

## Engine Rebuild: Disassembly Sequence From Green Flag Motorsports

Suggested Sequence:	Operation:	Tool:	Description:
Step 1 (See Figure 1)	remove (5) pressure plate nuts remove springs & plates items	standard	13mm socket
Step 2 (See Figure 2)	hold & remove clutch hub nut hold clutch hub remove clutch hub	standard	spanner & 1/2" drive breaker bar / 19mm socket
Step 3 (See Figure 3)	remove (10) clutch cover screws use small dead blow hammer or block of wood to free up cover (ensure that clutch release pushrods located in trans mainshaft are secured until reassembly	standard	5mm hex wrench dead blow hammer
Step 4 (See Figure 4)	remove 20mm snap ring from crankshaft slip off drive gear	standard	snap ring pliers
Step 5 (See Figure 5)	hold & remove PVL rotor nut - part of	standard	spanner & 1/2" drive breaker bar & 20mm socket
Step 6 (See Figure 6)	remove PVL rotor		rotor puller
Step 7 (See Figure 7)	remove (3) stator plate screws remove stator plate	standard	4mm hex wrench
Step 8 (See Figure 8)	remove (4) cylinder nuts remove hose, cylinder & gasket	standard	12mm box end - reduced box section
Step 9 (See Figure 9)	remove (17) crankcase screws gently remove one crankcase half from mating half tap with wood block or small dead blow hammer to loosen sealer work cases from end to end to break shafts loose from bearings - <i>do not pry</i> remove crankshaft assembly	standard	5mm hex wrench
Step 10 (See Figure 10)	remove complete crankshaft/rod/piston assembly from igtion side remove primary & secondary shafts as one unit - note position of thrust washer and shifter forks  place small piece of tape over clutch shaft hole in primary shaft to retain clutch push rods	<i>manual</i>	

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- ! the disassembly of the crankcase is necessary when preparing to replace crankcase bearings and seals or rebuild crankshaft.
- ! separate sections will explain bearing, seal replacement
- ! keep all loose parts organized in clean container for reassembly

