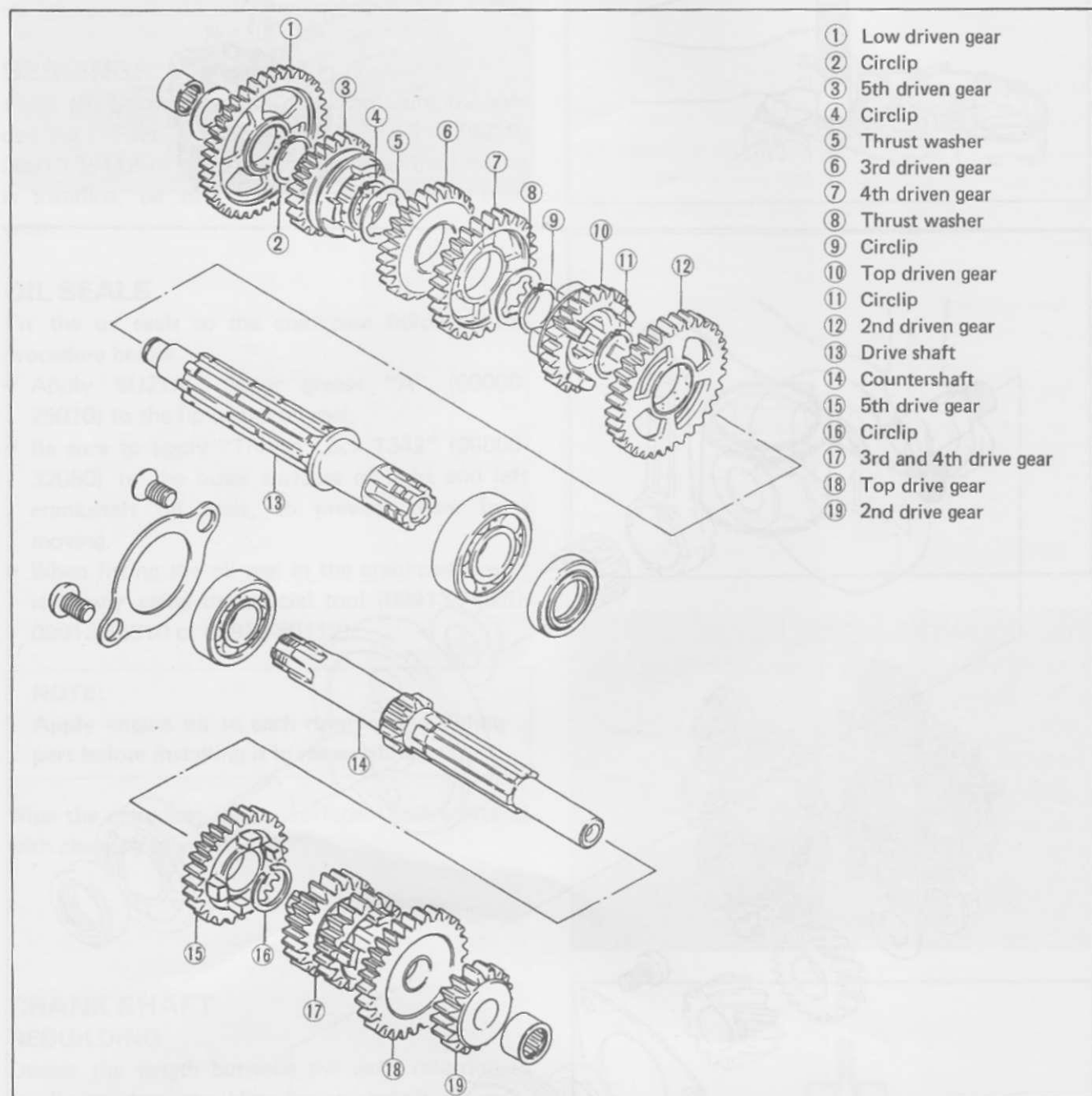


TRANSMISSION

In reassembling the transmission, attention must be given to the locations and positions of washers and circlips. The expanded view given here will serve as a reference for correctly mounting the gears, washers and circlips.

