



2. Jet needle adjustment

The mid-range air/fuel supply is affected by the position of the needle in the needle jet. If it is necessary to alter the mid-range air/fuel mixture characteristics of the machine, the jet needle position may be changed. Move the jet needle up for a leaner condition or toward the bottom position for a richer condition.

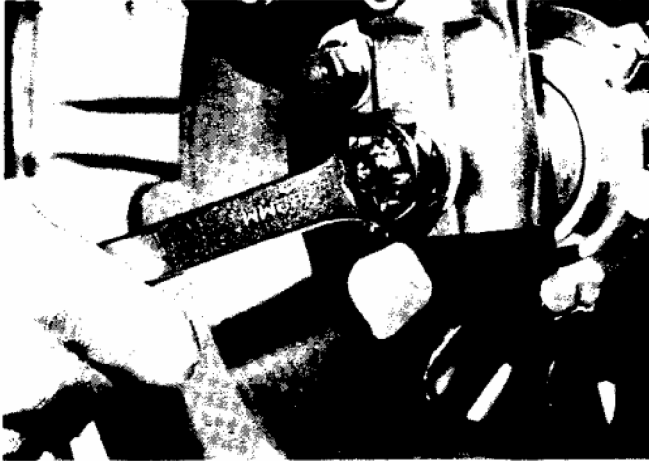


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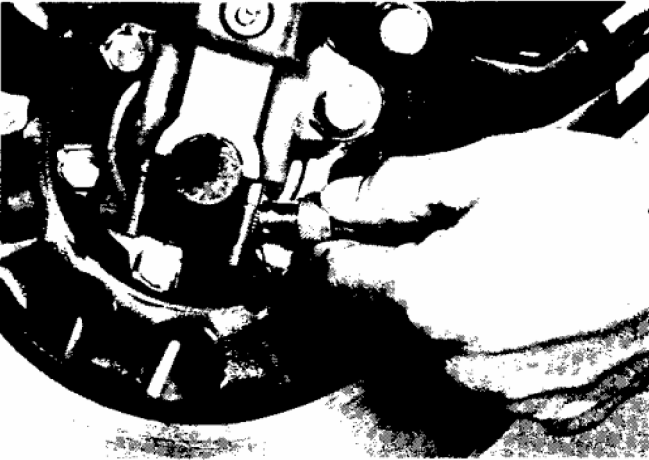
5-1 FRONT WHEEL

A. Removal

1. Remove cotter pin from front axle nut.
2. Remove the front axle nut.



3. Loosen the two axle nut holder nuts at the bottom of the fork leg.
4. Raise the front wheel of the machine by placing suitable stand under the engine.
5. Remove the front wheel axle by simultaneously twisting and pulling out on the axle. Then remove the wheel assembly. The speedometer gear unit housing must be removed.

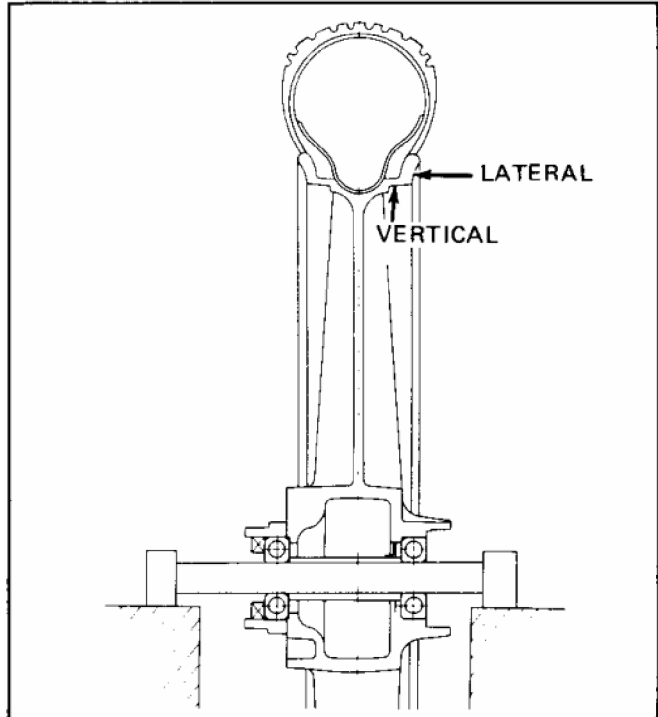


B. Front Axle Inspection

Remove any corrosion from axle with emery cloth. Place the axle on a surface plate and check for bends. If bent, replace axle.

C. Front Wheel Inspection

1. Check for cracks, bends or warpage of wheels. If a wheel is deformed or cracked, it must be replaced.
2. Check wheel run-out. If deflection exceeds tolerance, check wheel bearing or replace wheel as required.



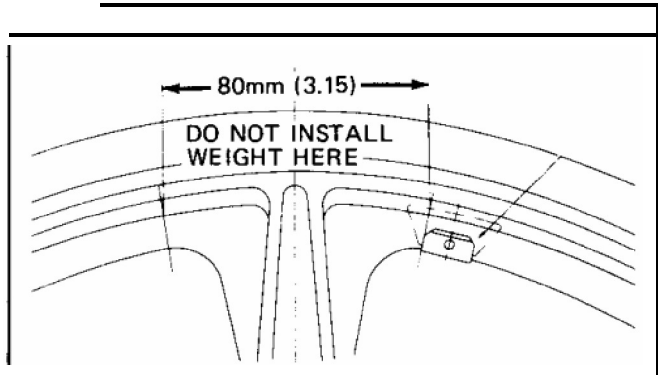
Rim run-out limits:

Vertical -- 2mm (0.08 in.)

Lateral -- 1mm (0.04 in.)

3. Check wheel balance. Rotate wheel lightly several times and observe resting position. If wheel is not statically balanced, wheel will come to rest at the same position. Install balance weight at lighter position (at top) as illustrated.

NOTE: The wheel should be balanced with brake discs installed.



D. Replacing Wheel Bearings

If the bearings allow play in the wheel hub or if wheel does not turn smoothly, replace the bearings as follows:

1. Clean the outside of the wheel hub.
2. Drive the bearing out by pushing the spacer aside and tapping around the perimeter of the bearing inner race with a soft metal drift pin and hammer. The spacer "floats" between the bearings. Both bearings can be removed in this manner.
3. To install the wheel bearing, reverse the above sequence. Be sure to grease the bearing before installation. Use a socket that matches the outside race of the bearing as a tool to drive in the bearing.

CAUTION: Do not strike the center race or balls of the bearing. Contact should be made only with the outer race.

E. Installing Front Wheel

When installing front wheel, reverse the removal procedure. Note the following points:

1. Lightly grease lips of front wheel oil seals and gear teeth of speedometer drive and driven gears. Use lightweight lithium soap base grease.
2. Make sure there is enough gap between disc pads.
3. Check for proper engagement of the boss on the outer fork tube with the locating slot on speedometer gear unit housing.
4. Always secure the front wheel axle as follows:
 - a. Tighten the front axle nut.

