

CHECKING 1340cc LEFT MAIN BEARING END PLAY

General

When performing an entire engine overhaul, it is important that the left main bearing end play be within the recommended .001 to .004 in. specifications to prevent bearing damage. This end play can be adjusted by selecting the required bearing inner spacer.

The chart at the end of this Service Bulletin lists the new Bearing Inner Spacers by part number and size which can be ordered through Parts and Accessories.

**Crankcase Assembly for Left Main Bearing End Play Check
(Refer to Figure 1.)**
NOTE

The following procedure must be performed with bearings that are clean and dry. Oiled surfaces will take up some clearance and give a false reading.

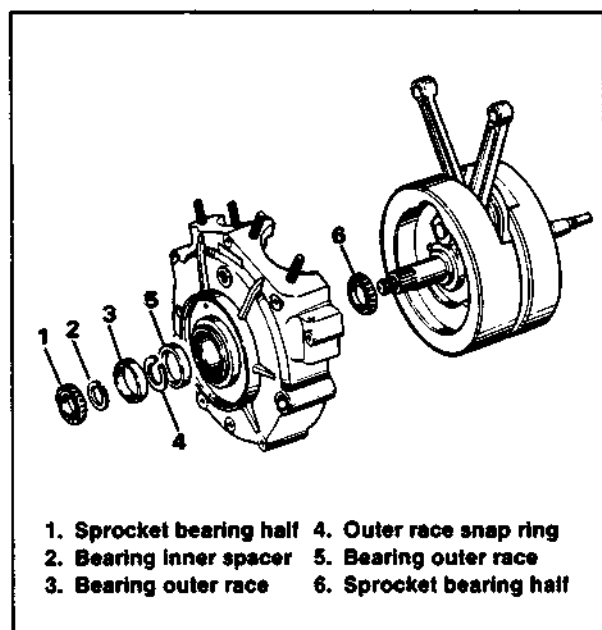


Figure 1. Left Main Bearing Assembly

1. Install the outer race snap ring (4) in the left crankcase half making sure the oil hole in the snap ring groove is centered in the snap ring gap. Using an arbor press and OUTER RACE PRESS PLUG, Part No. HD 94547-80, press each bearing outer race (3) and (5) into the left crankcase bushing, one from each side, one at a time, with the widest ends outward to match the taper of the bearings.

NOTE

Be sure each bearing race bottoms on the snap ring.

2. See Figure 2. Position the flywheel assembly, sprocket shaft up, in a vise with copper jaws. Using BEARING INSTALLATION TOOL, Part No. HD 97225-55, press sprocket bearing half (6) onto the sprocket shaft.

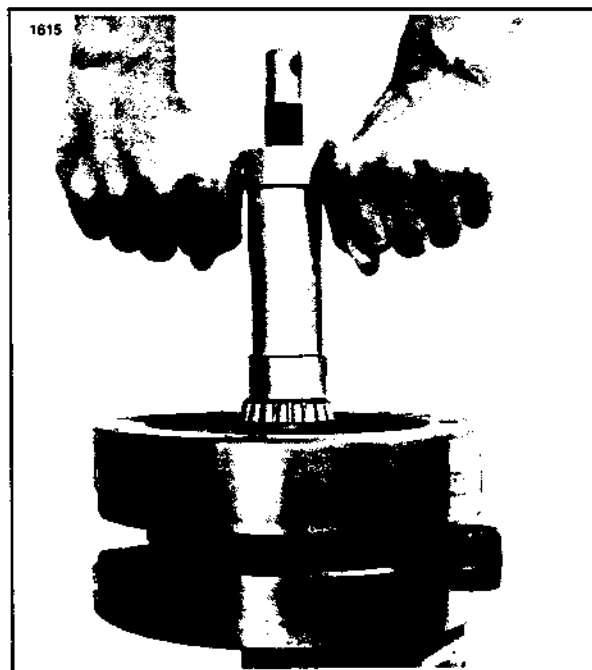


Figure 2. Pressing Bearing On Sprocket Shaft

ROUTING:	SERVICE MANAGER	SALES MANAGER	PARTS MANAGER	CHIEF MECHANIC	MECHANIC NO. 1	MECHANIC NO. 2	MECHANIC NO. 3	MECHANIC NO. 4	RETURN THIS TO:
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NOTE

A SPROCKET SHAFT SPACER, Part No. HD 24036-80, may be needed with the bearing installation tool as shown in Figure 2.

