

250/260 LIQUID COOLED



ENGINE PARTS MANUAL

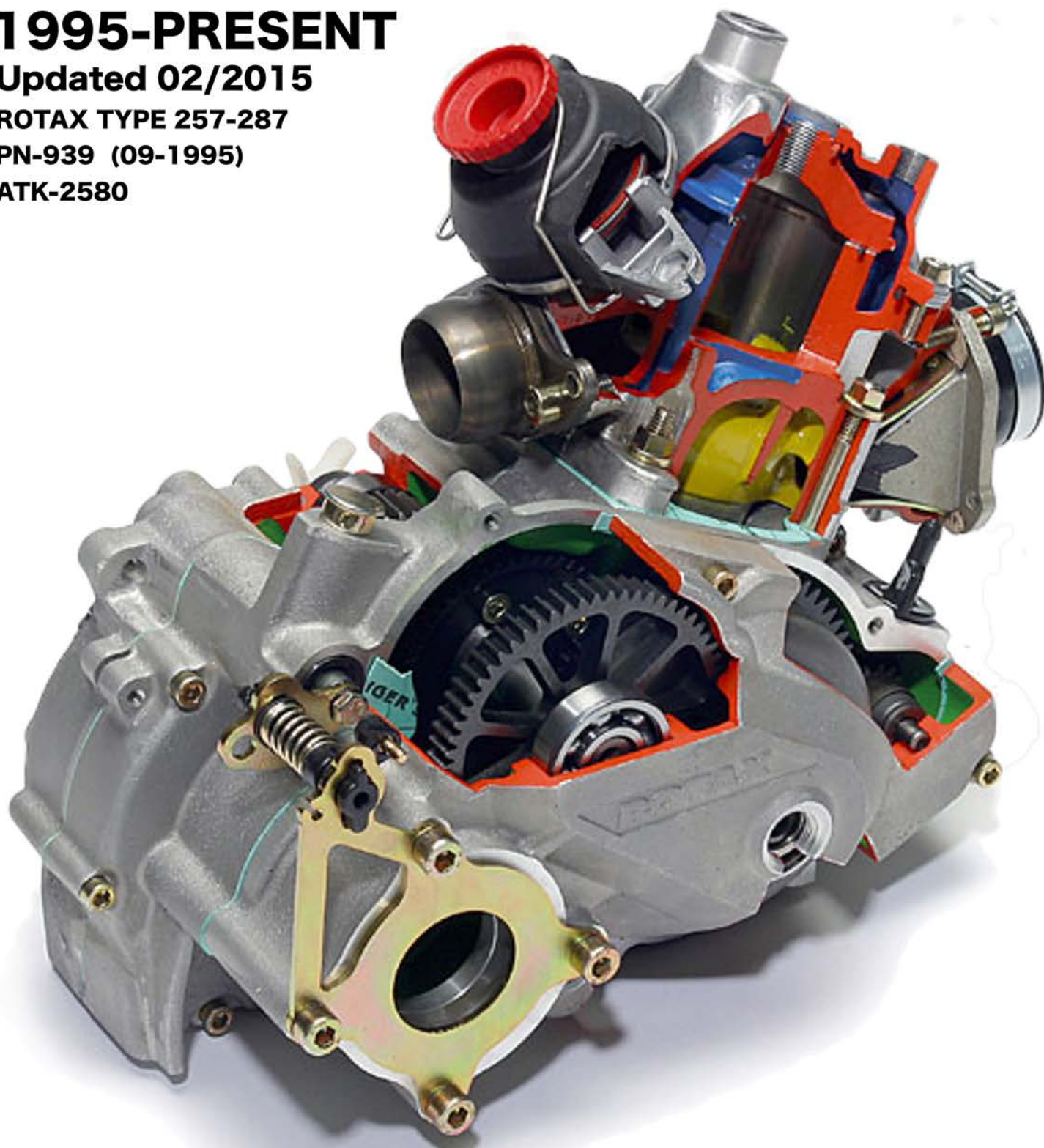
1995-PRESENT

Updated 02/2015

ROTAX TYPE 257-287

PN-939 (09-1995)