Axle nut torque:

8.3~13 m-kg (60~94 ft-lb)

- b. Tighten axle holder nuts. First tighten nut on front end of axle holder, then tighten nut on rear end.

Holder nut torque:

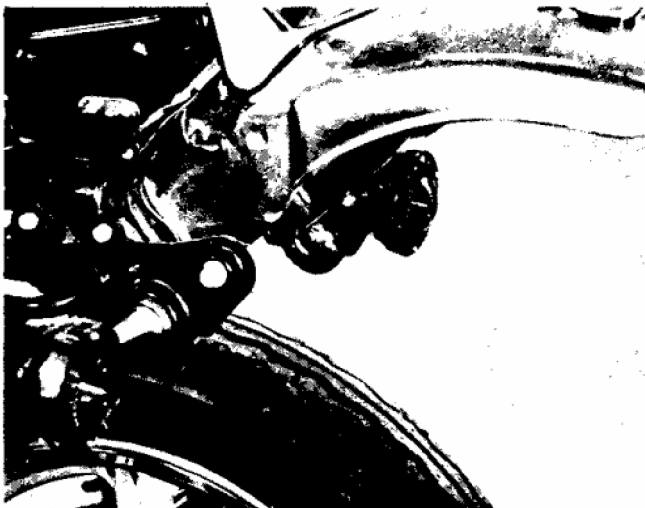
1.1~1.8 m-kg (8.0~13.0 ft-lb)

- c. Install a new cotter pin.

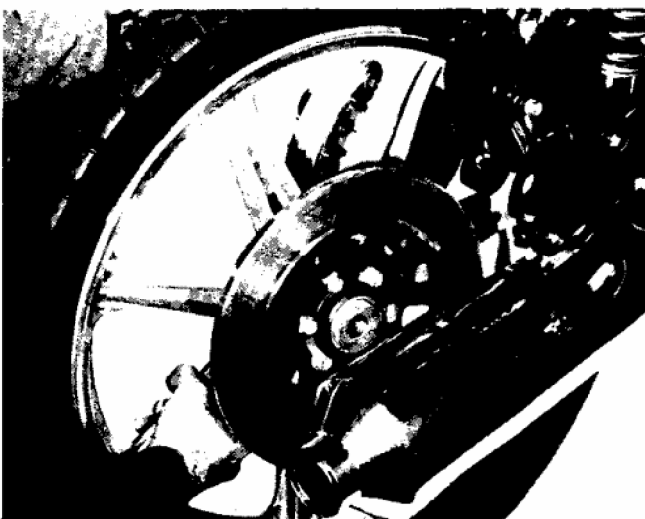
5-2 REAR WHEEL

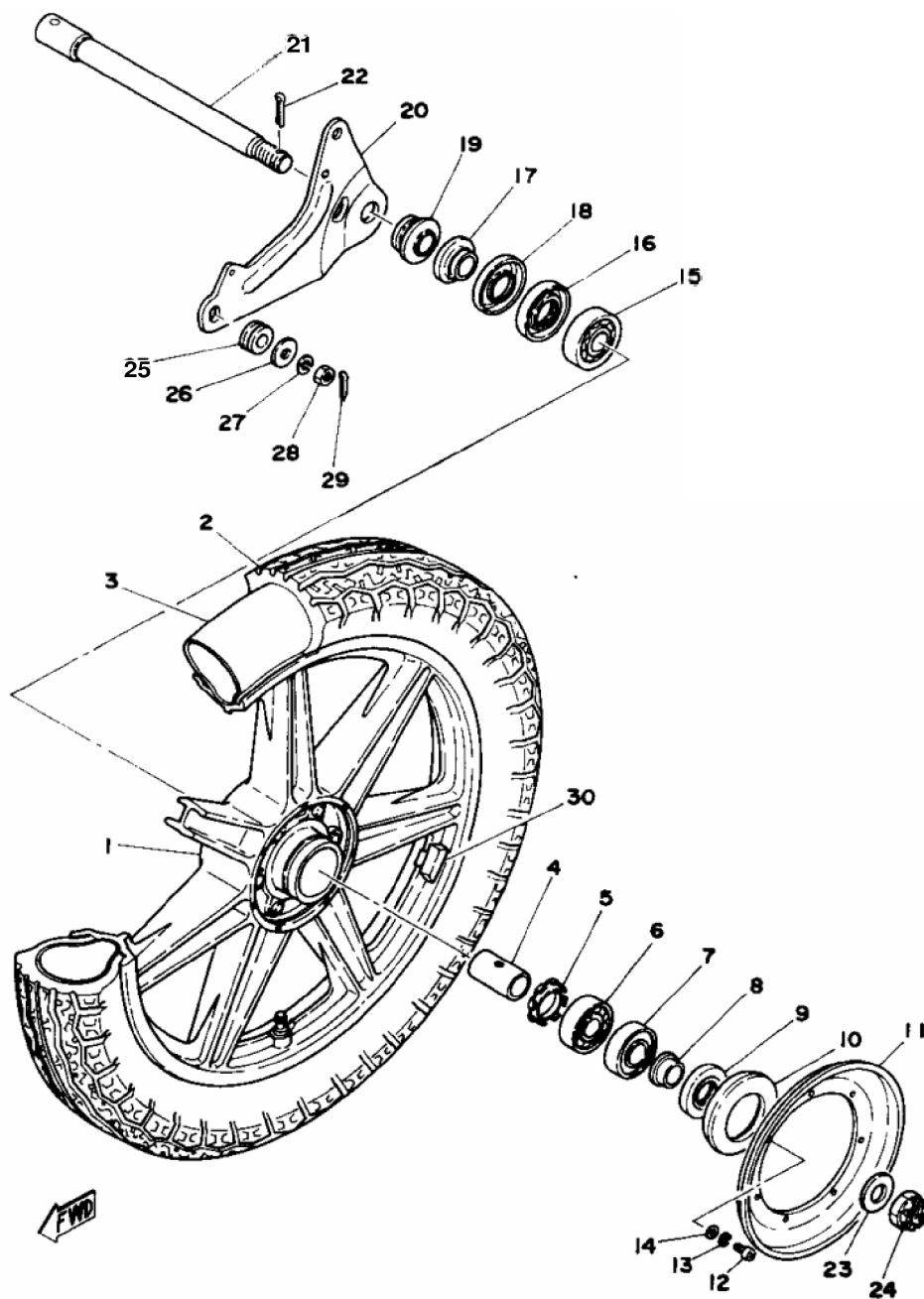
A. Removal

1. Place machine on center stand.
2. Raise the seat. Unscrew rear fender installation bolts until their threaded portion is completely out. Raise fender. Reinsert bolts as stopper to support raised fender.

