

I. PROCEDURE OF PERFORMING THE WORK

1. When performing an overhaul, all the parts which have been disassembled should be separated in their respective groups so that they will not become mixed.
2. All packings, gaskets and cotter pins which have been removed should be replaced with new items when reassembling. Any snap rings which are deformed should also be replaced.
3. All engine parts should be cleaned after disassembly. Metal surfaces which are subject to friction must be coated with oil.
4. The work should be performed with special tools for better results.
5. All nuts and bolts are normally torqued starting from those of large diameter and from inside to outside symmetrically.
6. Refer to torque values shown in the following table.

UNIT: kg-m (ft-lb)

Engine		Frame	
Item	Torque values	Item	Torque values
Cylinder head	1.8~ 2.0 (11.5~14.5)	Front axle nut	4.0~ 5.0 (29.0~36.0)
Spark advance	0.8~ 1.2 (5.8~ 8.7)	Rear axle nut	4.0~ 5.0 (29.0~36.0)
Cam sprocket	0.8~ 1.2 (5.8~ 8.7)	Rear fork pivot bolt	3.0~ 4.0 (21.7~29.0)
Cylinder mount bolt, 6 mm	1.2~ 1.8 (8.7~13.0)	Engine mounting bolt	2.0~ 2.5 (14.5~18.8)
Left crank case cover	0.8~ 1.2 (5.8~ 8.7)	Handle mounting bolt	0.9~ 1.1 (6.50~7.95)
A.C rotor	2.6~ 3.2 (18.8~23.2)	Steering stem nut	6.0~8.0 (43.3~57.8)
A.C generator mounting screw	0.8~ 1.2 (5.8~ 8.7)	Front cushion mounting bolt	4.0~ 5.0 (29.0~36.0)
Cam chain tensioner arm	0.8~ 1.2 (5.8~ 8.7)	Rear cushion mounting nut	3.0~ 4.0 (21.7~29.0)
Right crank case cover screw	0.8~ 1.2 (5.8~ 8.7)	Torque link mounting bolt	2.0~ 2.5 (14.5~18.0)
Oil filter cover screw	0.8~ 0.4 (2.2~ 2.9)	Top bridge lock nut	4.0~ 4.8 (29.0~34.7)
Oil filter (lock nut, 16 mm)	4.0~ 5.0 (29.0~36.0)	Final driven sprocket	2.0~ 2.5 (14.5~18.0)
Oil pump gear cover bolt	0.4~ 0.6 (2.9~ 4.4)	Seat mounting bolt	2.0~ 2.5 (14.5~18.0)
Clutch mounting bolt	0.8~ 1.2 (5.6~ 8.7)		
Gear shift drum stopper bolt	0.8~ 1.2 (5.6~ 8.7)		
Gear shift drum cam bolt	0.8~ 1.2 (5.6~ 8.7)		

Standard parts

Bolt hex. 6 mm	0.8~1.2 kg/m (5.8~8.7)
Screw cross, 6 mm	0.8~1.2 kg/m (5.8~8.7)
Nut, 6 mm	0.8~1.2 kg/m (5.8~8.7)
Screw cross, 5 mm	0.3~0.4 kg/m (2.2~2.9)