Press the sprocket bearing half on using the sprocket shaft spacer as a pressing tool only.

3. See Figure 3. Slip the left crankcase half over the sprocket shaft. Install the small bearing inner spacer (2) that came with the bearing set. Position the sprocket bearing half (1) on the shaft squarely. Using BEARING INSTALLATION TOOL, Part No. HD 97225-55, press bearings tightly together.

NOTE

Bearings must be tight against the bearing inner spacer to provide correct bearing clearance.

4. Assemble the right crankcase half to the left with two mounting bolts. Place the crankcase assembly into an engine stand.
5. See Figure 4. Before removing the bearing installation tool, fasten a dial indicator to the gear side of the crankcase. Place the indicator stem on the end of the gearshaft. Check amount of main bearing end play by rotating and pushing on the sprocket shaft while reading the dial indicator extremes of travel. If the reading is not between .001 and .004 in., remove the bearing inner spacer.

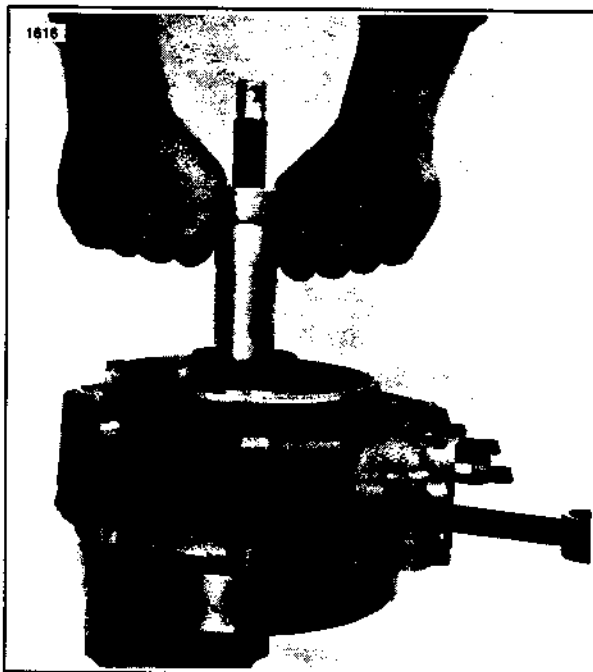


Figure 3. Pressing Flywheel Into Crankcase

NOTE

Refer to DISASSEMBLING CRANKCASE in the latest

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Service Manual for sprocket bearing half removal.

6. Measure the bearing inner spacer with a micrometer, and, depending on the dial indicator reading, add or subtract the amount from the spacer requirement and choose the appropriate spacer from the chart.
7. Reinstall the bearing inner spacer and the sprocket bearing half and recheck the end play.
8. If end play is within recommended specifications, lubricate the bearing assembly with engine crankcase oil.

Refer to ASSEMBLING CRANKCASE in the latest Service Manual for further crankcase assembly procedure.

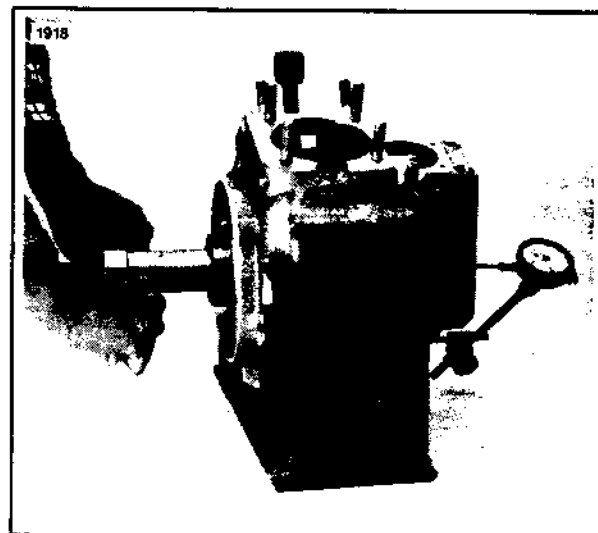


Figure 4. Checking Flywheel End Play

PART NO.	SIZE
9120	.0925/.0915
9121	.0945/.0935
9122	.0965/.0955
9123	.0985/.0975
9124	.1005/.0995
9125	.1025/.1015
9126	.1045/.1035
9127	.1065/.1055
9128	.1085/.1075
9129	.1105/.1095
9130	.1125/.1115
9131	.1145/.1135
9132	.1165/.1155
9133	.1185/.1175
9134	.1205/.1195

Bearing Inner Spacers