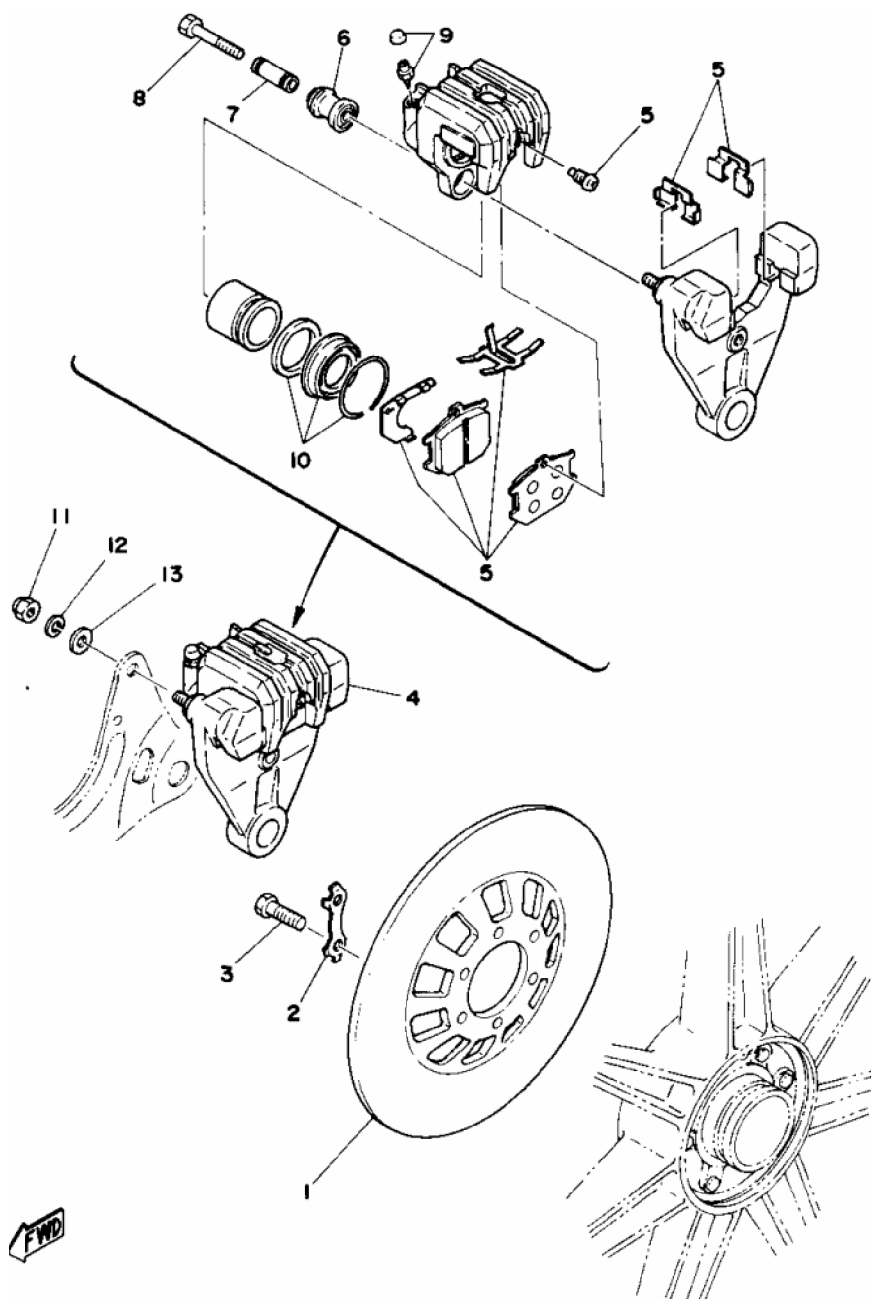


3. Remove the muffler protector.
4. Remove the axle nut cotter pin and the axle nut.
5. Loosen the rear axle pinch bolt.
6. While supporting the brake caliper, pull out the rear axle.
7. Hold up the brake caliper assembly and place it on the hook of the rear arm.
8. Move the wheel to the right side to separate it from the final gear case and remove the rear wheel.

