



# INSTRUCTIONS

-J00025

REV. 3-1-95

Kit Number 24354-87A

## BEARING SET

This new bearing set can be used to service all XL, XR-1000 models from 1957 - early 1986 when used with the appropriate flywheel thrust washers. They are also a direct replacement for late 1986 to current XL models.

| THRUST WASHERS | MODEL YEAR FILAMENT     |
|----------------|-------------------------|
| 23972-57A      | 1957 to 1971            |
| 23972-72A      | 1972 to Early 1979      |
| 6508           | Late 1979 to Early 1986 |

These thrust washers have been machined with a step on the thrust surface to allow for adequate rod bearing cage end play.

### CAUTION

Failure to use the proper thrust washer may result in bearing and connecting rod failure.

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See Figure 1. Some early flywheels have a raised lip in the area of the flywheel thrust washer's inside diameter. This lip must be machined off or you will crush the bearing cage as you assemble and torque the crankpin nuts.

When you remove this lip, be careful not to damage the flywheel crankpin taper. Remove only enough material to remove the lip and make the lip area flush with the bottom of the thrust washer recess.

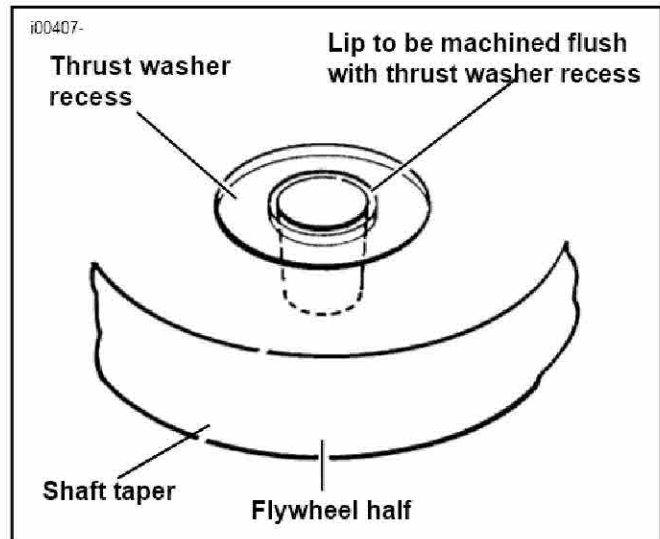


Figure 1. Early-style Flywheel Thrust Washer Lip



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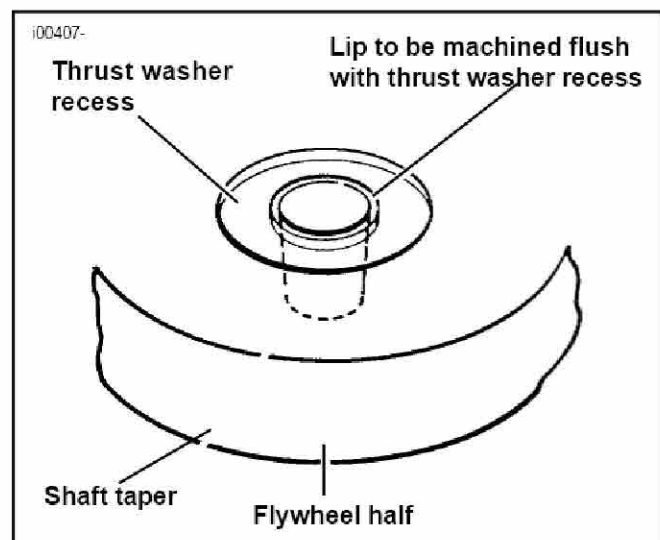


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