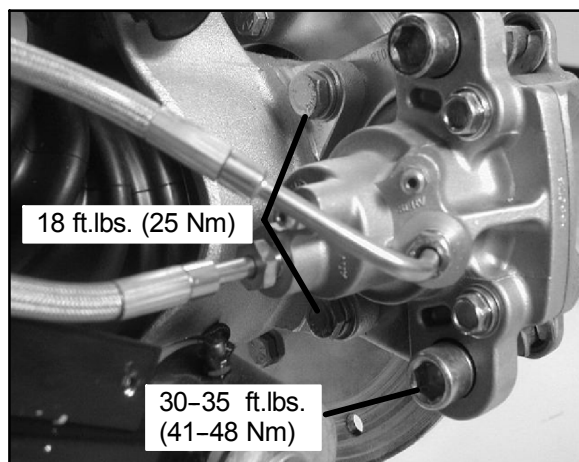
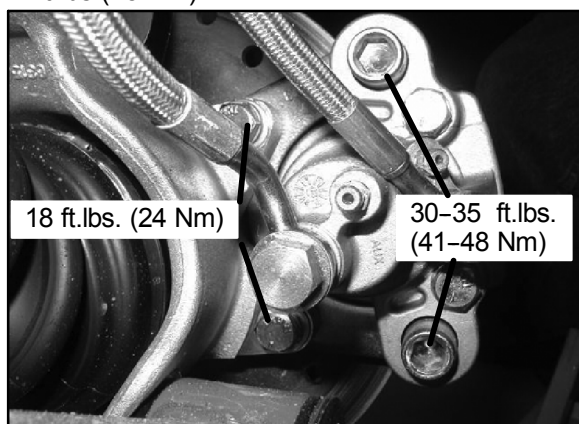


Caliper Slide Pin Torque:
30-35 ft. lbs. (41 Nm-48 Nm)

4. Install caliper and torque mounting bolts to 18 ft.lbs (25 Nm).

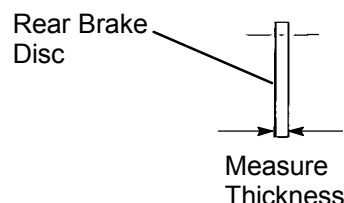


Caliper Mounting Bolt Torque:
18 ft. lbs. (24 Nm)

5. Install brake line and tighten securely with a line wrench. Torque the brake lines to the proper torque specification.
6. Follow bleeding procedure outlined on Pages 9.6-9.7 of this section and refer to system overview and illustrations on Pages 9.2-9.3.
7. Field test unit for proper braking action before putting into service. Inspect for fluid leaks and firm brakes. Make sure the brake is not dragging when lever is released. If the brake drags, re-check assembly and installation.

REAR BRAKE DISC INSPECTION

1. Visually inspect disc for scoring, scratches, or gouges. Replace the disc if any deep scratches are evident.
2. Use a 0-1" micrometer and measure disc thickness at 8 different points around perimeter of disc. Replace disc if worn beyond service limit.



Brake Disc Thickness

New .150-.165" (3.81-4.19 mm)
Service Limit .140" (3.556 mm)

Brake Disc Thickness Variance

Service Limit .002" (.051 mm)
difference between measurements

3. Mount dial indicator and measure disc runout. Replace the disc if runout exceeds specifications.

Brake Disc Runout

Service Limit .010" / .254 mm



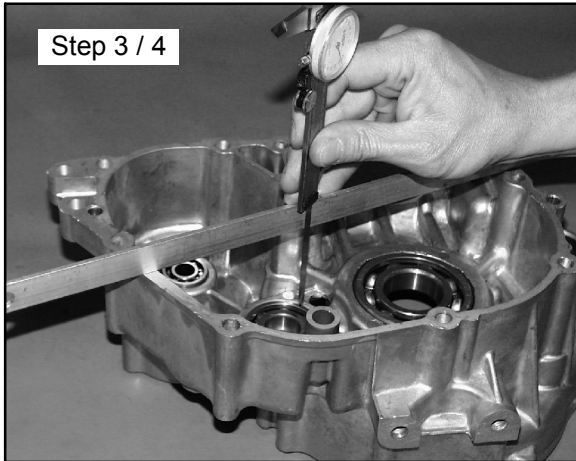
COUNTER BALANCER SHAFT END PLAY ADJUST.

Step 2



1. Make sure all bearings are firmly seated in the crankcase.
2. Measure the width of the counter balancer shaft at the bearing seats with a dial caliper or micrometer, and record reading.

Step 3 / 4



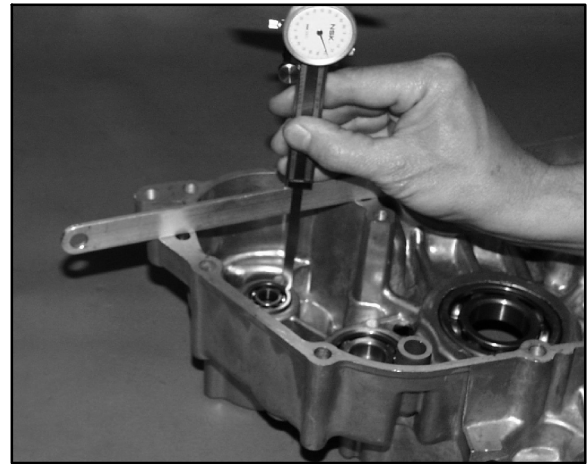
3. Measure the distance from the Mag crankcase mating surface to the balance shaft bearing using a dial caliper and a straight edge. Subtract the thickness of the straightedge and record.
4. Measure the distance from the PTO crankcase mating surface to the bearing using the same method outlined in Step 1, 2, and-3.
5. Add the readings obtained in Step 3 and Step 4.
6. Subtract the counter balancer shaft width measured in Step 2 from the figure obtained in Step 5.
7. Subtract the thickness of the existing shim from the result of Step 6 to determine if a different shim is needed. The result must be within the specified range listed at below.

Counter Balancer Shaft End Play:

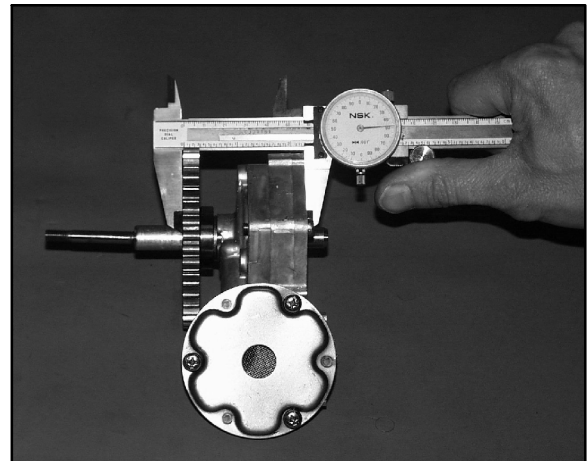
.008"-.016" (.02-.04 cm)

OIL PUMP SHAFT END PLAY ADJUSTMENT

1. Make sure the pump shaft bearing is firmly seated in the Magneto side crankcase.



2. Measure the distance from the magneto crankcase mating surface to the bearing using a dial caliper and a straight edge. Subtract the thickness of the straightedge and record.



3. Install the gear on the oil pump and measure the width of the pump and gear. Subtract this measurement from the measurement recorded in Step 2.
4. Subtract the thickness of the existing shim from the result of Step 3 to determine if a different shim is needed. See Shaft End Play Spec. next page.

