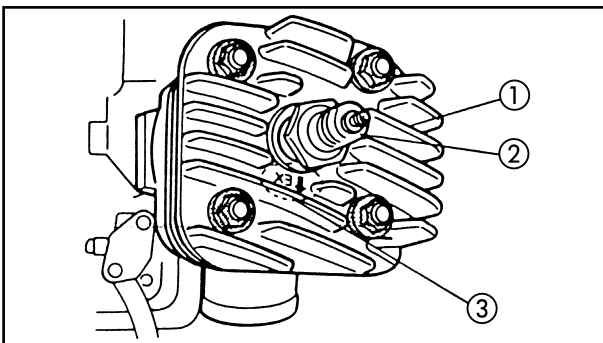


3. Install:
- Cylinder ①

NOTE:

Install the cylinder with one hand while compressing the piston rings with the other.



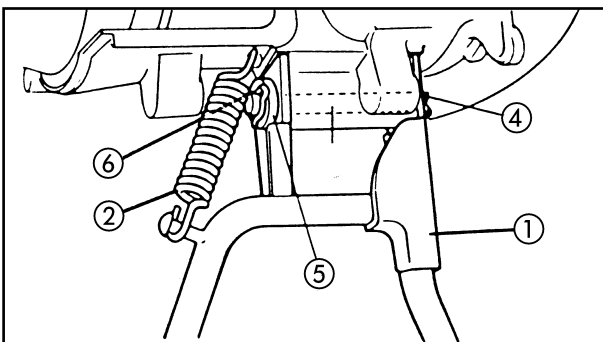
4. Install:
- Cylinder head gasket (new gasket)
5. Install:
- Cylinder head ①
 - Spark plug ②
 - Air protector

NOTE:

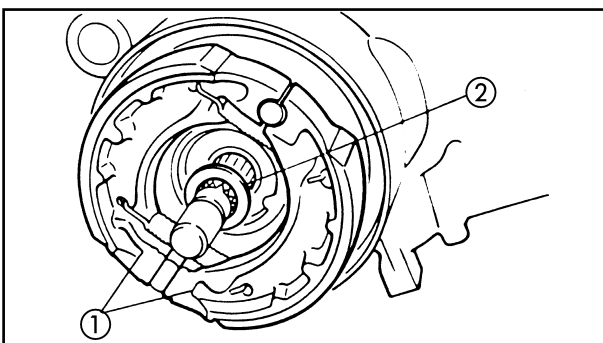
- The arrow ③ “EX” from the cylinder head should point to the exhaust side.
- Tighten the cylinder head positioning nuts in several steps, using a *cris-cross pattern*



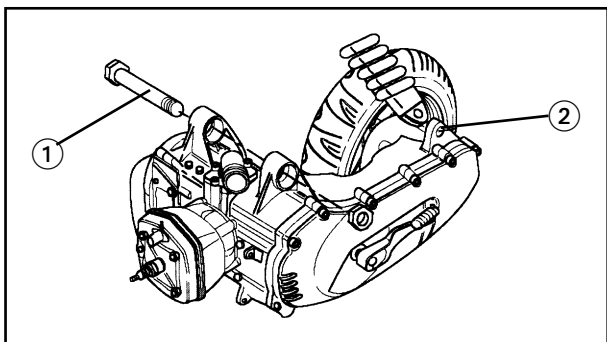
Cylinder head positioning screws
 1.4 m • kg
 spark plug
 2.0 m • kg



6. Install:
- Central stand ①
 - Spring ②
 - Axle ③
 - Clasp ④
 - Rubber washer ⑤
 - Strap loop ⑥



7. Install:
- Brake shoes ①
 - Flat washer ②
 - Rear wheel



ASSEMBLY OF ENGINE

When the engine is being assembled, reverse the removal procedure

1. Install:
 - Engine assembly bolt ①
 - Rear shock absorber bolt ② (lower)



Engine assembly bolt
8.4 m • kg
Rear shock absorber bolt (lower)
1.8 m • kg

2. Install:
 - Carburettor
 - Oil supply pipe
 - Fuel pipes
 - Air filter box assembly

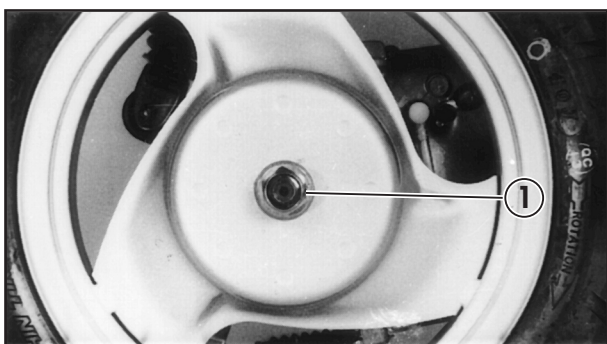
NOTE:

- Align the projection of the carburettor with the projections of the head
- Before installing the oil supply pipe, fill it with oil.

