

Engine Rebuild: Assembly Sequence From Green Flag Motorsports

Suggested Sequence	Operation - assemble	Tool	Description
Step 1 (see figure1)	(after following operation for sealing case halves) carefully insert crank assembly into a case half - light oil can be used for ease of fit place other case half over crank assembly tap case(s) together to form a square seal at the interface		
Step 2	install primary & secondary shaft as one unit - be sure both lower shifter forks are aligned correctly the respective gears - upper fork can be installed when both shafts are secure in case - replace pivot shafts for shifter forks making sure the fork(s) pivot freely on shaft(s) loose assemble (17) crankcase screws install ignition & clutch side seals	standard	6mm hex wrench
Step 3 (see figure 3)	replace cylinder - install new gasket if required lightly lube & start cyl over piston by tilting slightly forward to close ring gap allowing cyl to slip over piston - loose assemble (4) cylinder nuts item - rotate crank asm to center & tighten nuts at this point loosen all cylinder nuts, now tighten all case screws (this allows case halves & cylinder to mount flush) re-tighten cylinder nuts	standard	6mm hex wrench
Step 4 (see figure 4)	install stator plate loose assemble (3) stator plate screws	standard	5mm hex wrench
Step 5 (see figure 5)	install PVL rotor install key, rotor & rotor nut using spanner to hold crankshaft while tightening	standard/ special	spanner & 17mm 17mm socket
Step 6 (see figure 6)	install drive gear on crank spline ensuring that gear is in proper position install 20mm snap ring	standard	snap ring pliers
Step 7 (see figure 7)	install clutch cover with gasket install (10) clutch cover screws	standard	5mm hex wrench
Step 8 (see figure 8)	install thrust washer on primary shaft install clutch hub install clutch hub spacer install clutch hub nut	standard/ special	spanner / 20mm socket
Step 9 (see figure 9)	install clutch plates - start with friction then alternate steel/friction install (5) pressure plate springs & nuts	standard	13mm socket
	<i>time engine to mfg specs</i>		

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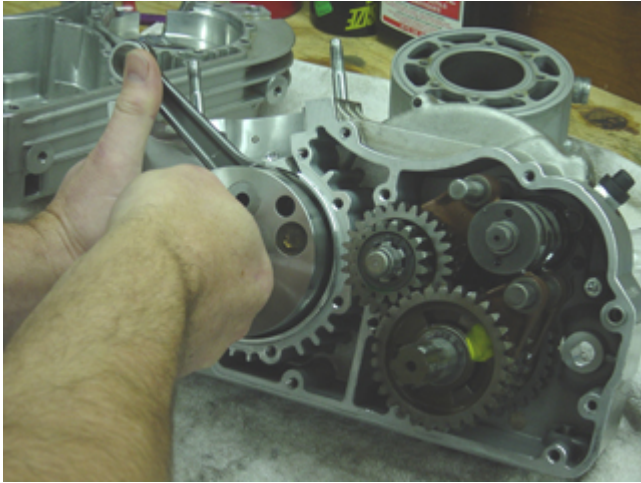


Figure 1



Figure 3

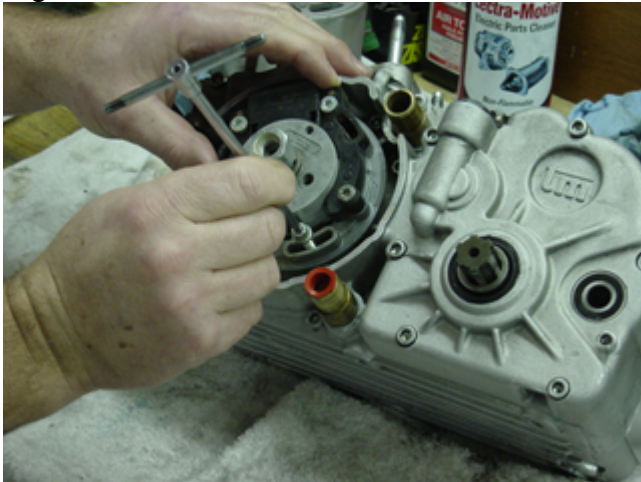


Figure 4



Figure 5



Figure 6



Figure 7

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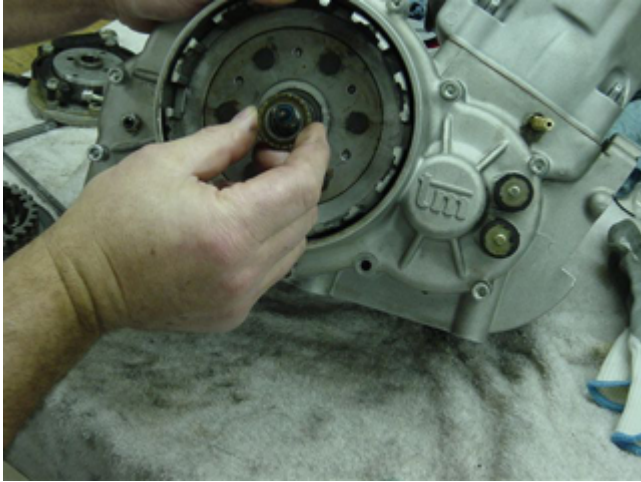


Figure 8



Figure 9