ATK-2580





SPARE PARTS LIST

FOR ROTAX ENGINE

**TYPE 257 GS
 287 GS**

ATK



No.: 939

EDITION: 09 1995



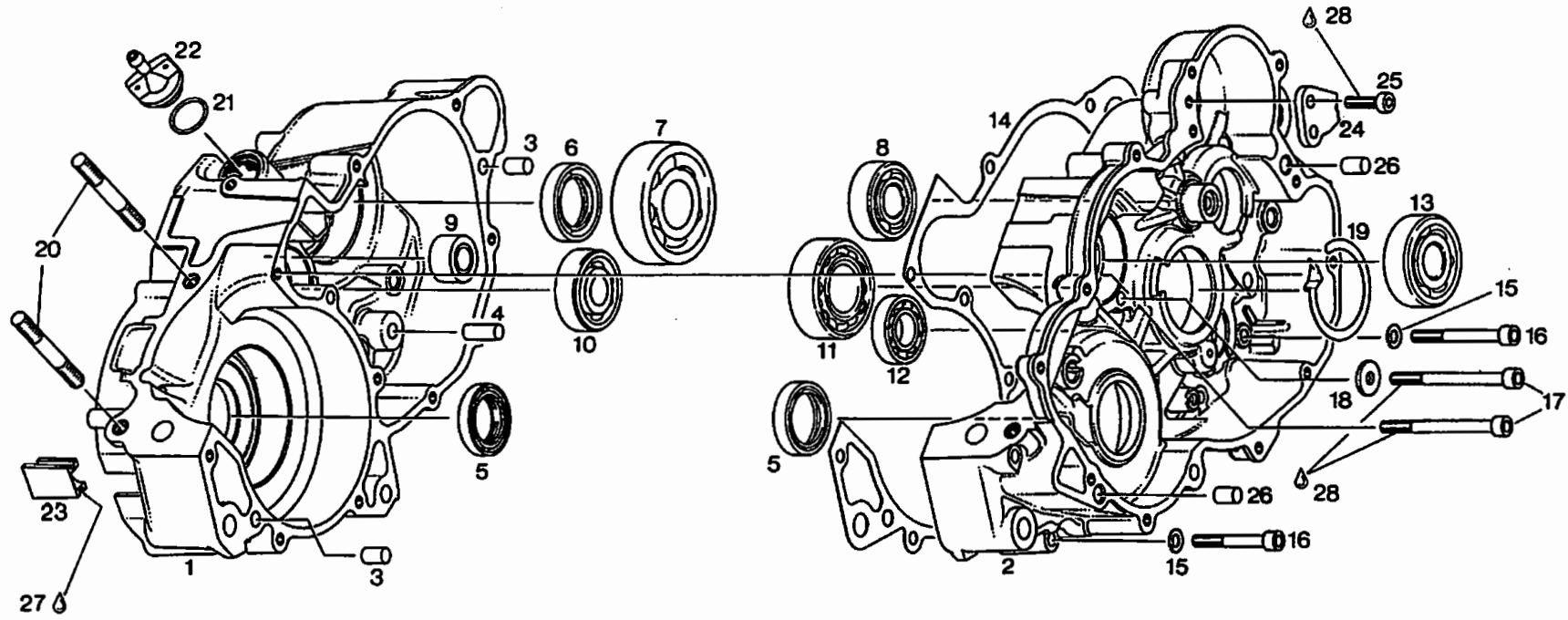
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POUR INFORMATION SEULEMENT
MODIFICATIONS SANS AVIS OBLIGATOIRE**



TABLE OF CONTENTS

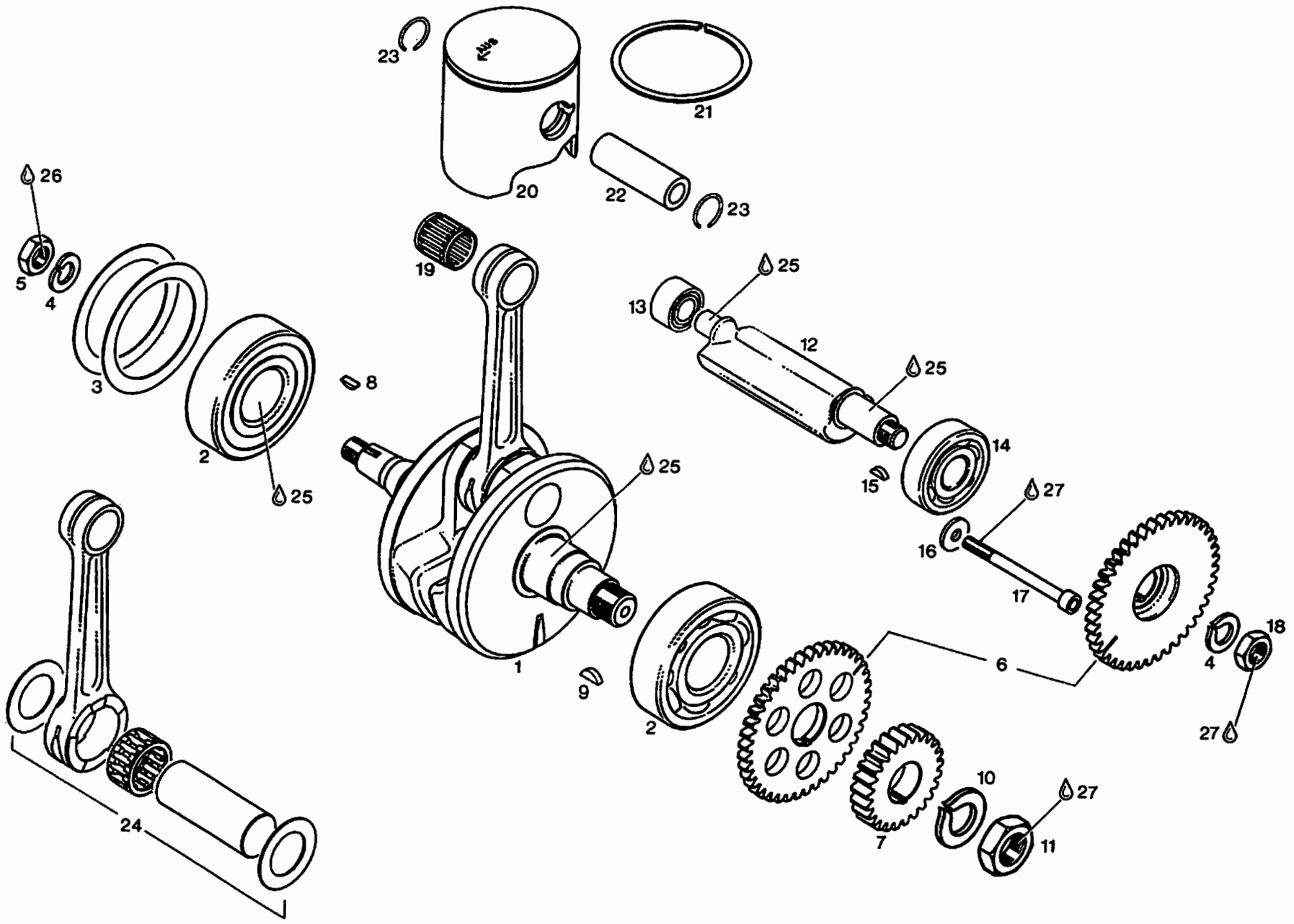
PAGE	CHAPTER
3	Crankcase, gear bearings 1
7	Crankshaft, balancer drive, piston For engine type 257 2
11	Crankshaft, balancer drive, piston For engine type 287 3
15	Cylinder, exhaust valve, cylinder head, thermostat, intake socket For engine type 257 4
19	Cylinder, exhaust valve, cylinder head, thermostat, intake socket For engine type 287 5
23	6-speed transmission 6
27	clutch, kick start 7
31	clutch cover, water pump 8
35	S E M magneto-generator, ignition cover 9
39	Repair tools, gasket sets 10