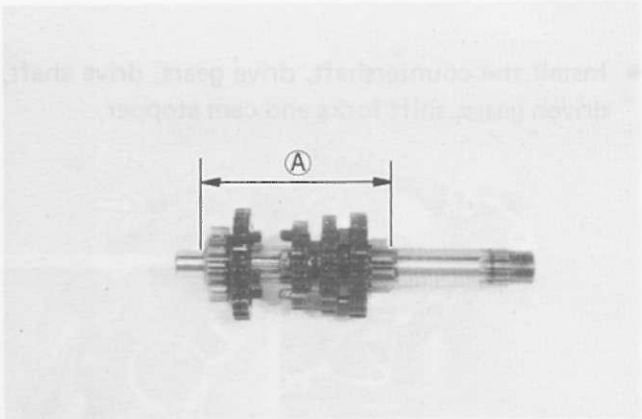


CAUTION:

- * Never reuse a circlip, after a circlip has been removed from a shaft, it should be discarded and a new circlip must be installed.
- * When installing a new circlip, care must be taken not to expand the end gap larger than required to slip the circlip over the shaft.
- * After installing a circlip, always insure that it is completely seated in its groove and securely fitted.

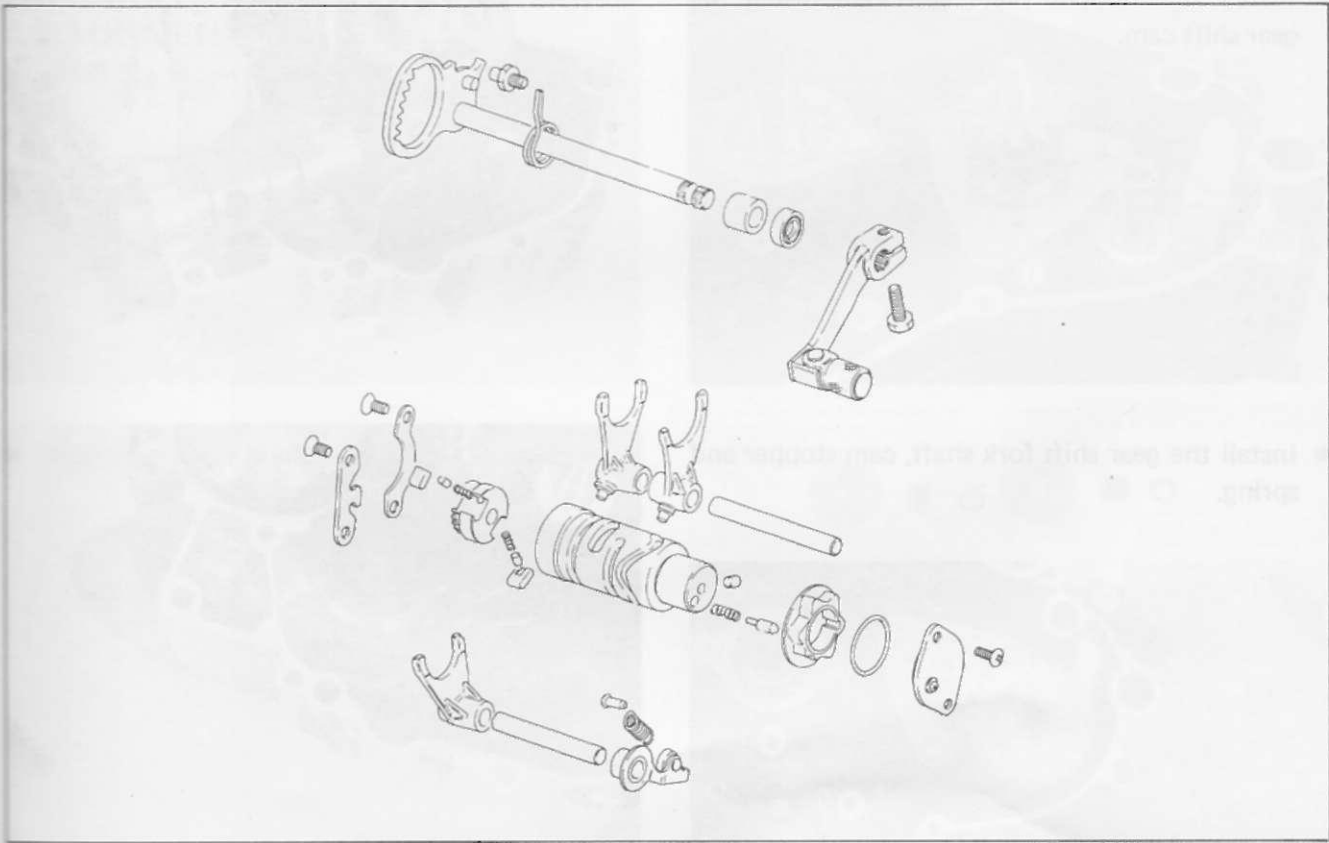
The 2nd drive gear ① has been press-fitted into the counter shaft. Remove it using a hydraulic press.
 Before reassembling, coat the internal face of the 2nd drive gear with thread lock "1303B" and install so that the length ② is 84.5 – 84.6 mm.

