

### 5.3.3 MAIN BEARING ASSEMBLY

- Check the interference fit between the bearing and the engine case hole.  
Interference (X) (diameter A – diameter A1): min. (tight) 0.0004 in (0.01 mm).
- Lubricate the external diameter of the bearings slightly and, with due care, fit them all the way in on the outer race using a suitable assembly drift:
  - gearbox main shaft (8), alternator side;
  - gearbox main shaft (8), clutch side;
  - gearbox countershaft (9), clutch side;
  - shift cam (10), clutch side;
  - gearbox countershaft (11), alternator side.

#### CAUTION

The gasket of the gearbox main shaft ball bearing (6), alternator side, must face outwards.

**NOTE** As a rule, the disassembled ball bearings should be replaced.

- Lubricate the internal diameter of the shift cam ball bearing (12), alternator side, slightly and, with due care, fit it all the way in on the inner ring using a suitable assembly drift.
- Apply LOCTITE® 243 on the screws (4) (5) securing the ball bearings and screw them into the engine case.

Screws tightening torque: 8 ftlb (11 Nm).

### 5.3.4 OIL SEAL ASSEMBLY

**NOTE** Have the appropriate special tool  available:

- aprilia part# 0877650 (handle for drift) (13);
- aprilia part# 0277680 (countershaft oil seal assembly drift) (1-4);
- aprilia part# 8140155 (main shaft oil seal-clutch shaft oil seal assembly drift) (15).

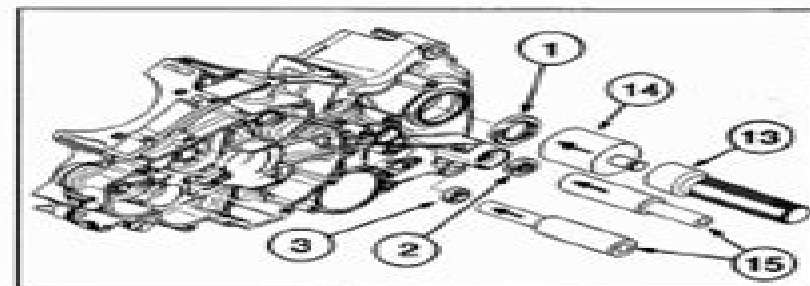
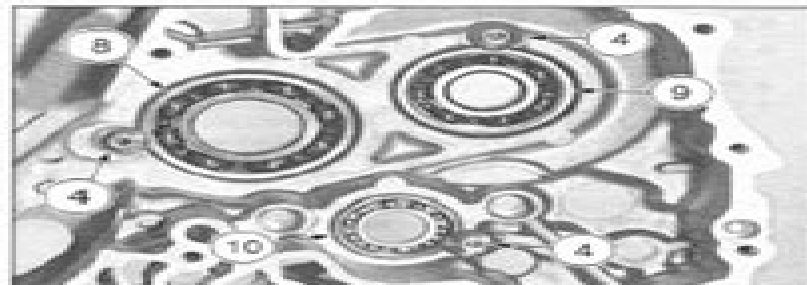
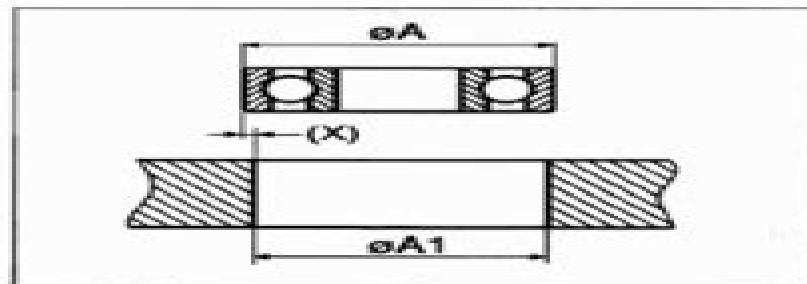
**NOTE** Before assembling the shaft seals, their external diameter must be lubricated slightly.

The closed side of the shaft seals must face outwards. Grease the sealing lips.

#### CAUTION

The oil seal (1) of the countershaft must not touch the inner race of the bearing in any way as this would result in damage.

- Insert the oil seal (1) flush with the engine case using the assembly drift (14).
- Insert the shaft seals (2) (3) all the way using the assembly drift (15).



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