CRANKCASE, GEAR BEARINGS

ILL. NO.	PART NO.	D E S C R I P T I O N	QTY.
1 - 3	294 843	CRANKCASE ASSY., LIGHT-GRAY.....	1
2	632 010	PIN 8X12.....	2
3	929 940	PIN 8X20.....	1
4	230 425	OIL SEAL 28X38X7..... FOR CRANKSHAFT, CLUTCH SIDE	1
5	930 675	OIL SEAL 25X38X7..... FOR CRANKSHAFT, MAGNETO SIDE	1
6	830 602	OIL SEAL 25X35X7..... FOR MAIN SHAFT	1
7	932 825	BALL BEARING 6305 C3, 25-62-17..... FOR MAIN SHAFT, MAGNETO SIDE	1
8	932 032	BALL BEAR. 6203 TVH C3, 17-40-12..... FOR MAIN SHAFT, CLUTCH SIDE	1
9	232 600	NEEDLE BEARING 12X24X13..... FOR BALANCE SHAFT, MAGNETO SIDE	1
10	232 291	BALL BEARING 6302 TN ⁹ C3/15-42-13..... FOR CLUTCH SHAFT, MAGNETO SIDE	1
11	232 765	BALL BEARING 6205 TVH / 25-52-15..... FOR CLUTCH SHAFT, CLUTCH SIDE	1
12	232 590	BALL BEARING 16003..... FOR GEAR SHIFT DRUM 17-35-8	1
13	932 815	BALL BEARING 6303E C3, 17-47-14..... FOR BALANCE SHAFT, CLUTCH SIDE	1
14	250 820	GASKET.....	1
15	945 751	LOCK WASHER A6.....	9
16	241 821	ALLEN SCREW M6X45..... FOR VERSION GS TIGHTENING TORQUE 10 NM (89 IN.LB.)	7
17	241 871	ALLEN SCREW M6X70..... TIGHTENING TORQUE 10 NM (88 IN.LB.)	4
18	827 305	WASHER 6,2/18/2..... FOR BALANCE SHAFT BEARING	1

ILL. NO.	PART NO.	DESCRIPTION	QTY.
19	627 010	SHIM..... FOR CLUTCH SHAFT	AS REQ
20	840 536	STUD M8X44/20..... TIGHTENING TORQUE 10 NM (88 IN.LB.)	4
21	250 890	O-RING DIN 3771-17X1,5-N.....	1
22	241 925	AIR VENT SCREW M18X1,5.....	1
23	260 840	GROMMET.....	1
24	228 230	RATCHET GEAR STOP.....	1
25	240 401	ALLEN SCREW M6X20..... TIGHTENING TORQUE 10 NM (85 IN.LB.)	2
26	632 010	PIN 8X12.....	2
27	297 386	SILASTIC 732 RTV, 100 GR.,..... TRANSPARENT	AS REQ
28	899 785	LOCTITE 221 VIOLET 10 CC.,..... LOW STRENGTH BOND	AS REQ