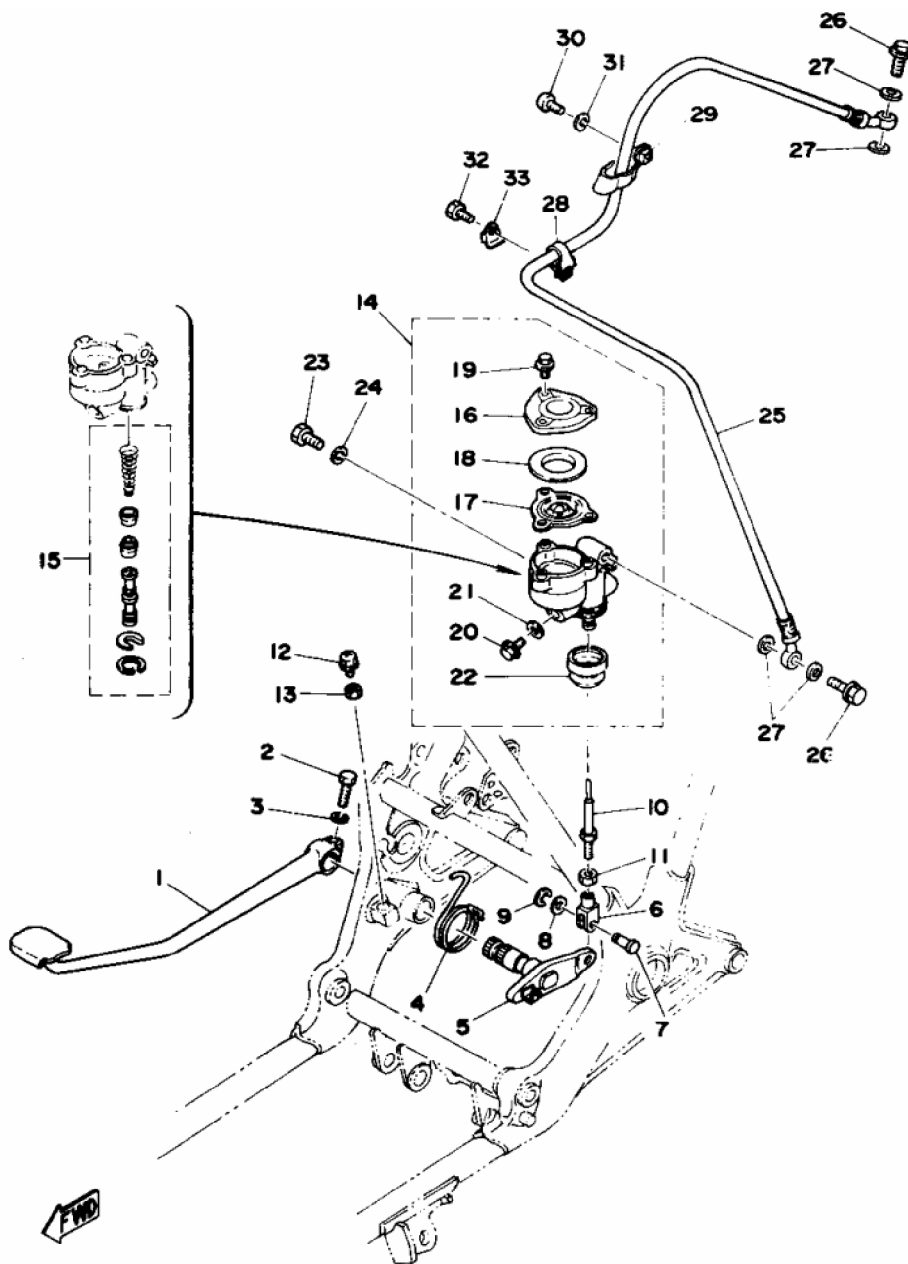




- | | | | |
|----|----------------------------|----|-----------------------|
| 1 | CAST WHEEL, rear (2.15-18) | 16 | OIL SEAL (SO-27-52-5) |
| 2 | TIRE, rear (4.00-18-4PR) | 17 | COLLAR, shaft |
| 3 | TUBE, rear (4.00-18) | 18 | COVER, dust |
| 4 | SPACER, bearing | 19 | COLLAR |
| 5 | FLANGE, spacer | 20 | PLATE, stopper torque |
| 6 | BEARING (B6204) | 21 | SHAFT, wheel |
| 7 | BEARING (B6204RS) | 22 | PIN, cotter |
| 8 | COLLAR | 23 | WASHER, plate |
| 9 | OIL SEAL (SD-25-47-7) | 24 | NUT, shaft |
| 10 | SEAL, dust | 25 | SPACER |
| 11 | COVER, plate dust | 26 | WASHER, plain |
| 12 | SCREW, pan head | 27 | WASHER, spring |
| 13 | WASHER, spring | 28 | NUT, hexagon |
| 14 | WASHER, plate | 29 | PIN, cotter |
| 15 | BEARING (B6304Z) | 30 | BALANCER, wheel |



- 1 DISK, rear brake
- 2 WASHER, lock
- 3 BOLT, hexagon
- 4 CALIPER ASS'Y, rear
- 5 CALIPER PAD KIT
- 6 BUSHING, boot
- 7 SLEEVE
- 8 BOLT, support
- 9 SCREW, bleed with cap
- 10 CALIPER SEAL KIT
- 11 NUT, crown
- 12 WASHER, spring
- 13 WASHER, plate



- | | | | |
|----|-----------------------------|----|-----------------------|
| 1 | PEDAL, brake | 18 | BUSHING, diaphragm |
| 2 | BOLT, hexagon | 19 | BOLT, cap |
| 3 | WASHER, spring | 20 | BOLT, plug |
| 4 | SPRING, torsion | 21 | GASKET |
| 5 | SHAFT, brake pedal | 22 | BOOT, master cylinder |
| 6 | JOINT | 23 | BOLT, hexagon |
| 7 | PIN | 24 | WASHER, spring |
| 8 | WASHER, plate | 25 | HOSE, rear brake |
| 9 | CIRCLIP (E-6) | 26 | BOLT, union |
| 10 | ROD, brake | 27 | WASHER, plain |
| 11 | NUT, hexagon | 28 | CLAMP 1 |
| 12 | SCREW | 29 | CLAMP 2 |
| 13 | NUT, adjusting | 30 | SCREW, pan head |
| 14 | MASTER CYLINDER ASS'Y, rear | 31 | WASHER, spring |
| 15 | CYLINDER KIT, master | 32 | BOLT |
| 16 | CAP, reservoir | 33 | WASHER, lock |
| 17 | DIAPHRAGM, reservoir | | |

NOTE: Do not depress the brake pedal when the wheel is off the machine so that the caliper piston is not forced out of the cylinder.

9. To install the rear wheel, reverse the removal procedure.

B. Rear Axle Inspection

(See Front Wheel, Axle Inspection Procedure.)

C. Replacing Wheel Bearings

Rear wheel bearing replacement is similar to the procedure for the front wheel.

D. Rear Wheel Inspection

(See Front Wheel, Inspection Procedures.)

E. Installing Rear Wheel

1. Lightly grease lips of rear wheel oil seals.
2. Make sure the brake pads are installed properly and that there is enough gap to install the rear disc.
3. Install wheel assembly and axle.

NOTE: When installing the rear wheel, be sure the splines on the wheel hub fit into the final gear case.

Always use a new cotter pin on the axle nut.

Torque:

Axle nut: 12~18 m·kg (87~130 ft·lb)

Axle pinch bolt: 0.45~0.75 m·kg (3~5 ft·lb)

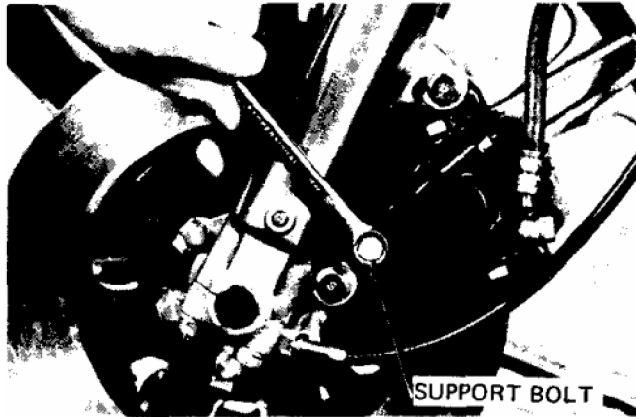
5-3 BRAKES

CAUTION: Disc brake components rarely require disassembly. Do not disassemble components unless absolutely necessary. If any hydraulic connection in the system is opened, the entire system should be disassembled, drained, cleaned and then properly filled and bled upon reassembly.

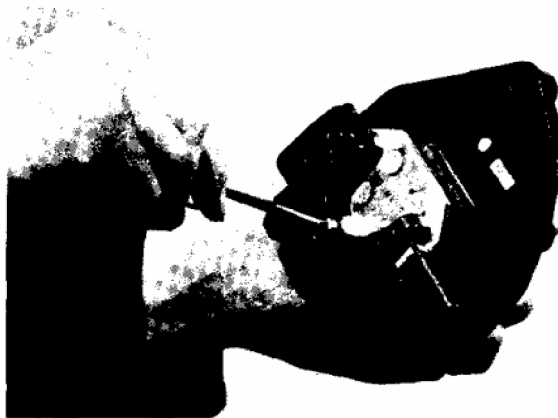
CAUTION: Do not use solvents on brake internal components. Solvents will cause seals to swell and distort. Use only clean brake fluid for cleaning. Use care with brake fluid. Brake fluid is injurious to eyes and will damage painted surfaces.