S.T.D.	84.5 – 84.6 mm
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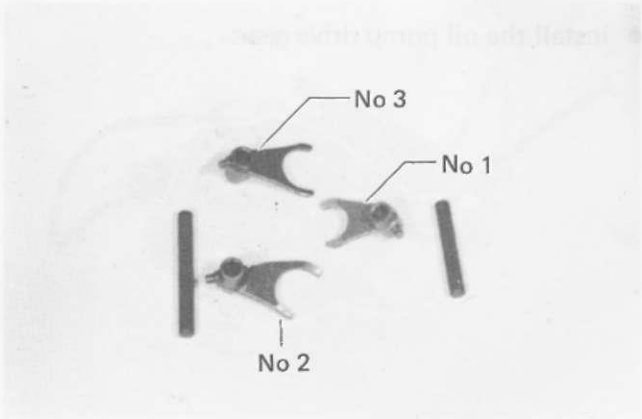


GEAR SHIFT MECHANISM

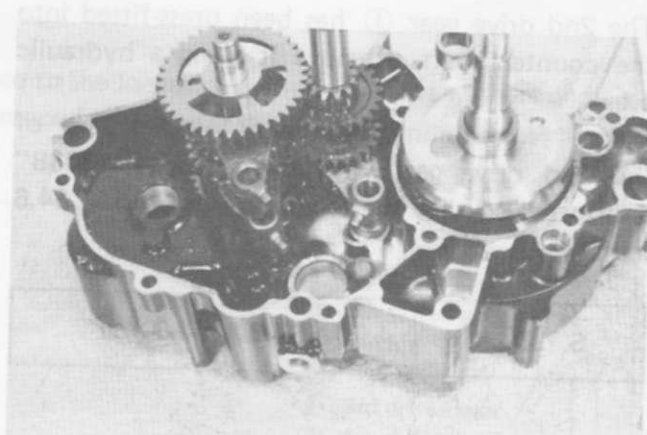
The exploded view of the mechanism given in Fig. serves as reference for reassembly work.



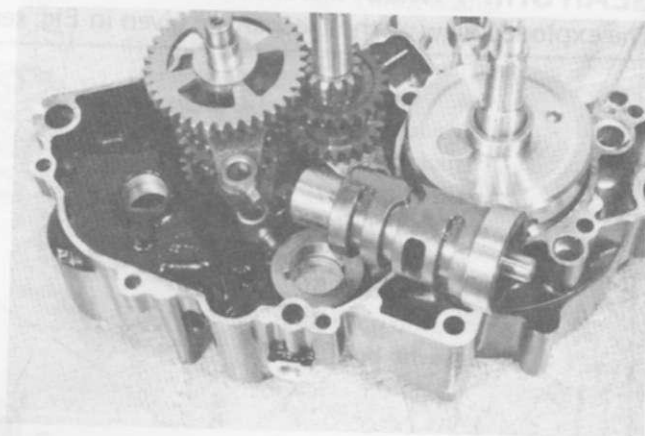
Three kinds of different forks are used, refer to Fig. When reinstalling gear shift forks; No. 1, No. 2 and No. 3.



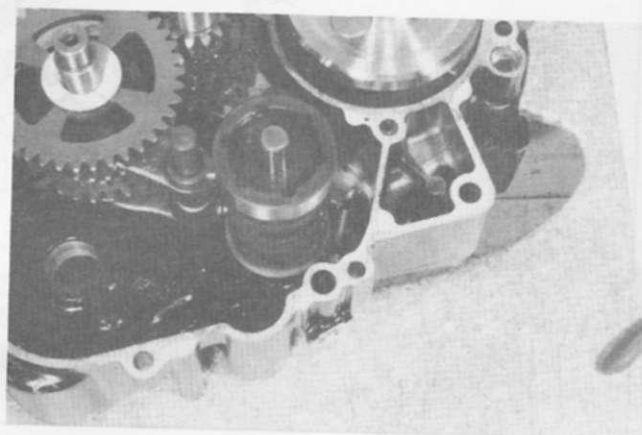
- Install the countershaft, drive gears, drive shaft, driven gears, shift forks and cam stopper.