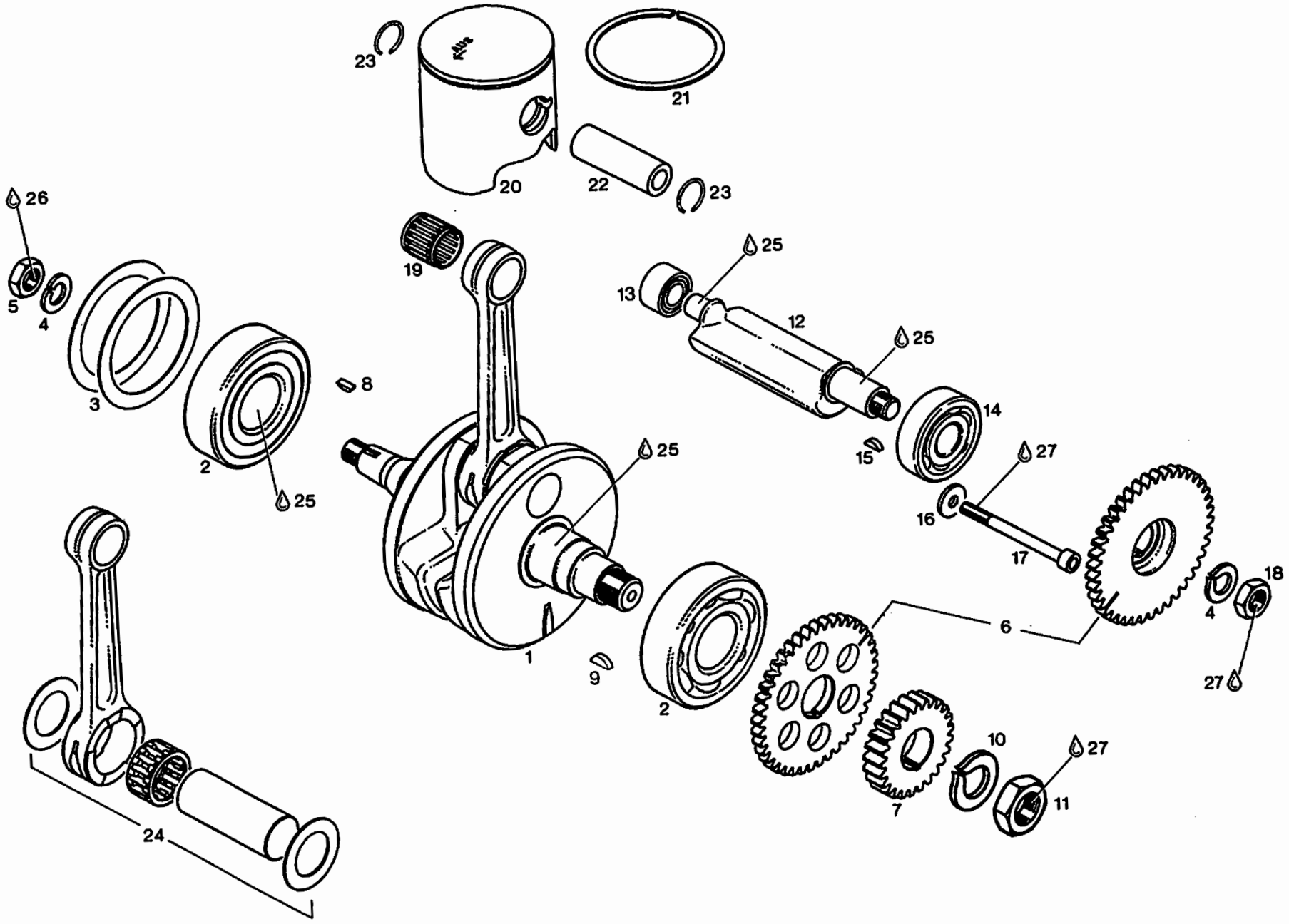


CRANKSHAFT, BALANCER DRIVE, PISTON

FOR ENGINE-TYPE 257

ILL. NO.	PART NO.	D E S C R I P T I O N	QTY.
1	294 862	CRANKSHAFT ASSY.,.....	1
2	932 571	BALL BEARING 6306TNH C3 32-72-19.....	2
3	427 660	SHIM 56X72X0,3.....	AS REQ
3	427 661	SHIM 56X72X0,5.....	AS REQ
3	427 662	SHIM 56X72X0,1.....	AS REQ
3	427 663	SHIM 56X72X0,2.....	AS REQ
4	945 754	LOCK WASHER A12.....	2
5	642 051	HEX. NUT M12X1..... TIGHTENING TORQUE 70 NM (620 IN.LB.)	1
6	295 260	BALANCE DRIVE ASSY.....	1
7	294 331	PRIMARY DRIVE ASSY..... REPLACE ONLY DRIVE GEAR WITH CLUTCH DRUM ASSY.	1
8	246 055	WOODRUFF KEY 3X3,7.....	1
9	946 005	WOODRUFF KEY 5X6,5.....	1
10	945 757	LOCK WASHER 18.....	1
11	942 220	HEX. NUT M18X1,5..... TIGHTENING TORQUE 120 NM (1060 IN.LB.)	1
12	220 042	BALANCE SHAFT.....	1
13	232 600	NEEDLE BEARING 12X24X13.....	1
14	932 815	BALL BEARING 6303E C3, 17-47-14..... FOR BALANCE SHAFT, CLUTCH SIDE	1
15	246 015	WOODRUFF KEY 3X5.....	1
16	827 305	WASHER 6,2/18/2.....	1
17	241 871	ALLEN SCREW M6X70.....	1
18	642 055	HEX. NUT M12X1..... TIGHTENING TORQUE 70 NM (620 IN.LB.)	1
19	932 904	NEEDLE CAGE 18X22X22.....	1