A. Caliper Pad Replacement

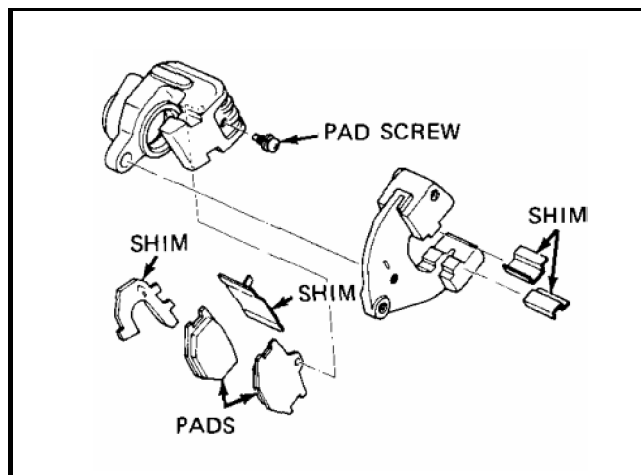
1. It is not necessary to disassemble the brake fluid hoses to replace the brake pads.
2. Remove the caliper support bolt.

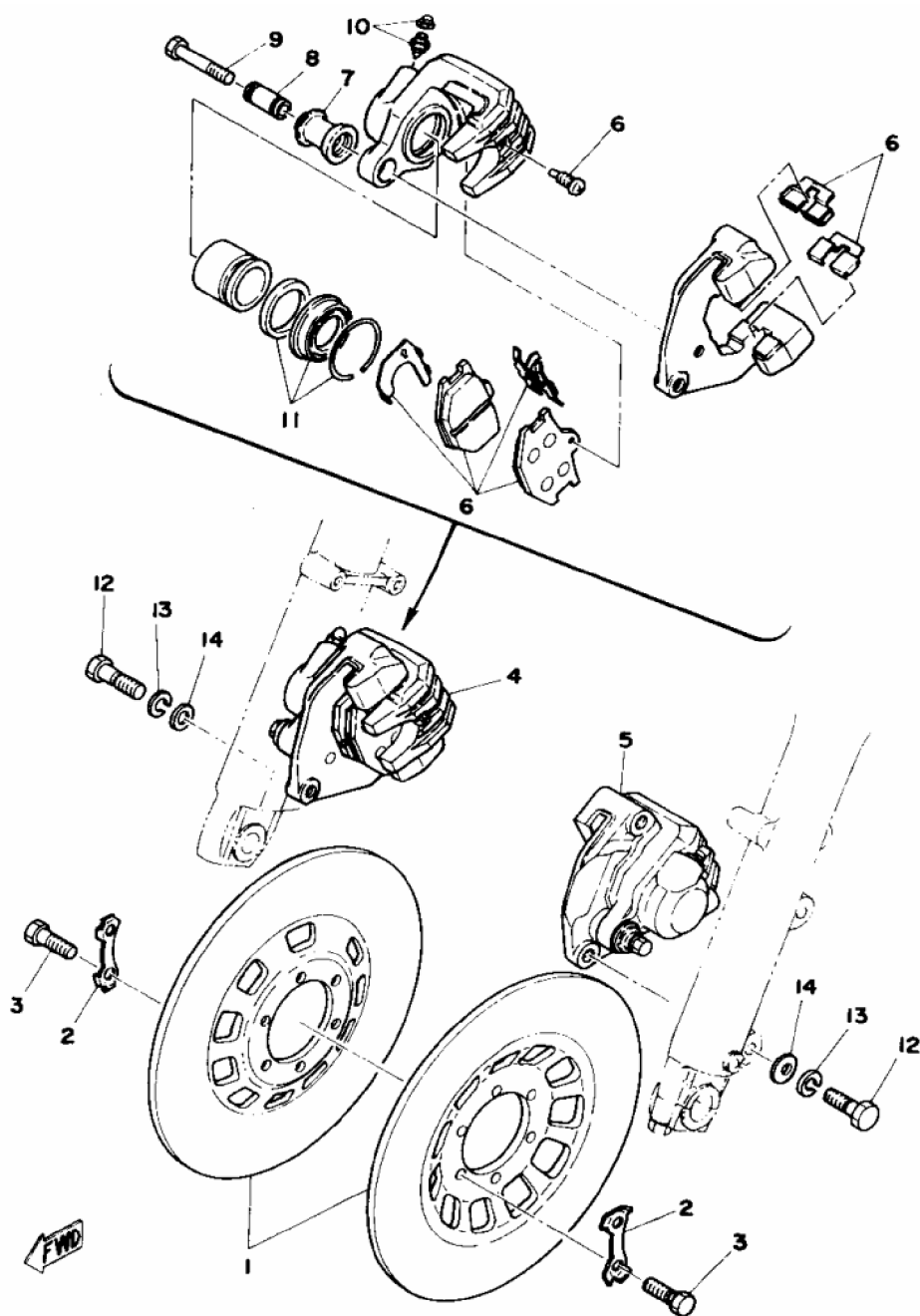


3. Remove the Phillips screw that holds the brake pads.



4. Pull caliper cylinder off caliper frame.
5. Install new brake pads. Replace pads as a set. Replace the following when pads are replaced:

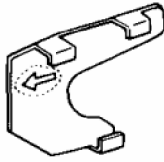




- 1 DISK, front brake
- 2 WASHER, lock
- 3 BOLT, hexagon
- 4 FRONT CALIPER ASS'Y, right
- 5 FRONT CALIPER ASS'Y, left
- 6 CALIPER PAD KIT
- 7 BUSHING, boot (with grease)
- 8 SLEEVE
- 9 BOLT, support
- 10 SCREW, bleed with cap
- 11 CALIPER SEAL KIT
- 12 BOLT, hexagon
- 13 WASHER, spring
- 14 WASHER, plate

6. Lightly grease the surface of the shim that contacts the pad. Bend each tab of the shim over the brake pad. The arrow on the shim must be in the turning direction of the wheel.

ARROW IN ROTATING
DIRECTION OF WHEEL



B. Caliper Disassembly (Front and Rear)

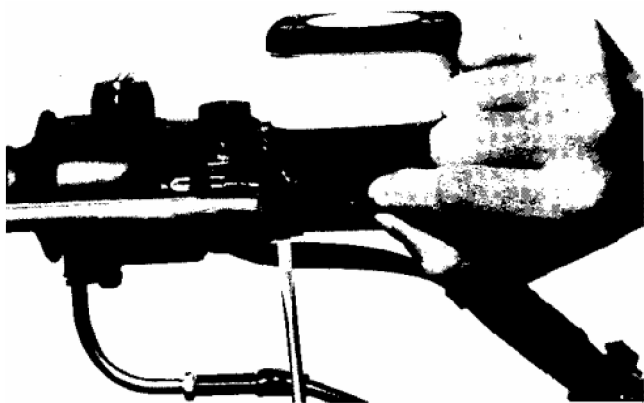
1. Remove caliper brake hose. Allow caliper assembly to drain into a container.
2. Place the open hose end into the container and pump the old fluid out.
3. Remove caliper support bolt and pad securing screw as in Caliper Pad Replacement procedure.
4. Remove caliper assembly from caliper frame.
5. Remove retaining ring and dust seal.
6. Carefully force the piston out of the caliper cylinder with compressed air. Never try to pry out the piston.