3. Install:
 - Oil pipe
 - Oil supply pipe

NOTE:

Pass the oil supply pipe and the oil pipe through as shown.



4. Bleed the air:
 - Autolubrication pump
Consult chapter 3, section – “BLEEDING OF AIR FROM THE AUTOLUBRICATION PUMP”.

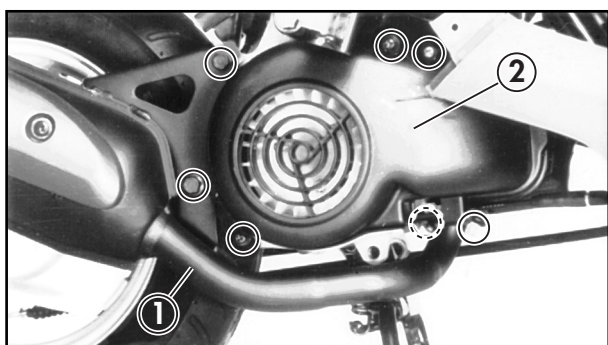
5. Tighten:
 - Rear wheel axle nut ①

NOTE:

When the rear wheel axle nut is tightened, apply the rear brake.



rear wheel axle bolt
12.5 m • kg



6. Install:
- Silencer ①
 - Fan cover ②

	Bolt (silencer)
	2.6 m • kg
	Bolt (exhaust pipe)
	0.9 m • kg

7. Apply:
- Transmission oil.
See chapter 3 section - “CHANGING TRANSMISSION OIL”.
8. Adjust:
- Free play of brake levers.
See chapter 3, section - “ADJUSTMENT OF FREE PLAY OF FRONT/REAR BRAKE LEVER”.
 - Free play of accelerator cable See section “ADJUSTMENT OF FREE PLAY OF ACCELERATOR CABLE”.

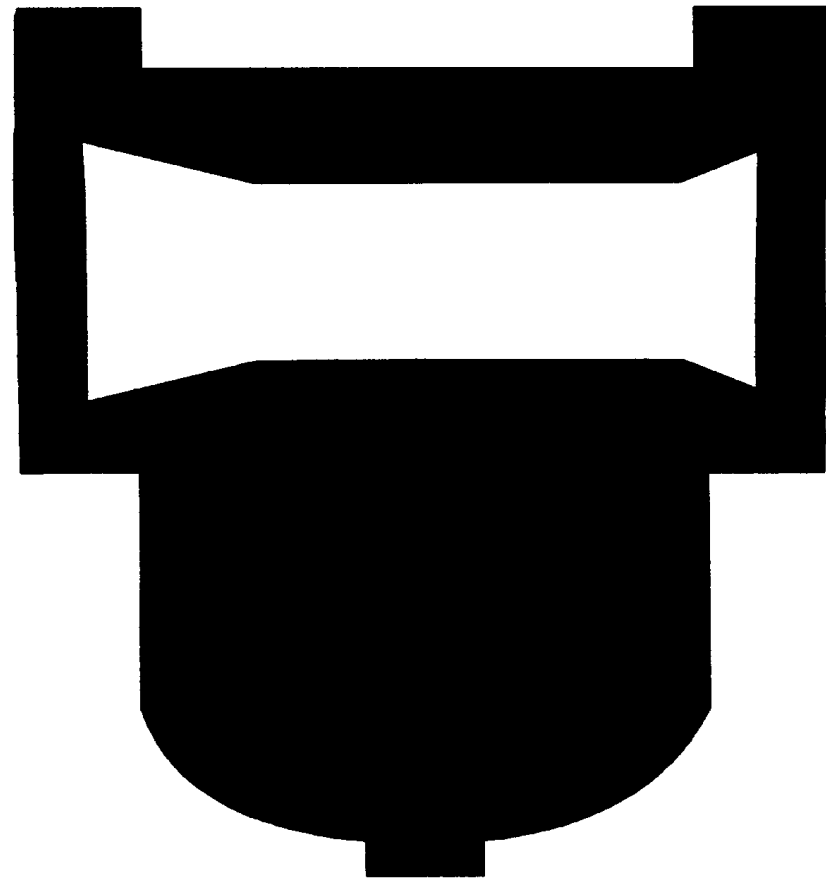
9. Install:
- Helmet carrier
 - Overflow bowl
 - Footrest
 - Rear bodywork
 - Rear cover
- Follow the reverse process to the removal procedure.

10. Install:
- Battery in its footrest housing

11. Connect:
- Battery cables

<p>Positive cable + to positive terminal + of battery Negative cable – to negative terminal – of battery</p>

12. Place:
- Front cover



CARB

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