ILL. NO.	PART NO.	D E S C R I P T I O N	QTY.
20 - 21	294 850	PISTON ASSY. 67,44/67,45..... WITH RING, STANDARD	1
20 - 21	294 851	PISTON ASSY. 67,46 MM..... WITH RING, 1ST OVERSIZE	1
20 - 21	294 852	PISTON ASSY. 67,47 MM..... WITH RING, 2ND OVERSIZE	1
21	215 760	RECT. RING 67,25.,.....	1
22	916 136	PISTON PIN 18X11X53,7.....	1
23	945 735	CIRCLIP 18..... USE ONLY ONCE	2
24	294 864	CRANKSHAFT REPAIR KIT.....	1
25	297 431	LOCTITE ANTI-SEIZE 76710 10 GR.,..... TO PREVENT METAL GALLING	AS REQ
26	899 783	LOCTITE 648 GREEN, 5 GR.,..... HIGH STRENGTH BOND	AS REQ
27	899 785	LOCTITE 221 VIOLET 10 CC.,..... LOW STRENGTH BOND	AS REQ

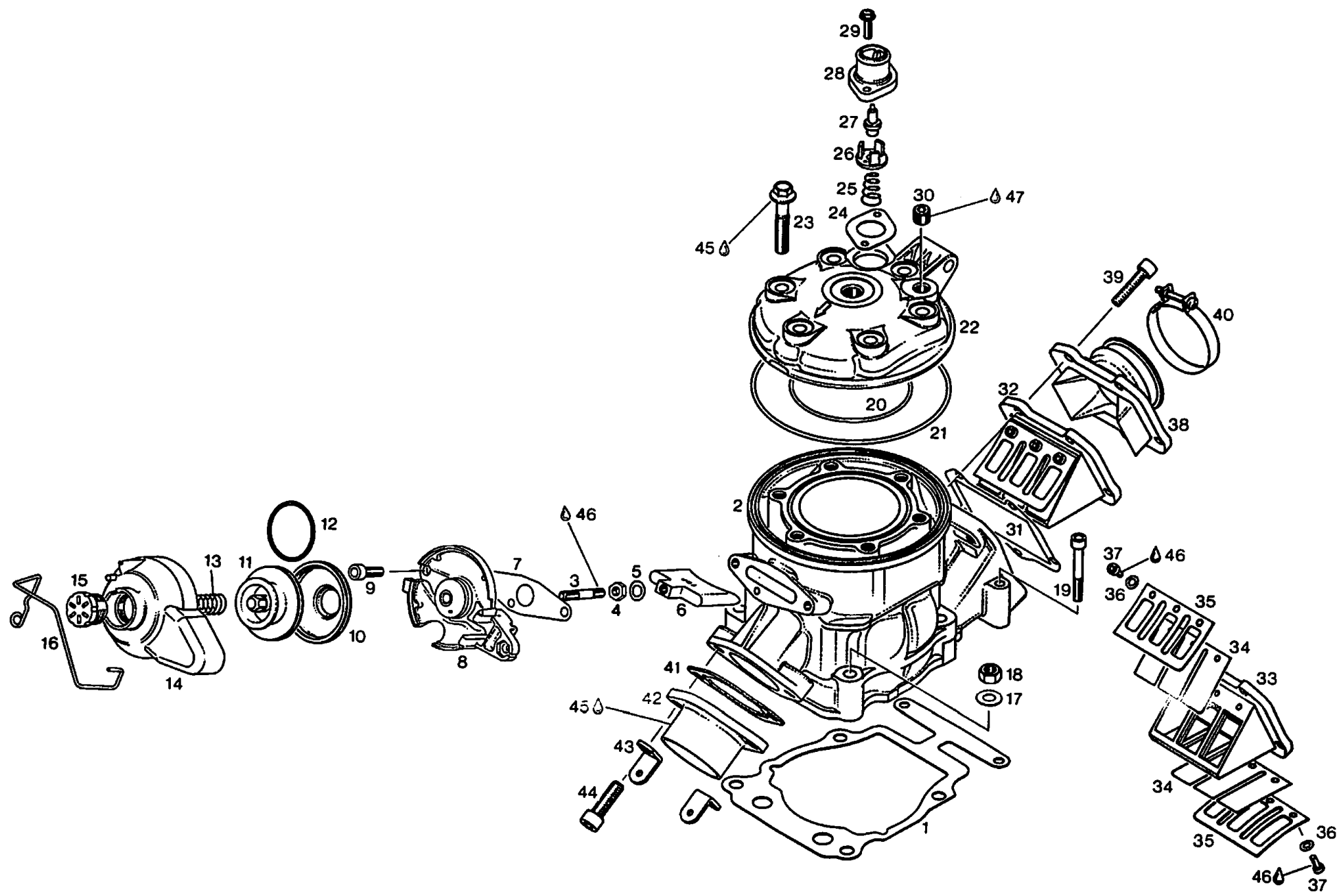


CRANKSHAFT, BALANCER DRIVE, PISTON

FOR ENGINE-TYPE 287

ILL. NO.	PART NO.	D E S C R I P T I O N	QTY.
1	294 862	CRANKSHAFT ASSY.....	1
2	932 571	BALL BEARING 6306TNH C3 32-72-19.....	2
3	427 660	SHIM 56X72X0,3.....	AS REQ
3	427 661	SHIM 56X72X0,5.....	AS REQ
3	427 662	SHIM 56X72X0,1.....	AS REQ
3	427 663	SHIM 56X72X0,2.....	AS REQ
4	945 754	LOCK WASHER A12.....	2
5	642 051	HEX. NUT M12X1..... TIGHTENING TORQUE 70 NM (620 IN.LB.)	1
6	295 260	BALANCE DRIVE ASSY.....	1
7	294 831	PRIMARY DRIVE ASSY..... REPLACE ONLY DRIVE GEAR WITH CLUTCH DRUM ASSY.	1
8	246 055	WOODRUFF KEY 3X3,7.....	1
9	946 005	WOODRUFF KEY 5X6,5.....	1
10	945 757	LOCK WASHER 18.....	1
11	942 220	HEX. NUT M18X1,5..... TIGHTENING TORQUE 120 NM (1060 IN.LB.)	1
12	220 042	BALANCE SHAFT.....	1
13	232 600	NEEDLE BEARING 12X24X13.....	1
14	932 815	BALL BEARING 6303E C3, 17-47-14..... FOR BALANCE SHAFT, CLUTCH SIDE	1
15	246 015	WOODRUFF KEY 3X5.....	1
16	827 305	WASHER 6,2/18/2.....	1
17	241 871	ALLEN SCREW M6X70.....	1
18	642 055	HEX. NUT M12X1..... TIGHTENING TORQUE 70 NM (620 IN.LB.)	1
19	932 904	NEEDLE CAGE 18X22X22.....	1

ILL. NO.	PART NO.	D E S C R I P T I O N	QTY.
20 - 21	294 855	PISTON ASSY., 67,44/67,95 MM..... WITH RING, STANDARD	1
20 - 21	294 856	PISTON ASSY., 67,96 MM..... WITH RING, 1ST OVERSIZE	1
20 - 21	294 857	PISTON ASSY., 67,97 MM..... WITH RING, 2ND OVERSIZE	1
21	215 765	RECTANGULAR RING 68/62,4X1,25.....	1
22	916 136	PISTON PIN 18X11X53,7.....	1
23	945 735	CIRCLIP 18..... USE ONLY ONCE	2
24	294 864	CRANKSHAFT REPAIR KIT.....	1
25	297 431	LOCTITE ANTI-SEIZE 76710 10 GR.,..... TO PREVENT METAL GALLING	AS REQ
26	899 788	LOCTITE 648 GREEN, 5 GR.,..... HIGH STRENGTH BOND	AS REQ
27	899 785	LOCTITE 221 VIOLET 10 CC.,..... LOW STRENGTH BOND	AS REQ