CAUTION: Cover the piston with a rag. Use care so that piston does not cause injury as it is expelled from the cylinder.

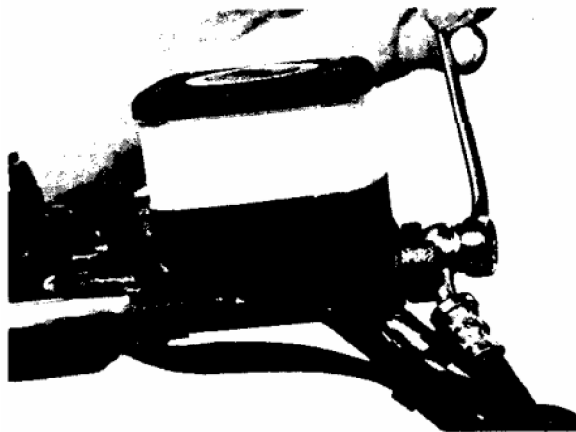
7. Remove piston seal.

C. Master Cylinder Disassembly

1. Front
 - a. Disconnect brake light wire.



- b. Remove brake lever and spring.
- c. Remove brake hose.



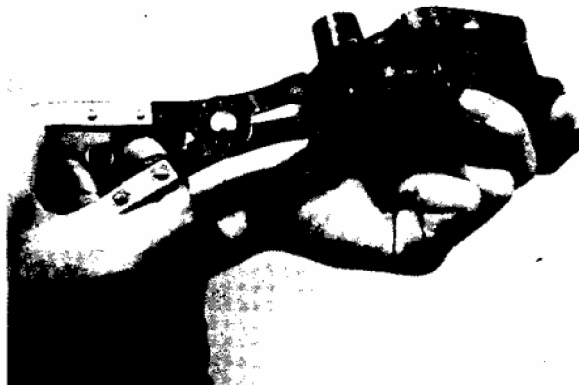
- d. Remove master cylinder from handlebars. Remove cap and drain remaining fluid.

2. Rear

- a. Remove brake hose.
- b. Remove two (2) bolts holding master cylinder to frame. Remove reservoir cap and drain brake fluid.

NOTE: The following steps 3 and 5 apply to both front and rear systems.

3. Remove master cylinder dust boot,
4. Remove snap ring.



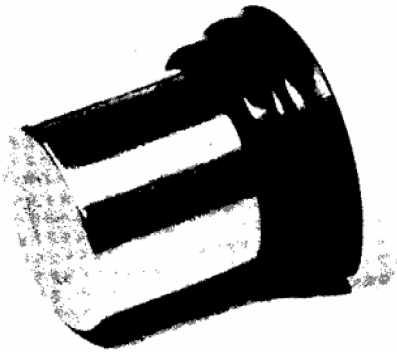
5. Remove master cylinder cup assembly. Note that the cylinder cups are installed with the larger diameter (lips) inserted first.

D. Brake Inspection and Repair

Recommended Brake Component Replacement Schedule:

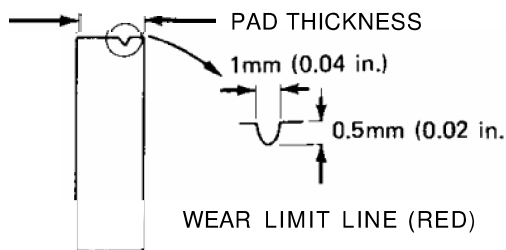
Brake pads.	As required
Piston seal, dust seal	Every two years
Brake hoses.	Every four years
Brake fluid	Replace only when brakes are disassembled

1. Replace caliper piston if it is scratched.



2. Replace any brake pad worn beyond limits.
Replace brake pads as a set.

CHECK WEAR ON DISC BRAKE PAD

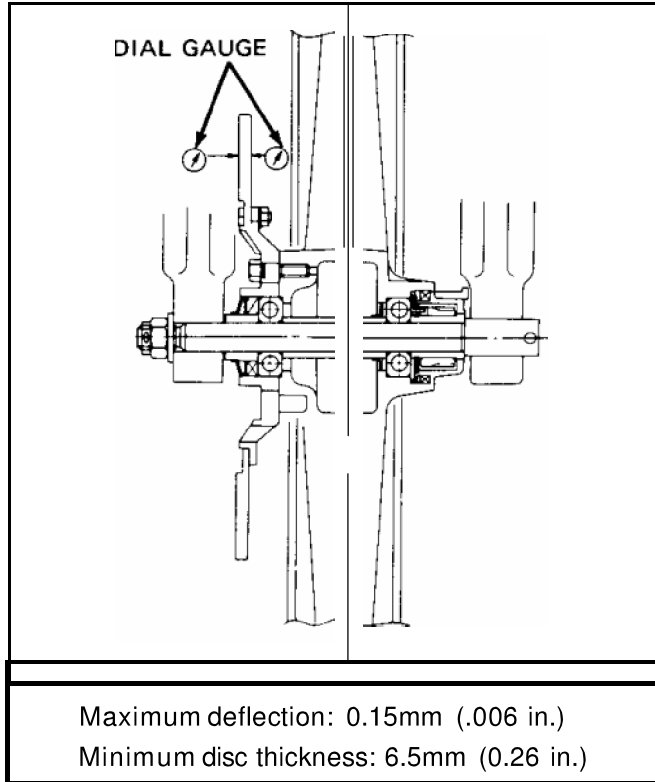


Wear limit: front and rear
5.5mm (0.18 in.)

See Caliper Pad Replacement procedure for parts to be replaced when pads are replaced.

3. Replace piston and dust seals if damaged. Replace seals every two years.
4. Inspect master cylinder body. Replace if scratched. Clean all passages with new brake fluid.
5. Inspect brake hoses. Replace every four years or if cracked, frayed or damaged.

