



# INSTRUCTIONS

-J00017

REV. 4-1-93

Kit Number 23802-92R

## RIGHT FLYWHEEL

### General

This kit is designed for installation on XR-750 with cam gear cover, Part No. 25198-93R.

#### NOTE

If flywheel is used with 1990 - 1992 cam gear cover, Part No. 25198-88R, cover needs to be modified to provide additional clearance for pinion shaft nut.

Kit Contents:	QTY	DESCRIPTION
	1	Flywheel

### Installation

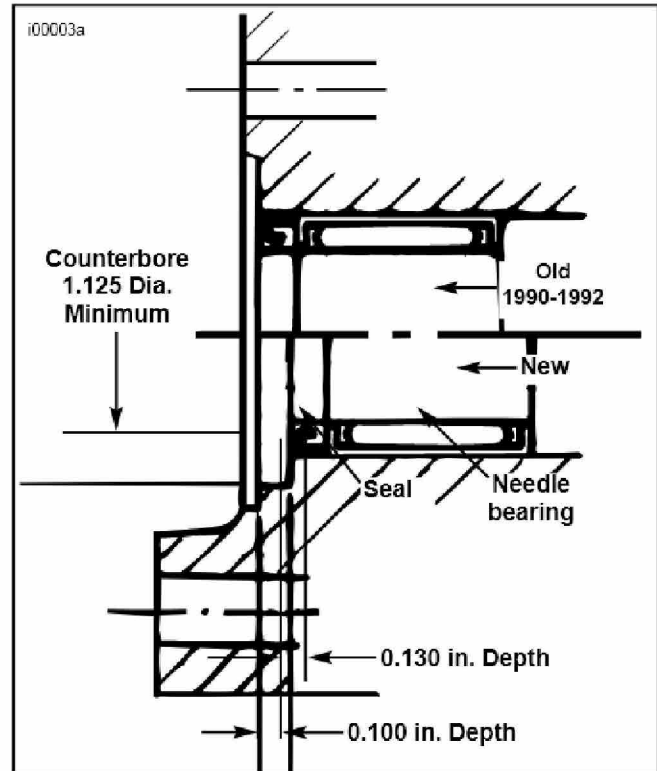
1. Remove seal and bearing.
2. See Illustration. Increase depth of existing counterbore by 0.100 in. and then increase bore to 1.125 in. diameter minimum.
3. Clean all parts thoroughly.
4. Press new needle bearing (Part No. 25592-74R) 0.130 in. below surface of new counter bore.
5. Install new seal (Part No. 25535-74R) flush with bottom of new counterbore.
6. Apply LOCTITE® 271 to pinion shaft and nuts. Torque to 70-90 ft-lbs.

#### NOTE

Bearing can be pressed down into bore by 0.100 in. and then the machine process can take place. This would eliminate the replacement of the needle bearing.

#### CAUTION

If above method of machining is used, please take caution to keep chips away from bearing. Care must be taken to thoroughly clean gearcase and bearing.



Bearing Installation