

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 **5-13** available:

- aprilia part# 0877650 (handle for drift) (13);
- aprilia part# 0277680 (countershaft oil seal assembly drift) (14);
- aprilia part# 8140155 (main shaft oil seal-clutch shaft oil seal assembly drift) (15).

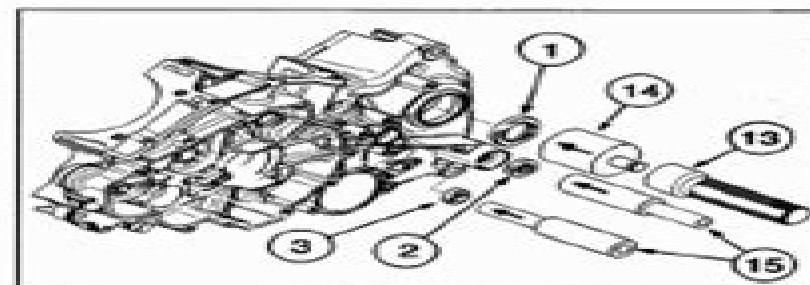
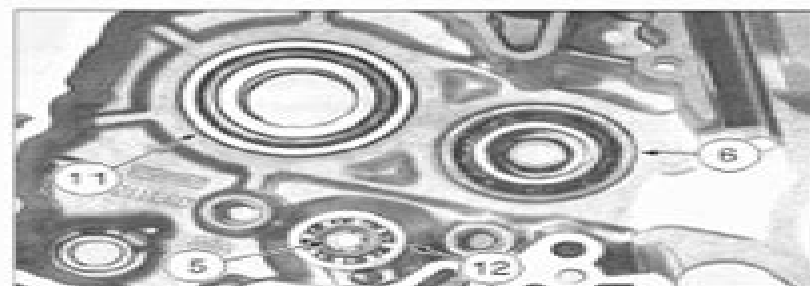
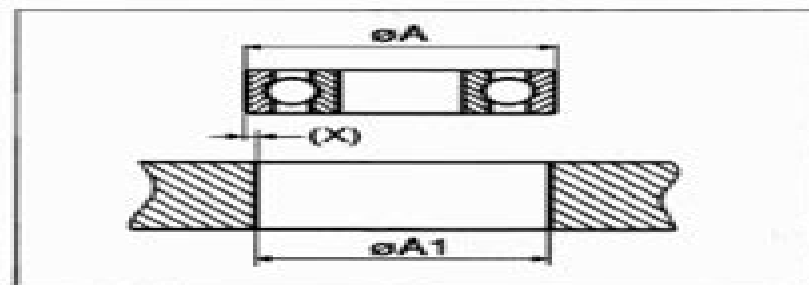
NOTE Before assembling the shaft seals, their external diameter must be lubricated slightly.

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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