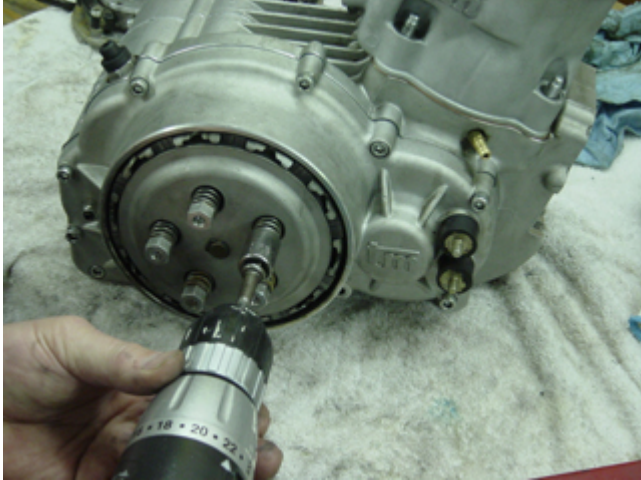


Figure 1



Figure 2

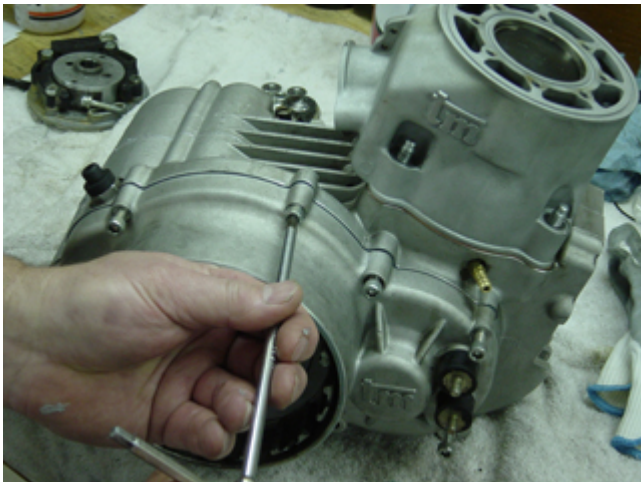


Figure 3

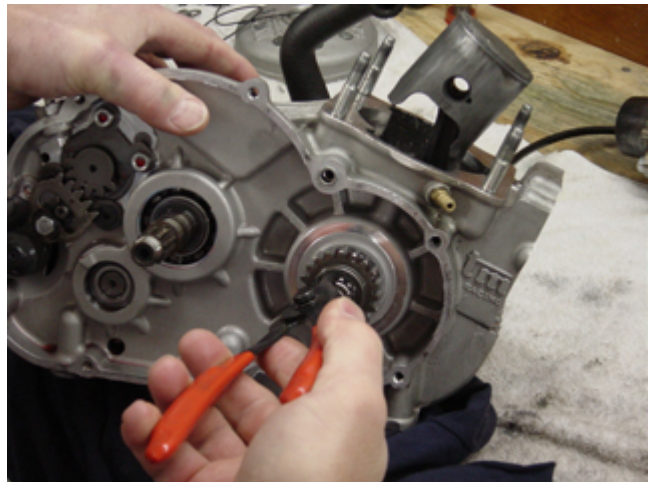


Figure 4

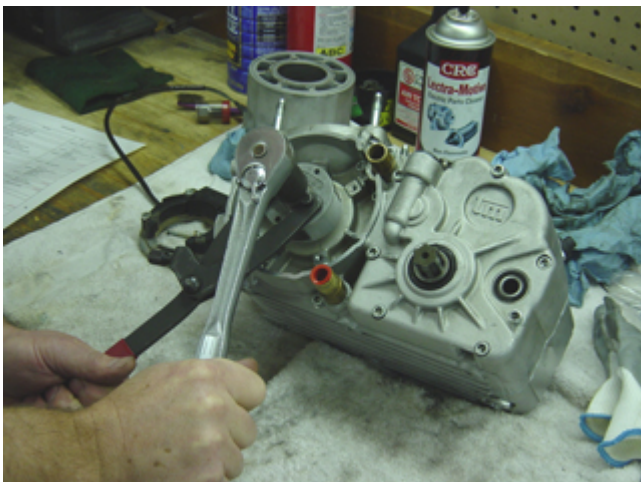


Figure 5

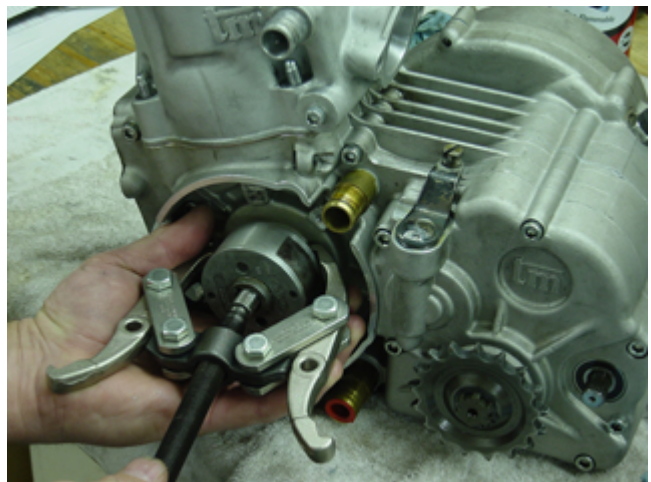


Figure 6