CYLINDER, EXHAUST VALVE, CYLINDER HEAD,
THERMOSTAT, INTAKE SOCKET

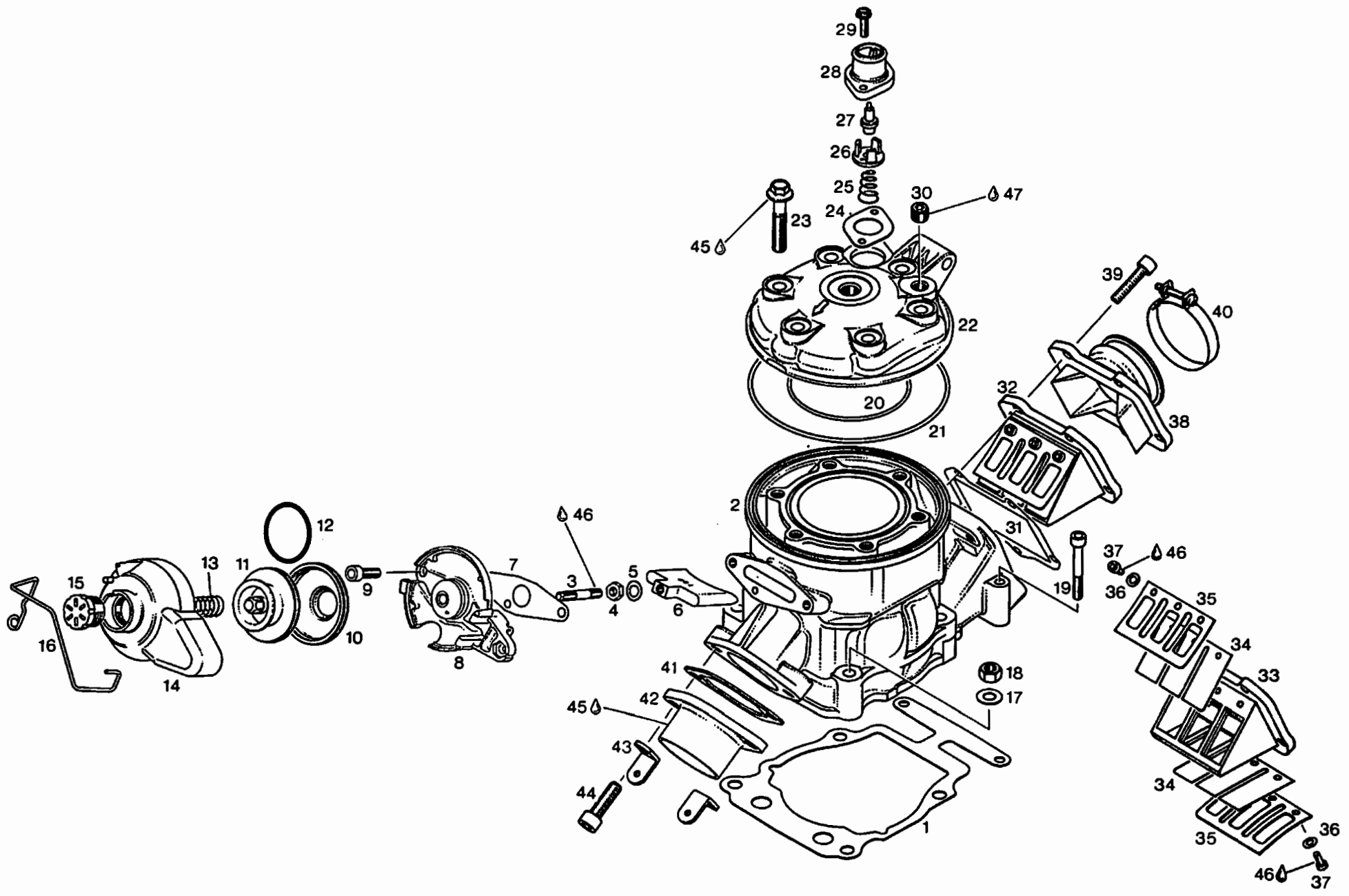
FOR ENGINE-TYPE 257

ILL. NO.	PART NO.	D E S C R I P T I O N	QTY.

1	250 745	GASKET 0,5.....	AS REQ
1	250 746	GASKET 0,3.....	AS REQ
1	250 747	GASKET 0,8.....	AS REQ
2 - 16	295 070	CYL. WITH EXHAUST VALVE ASSY.....	1
2	223 790	NIKASIL CYLINDER.....	1
3	941 145	STUD M6X30,5/12.....	1
4	242 031	HEX.NUT BM6.....	1
5	244 216	WASHER 6,2/14/1.....	1
6	253 710	EXHAUST VALVE.....	1
7	250 231	GASKET.....	1
8	253 380	VALVE ROD HOUSING.....	1
9	840 391	ALLEN SCREW M6X14..... TIGHTENING TORQUE 10 NM (85 IN.LB.)	2
10	260 728	BELLOWS.....	1
11	253 255	EXHAUST VALVE PISTON.....	1
12	239 040	HOSE SPRING 134-2,3-0,4-0,0.....	1
13	239 941	COMPRESSION SPRING 52,5 / 0,8 MM.....	1
14	210 331	VALVE COVER.....	1
15	241 220	ADJUSTMENT SCREW.....	1
16	239 030	SPRING CLIP.....	1
17	250 311	WASHER 8,4.....	4
18	942 671	HEX. NUT M8..... TIGHTENING TORQUE 20 NM (175 IN.LB.)	4
19	241 821	ALLEN SCREW M6X45.....	2
20	831 790	O-RING 78X2.....	1
21	250 750	O-RING 129X2,5-N.....	1

ILL. NO.	PART NO.	DESCRIPTION	QTY.
22	223 810	CYLINDER HEAD..... LIGHT GRAY	1
23	940 636	COLLAR-HEX. SCREW M8X45 SW 11..... TIGHTENING TORQUE 20 NM (175 IN.LB.)	6
24	250 020	GASKET.....	1
25	239 950	COMPRESSION SPRING.....	1
26	222 175	THERMOSTAT HOLDER.....	1
27	222 125	THERMOSTAT, 45 DEGR..... STANDARD	1
27	222 122	THERMOSTAT 70 DEGR.,..... OPTION	1
27	222 120	THERMOSTAT, 58 DEGR..... OPTION	1
28	222 360	WATER OUTLET SOCKET.....	1
29	941 925	TAPTITE SCREW M5X16.....	2
30	240 480	PLUG SCREW 1/8-27NPT.....	1
31	250 521	GASKET.....	1
32 - 37	224 387	REED VALVE ASSY.,.....	1
33	 REED VALVE, NOT AVAILABLE AS SPARE PART USE REED VALVE ASSY. 224 387	1
34	224 430	REED PETAL.....	2
35	 REED PETAL STOP, NOT AVAILABLE AS SPARE PART, USE REED VALVE ASSY. 224 387	2
36	945 758	LOCK WASHER A4.....	6
37	940 235	ALLEN SCREW M4X8.....	6
38	267 915	CARBURETOR FLANGE 42,5 MM.....	1
39	840 861	ALLEN SCREW M6X25..... TIGHTENING TORQUE 6 NM (50 IN.LB.)	5
40	251 850	HOSE CLAMP 51.....	1
41	830 271	GASKET.....	1
42	273 692	EXHAUST SOCKET.....	1
43	224 067	SPRING BRACKET.....	2