6. Check for wear and deflection of disc (front and rear).

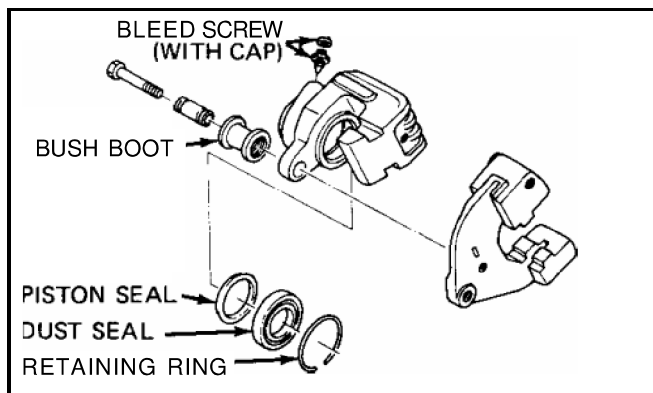


If disc is worn beyond minimum thickness or deflection exceeds specified amount, replace disc.

E. Brake Reassembly

1. All internal parts should be cleaned in new brake fluid. Internal parts should be lubricated with brake fluid when installed.
2. Caliper Reassembly

Replace the following parts whenever a caliper is disassembled: bleed screw and cap, boot bushing, piston seal, dust seal, retaining ring.

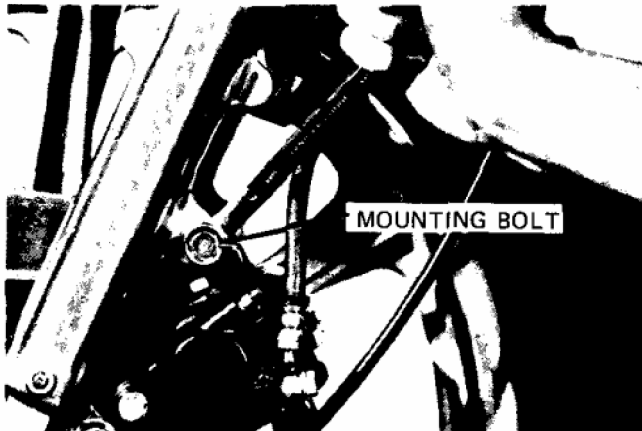


- a. Install piston seal and piston. Place caliper cylinder into caliper frame.

- b. Install pad spring, shim (with arrow) and retainer. The shim arrow is in the direction of wheel rotation. Install dust seal and clip.

- c. Install pad spring and pads,

- d. Install support bolt and remount caliper on brackets.



Support bolt torque:

1.5~2.0 m-kg (11~15 ft-lb)

Mounting bolt torque:

4.5~5.0 m-kg (28~35 ft-lbs)

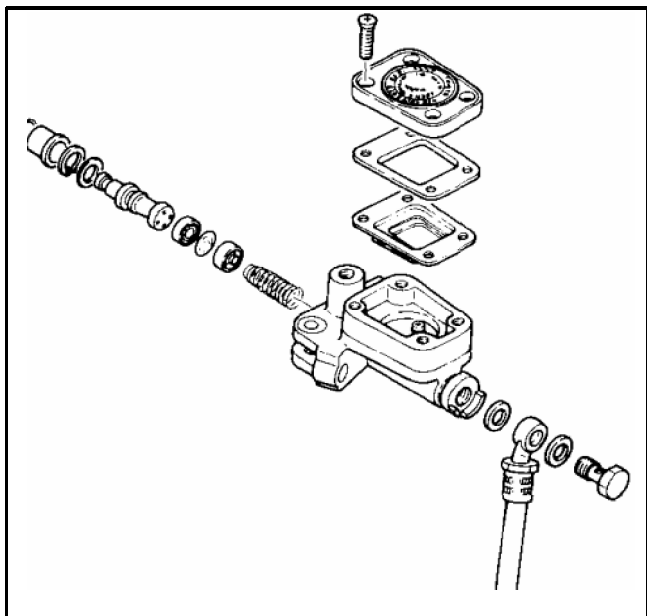
3. Attach brake hoses (front and rear).

Brake hose torque:

2.3~2.8 m-kg (16~20 ft-lbs)

4. Master Cylinder Reassembly

Reassemble master cylinder as shown in illustration.



Brake hose torque: (all brake union bolts)
2.3~2.8 m-kg (16~20 ft-lbs)

5. Brake Disc Assembly

If brake disc has been removed from hub or is loose, tighten bolts. Use new locking washers and bend over locking tabs after bolts are tightened.

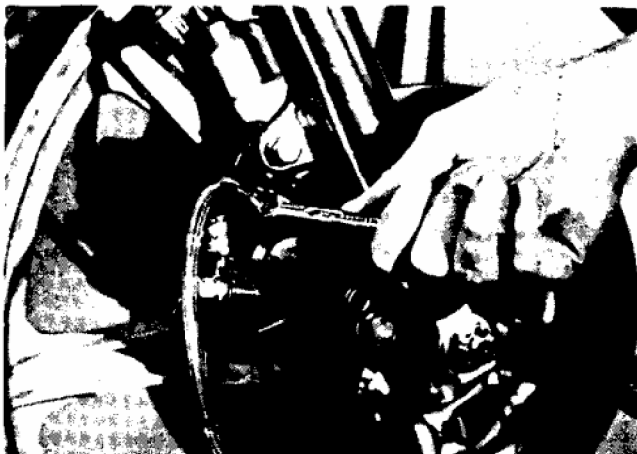
Disc bolt torque:

1.7~2.2 m-kg (12~16 ft-lbs)

6. Air Bleeding

CAUTION: If the brake system is disassembled or if any brake hose has been loosened or removed, the brake system must be bled to remove air from the brake fluid. If the brake fluid level is very low or brake operation is incorrect, bleed the brake system.

1. Add proper brake fluid to the reservoir. Install the diaphragm, being careful not to spill or overflow the reservoir.
2. Connect the clear plastic tube tightly to the caliper bleed screw. Put the end of the tube into a container.



3. Slowly apply the brake lever or pedal several times. Pull in lever (push down pedal). Hold lever or pedal in "on" position. Loosen bleed screw. Allow the pedal or lever to travel slowly toward its limit. When the limit is reached, tighten bleed screw.
4. Continue step 3 until all air bubbles are removed from system.

NOTE: If bleeding is difficult, it may be necessary to let the brake system stabilize for a few hours. Repeat bleeding procedure.

5-4 WHEELS, TIRES, TUBES

A. Wheel Inspection

Wheels should be inspected frequently. Wheel run-out and balancing is discussed in Chapter 5-1. In addition, wheels must be carefully inspected for small cracks, bends or warpage. Any wheel damaged or beyond specified limits should be replaced. Do not attempt to straighten a bent wheel.

WARNING: XS750D aluminum wheels are not designed for use with tubeless tires.

B. Tire, Tube Removal

1. Remove valve cap, valve core and valve stem lock nut.
2. When all air is out of tube, separate tire bead from rim (both sides) by stepping on tire with your foot.
3. Use two (2) wide, flat tire irons with rounded edges to work the tire bead over the edge of the rim, starting 180° opposite the tube stem. Be careful not to pinch the tube as you do this.
4. After you have worked one side of the tire completely off the rim, slip the tube out. Be very careful not to damage the stem while pushing it back out of the rim hole.