# Engine Rebuild: Disassembly Sequence

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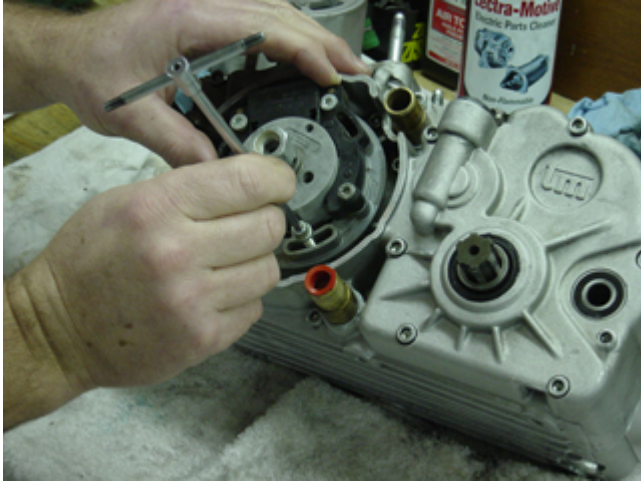


Figure 7

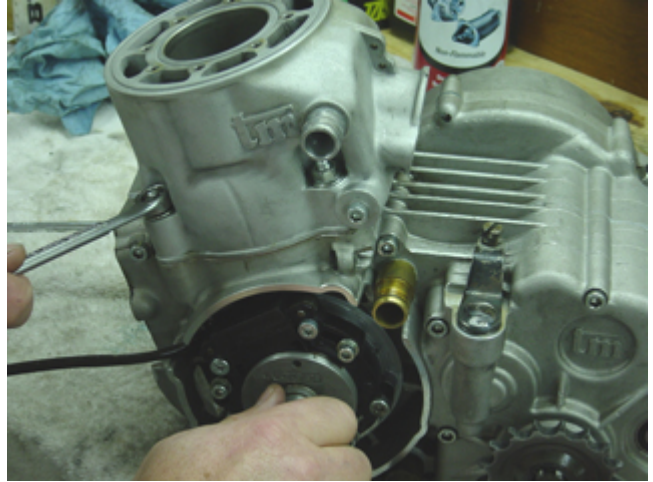


Figure 8

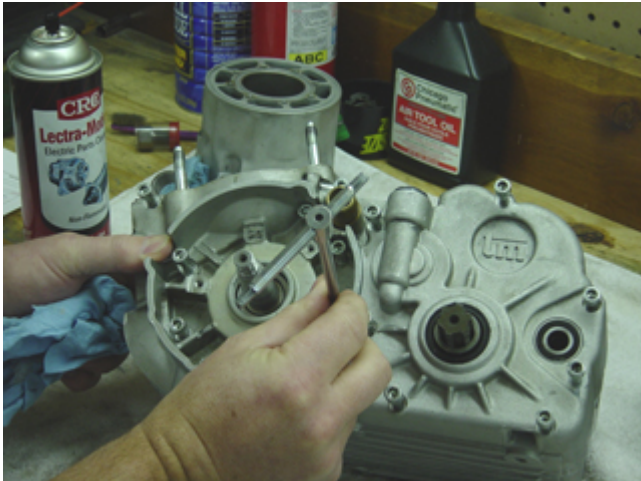


Figure 9

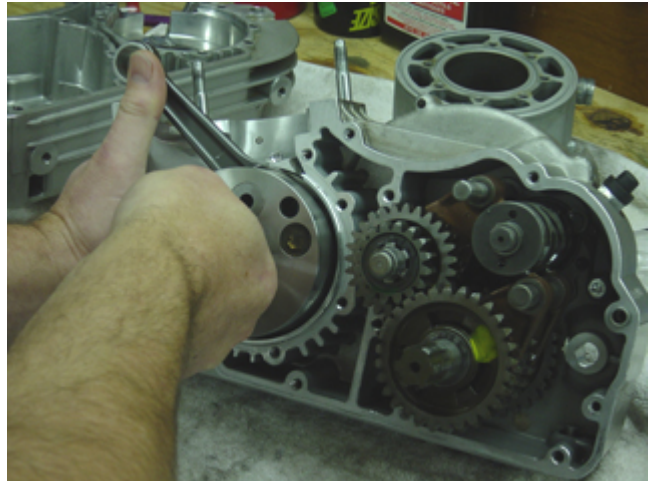


Figure 10