



# INSTRUCTIONS

-J00024

REV. 6-1-94

Kit Numbers 24324-88R, 24325-88R

## XR750 CONNECTING ROD INSTRUCTIONS

### IMPORTANT NOTES (ALL YEARS):

Before installing crankpin, check location of oil feed hole for unrestricted oil delivery to rod bearings.

Make sure there are no sharp corners on all chamfers on O.D.'s of crankpin and plugs and inside flywheel and crankpin bores.

Line up oil feed holes of crankpin and right flywheel first and press crankpin flush with outside of flywheel.

A high pressure lubricant may be used when crankpin is pressed into new flywheels.

- Surface finish rod I.D.: ..... 6 - 10 RMS
- Endplay rear connecting rod: ..... .018 - .025
- Endplay retainers: ..... .018 - .025
- Mainshaft runout with  
flywheel assy. between centers: ..... .002 in. max.



**Connecting rods are short peened; DO NOT POLISH.**

### Pre 1989 Engines

See Figure 2, page 2. The -88R connecting rods can be used in earlier engines provided that the following change is carried out;

Remove an equal amount from each rear rod retainer – nominally .006 in. until the total width of all four retainers equals 1.590 in.

When assembled, crankpin will protrude approximately .028 in. through the left flywheel.

Check retainer O.D. for a minimum clearance of .007 in.

For proper fitment of rod bearings, rod I.D. will have to be enlarged by approximately .004 in.

### Component sizes:

- Rod I.D. (as supplied) ..... 2.1000 - 2.1206
- Crankpin O.D. (as supplied) ..... 1.4984 - 1.4989
- Roller (STD) ..... .3125
- Roller over sizes ..... .0005; .0010; .0015; .0020

### Example of connecting rod I.D. calculation:

- Crankpin (as measured) ..... 1.4986
- Roller STD size (2) ..... .6250
- Clearance ..... .0010
- Total ..... 2.1246

Hone connecting rod I.D. to: ..... 2.1246 ± 0.0001

### 1989 and Later

See Figure 1, page 2. For proper fitment of rod bearings, rod I.D. will have to be increased by approximately .001 in.

The connecting rod bore size chart below gives the correct bore size for different bearing / crankpin sizes. Machine connecting rods to sizes given in chart below.

CONNECTING ROD BORE I.D. CHART				
Crankpin Size	Packaging Color Identification			
	GREEN	WHITE	BLUE	RED
	M6 M8 M7 M9	M4 M6 M5 M7	M2 M4 M3 M5	P0 M2 M1 M3
Standard	2.1213	2.1215	2.1216	2.1218
+0.001	2.1223	2.1225	2.1226	2.1228
+0.002	2.1233	2.1235	2.1236	2.1238

Bore Tolerance ±0.0001 in.

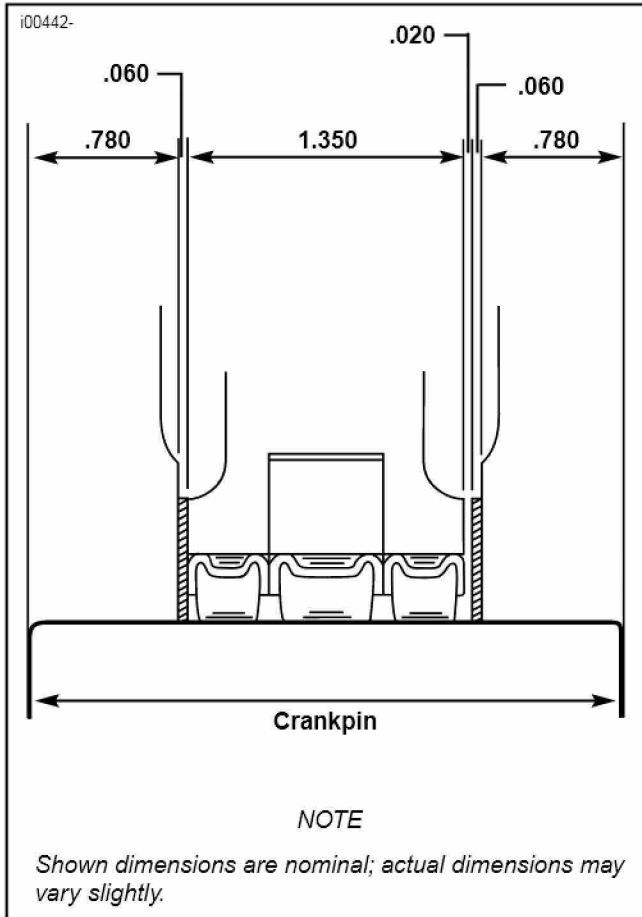


Figure 1. Connecting Rod and Bearing Assembly (1989 and Later)

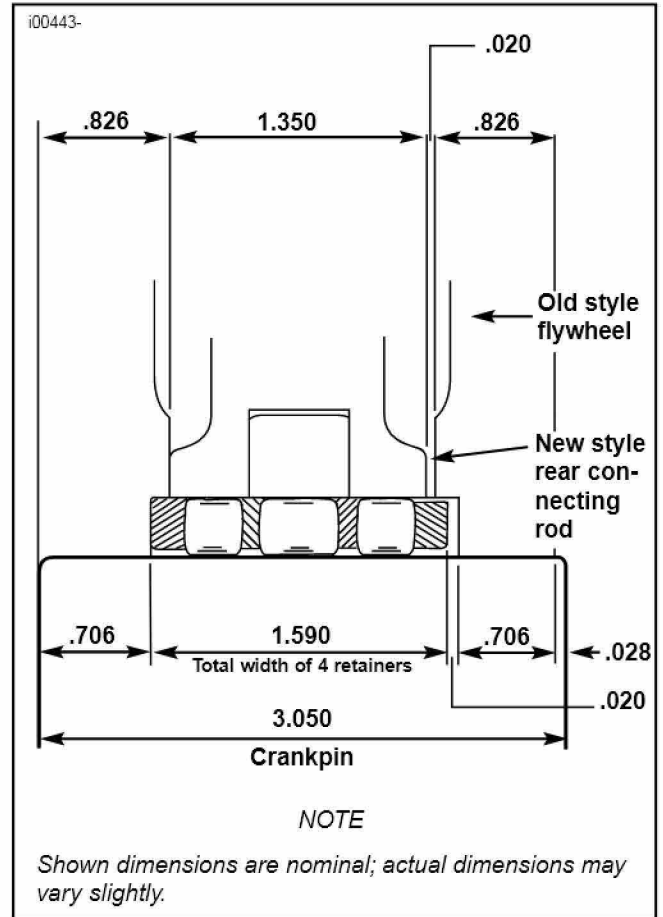


Figure 2. Dimensions for 1989 rear connecting rod (P/N 24325-88R) when used with Pre 1989 crankpin, rod bearing and flywheels (width of Pre 1989 rear connecting rod is 1.370)