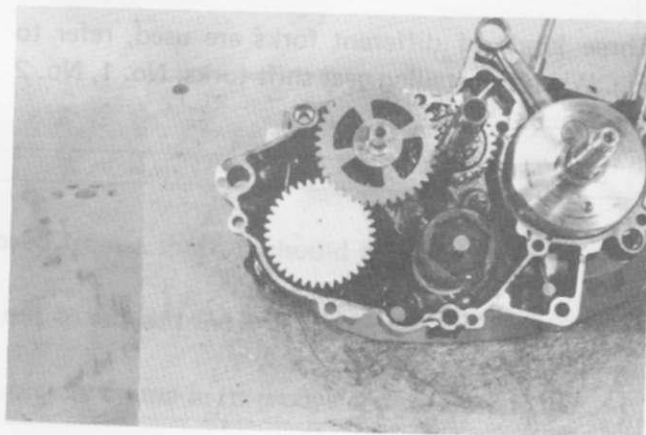
- Install the stopper plate and then install the gear shift cam.



- Install the gear shift fork shaft, cam stopper and spring.



- Install the oil pump drive gear.



CAUTION:

- Never turn the crankshaft by hand. The crankshaft must be turned by the flywheel.
- When installing a new oil pump, the pump must be turned to the position of the crankshaft.
- After installing a circlip, always ensure that it is seated.

CRANK CASE

- Install the two O-ring and two dowel pins.
- Coat one of a pair with SUZUKI Bond No. 1207B, just before assembling the crankcase.

NOTE:

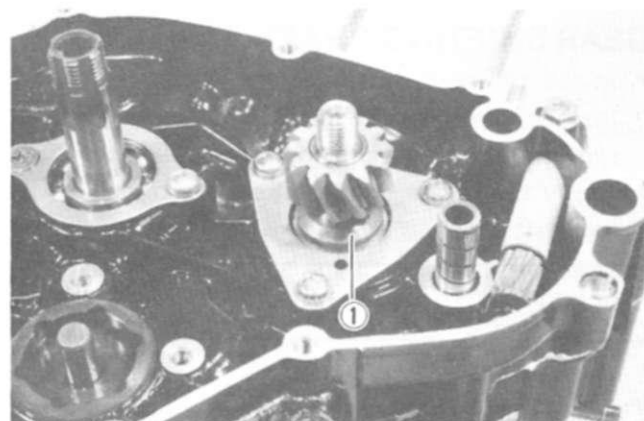
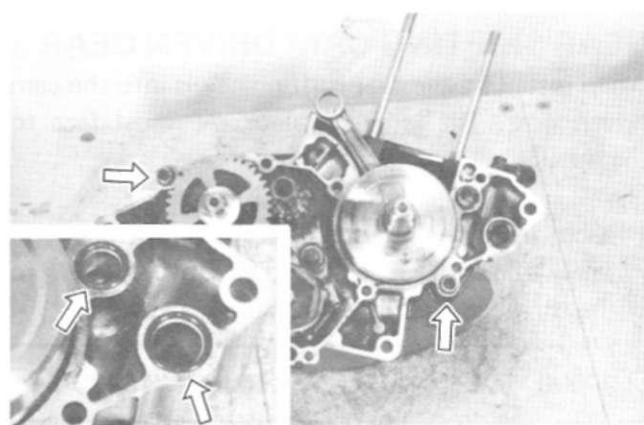
- * Spread on surface thinly to form an even layer and assemble the cases within few minutes.

99000 - 31140

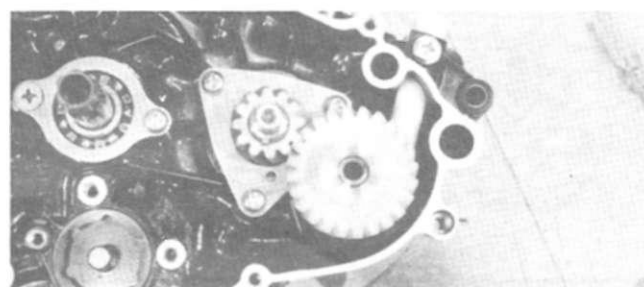
SUZUKI BOND NO. 1207B

PRIMARY GEAR, WATER PUMP DRIVE AND DRIVEN GEAR

- Install the spacer ① and water pump drive gear.



- Install the water pump driven gear assembly.



- Install the key, primary gear and nut.
- Tighten the primary gear nuts by using the special tool.

Tightening torque

40 – 60 N·m
(4.0 – 6.0 kg-m)

09910 - 20116

Conrod stopper