NOTE: If you are changing the tire itself, then finish the removal by working the second bead off the rim.

C. Installation

Reinstall the tire and tube by reversing the disassembly procedure. After the tube has been installed, but before the tire has been completely slipped onto the rim, put a small amount of air into the tube. This removes any creases that might exist. Release the air and continue with reassembly. After the tire has been completely slipped onto the rim, make sure the stem comes out of the hole in the rim at a right angle to the rim. Finally, inflate the tire.

	Front Tire	Rear Tire
Normal riding	1.8 kg/cm ² (26 psi)	2.0 kg/cm ² (28 psi)
Continued high speed riding or riding with passenger	2.0 kg/cm ² (28 psi)	2.3 kg/cm ² (33 psi)

NOTE: Make sure the wheel is balanced every time the tire is replaced. (Refer to Front Wheel Inspection.)

5-5 FRONT FORKS

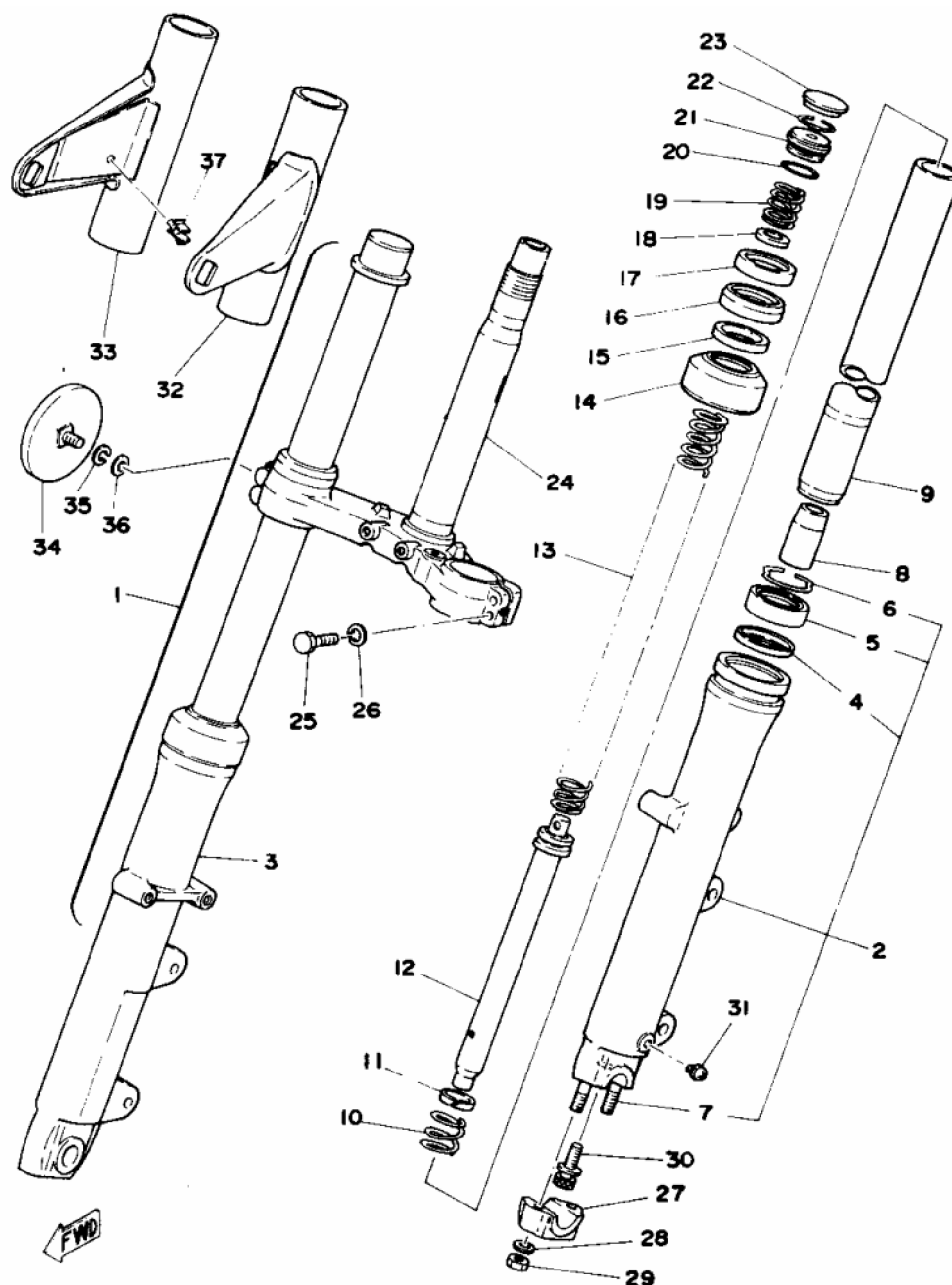
A. Removal and Disassembly

1. Disconnect speedometer cable. Disconnect brake calipers and remove front wheel. Place wooden wedge or other object into caliper assemblies to keep brake pads from falling out. Remove front fender.
2. Loosen pinch bolts on steering stem and crown and remove fork.
3. Remove fork tube caps, spring clips, spring stopper seats, and oil drain screws. Drain fork oil.
4. Remove Allen bolt from bottom of fork assembly. Pull inner tube out of outer tube.



5. To remove fork seal, pull off dust cover. Remove spring clip over oil seal. Pry out oil seal, being careful to not damage the fork tube.





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|----|----------------------------|----|---------------------|----|---------------------------|
| 1 | FRONT FORK ASS'Y | 14 | SEAL, dust | 27 | HOLDER, axle |
| 2 | FORK TUBE, outer left | 15 | GASKET | 28 | WASHER, plate |
| 3 | FORKTUBE, outer right | 16 | GUIDE, cover under | 29 | NUT, nylon |
| 4 | SEAL, spacer | 17 | GUIDE, cover upper | 30 | BOLT, hexagon socket head |
| 5 | OILSEAL | 18 | SEAT, spring upper | 31 | SCREW, drain |
| 6 | STOPPER RING, oil seal | 19 | SPRING | 32 | COVER, upper left |
| 7 | BOLT, stud | 20 | O-RING | 33 | COVER, upper right |
| 8 | PIECE, oil lock | 21 | SEAT, spring | 34 | REFLECTOR |
| 9 | INNER TUBE COMP. | 22 | RING, stopper | 35 | WASHER, spring |
| 10 | SPRING, rebound | 23 | CAP, front fork | 36 | WASHER, plain |
| 11 | RING, front fork piston | 24 | UNDER BRACKET COMP. | 37 | CLAMP |
| 12 | CYLINDER COMP., front fork | 25 | BOLT | | |
| 13 | SPRING, front fork | 26 | WASHER, spring | | |