ILL. NO.	PART NO.	D E S C R I P T I O N	QTY.
44	240 081	ALLEN SCREW M8X25..... TIGHTENING TORQUE 20 NM (175 IN.LB.)	2
45	297 431	LOCTITE ANTI-SEIZE 76710 10 GR.,..... TO PREVENT METAL GALLING	AS REQ
46	899 788	LOCTITE 648 GREEN, 5 GR.,..... HIGH STRENGTH BOND	AS REQ
47	899 785	LOCTITE 221 VIOLET 10 CC.,..... LOW STRENGTH BOND	AS REQ

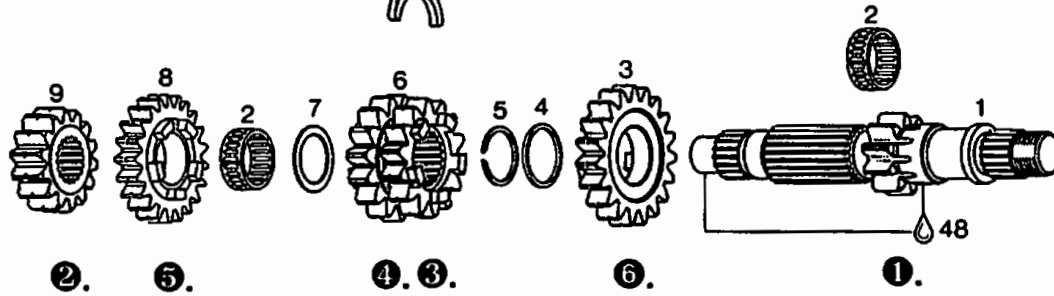
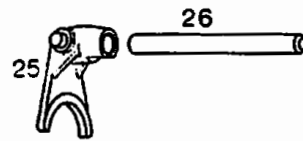
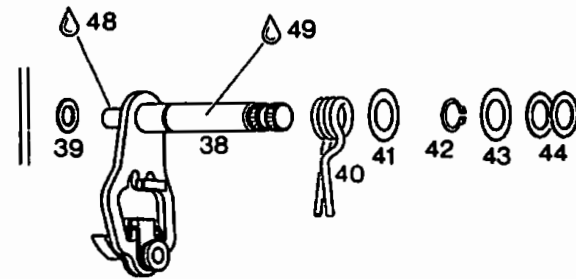
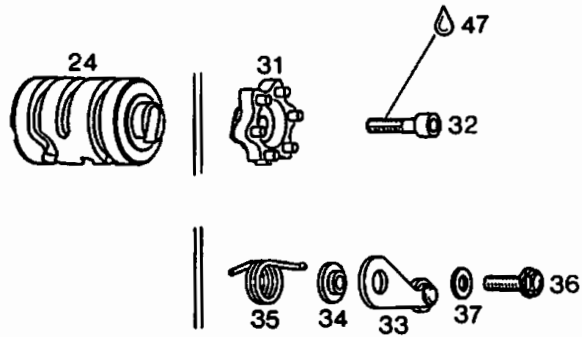
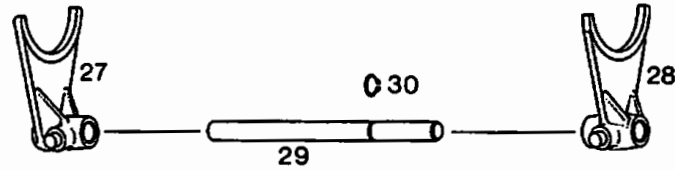
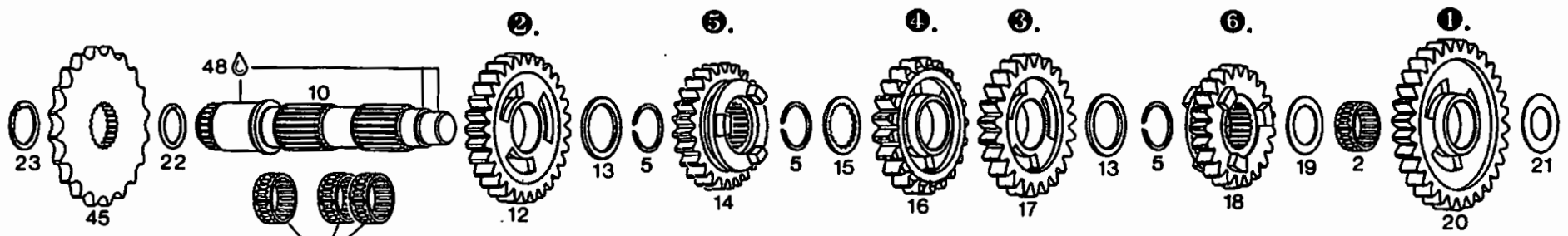


CYLINDER, EXHAUST VALVE, CYLINDER HEAD,
THERMOSTAT, INTAKE SOCKET

FOR ENGINE-TYPE 287

ILL. NO.	PART NO.	DESCRIPTION	QTY.
1	250 745	GASKET 0,5.....	AS REQ
1	250 746	GASKET 0,3.....	AS REQ
1	250 747	GASKET 0,8.....	AS REQ
2	223 795	NIKASIL CYLINDER.....	1
3	941 145	STUD M6X30,5/12.....	1
4	242 031	HEX.NUT M6.....	1
5	244 216	WASHER 6,2/14/1.....	1
6	253 710	EXHAUST VALVE.....	1
7	250 231	GASKET.....	1
8	253 380	VALVE ROD HOUSING.....	1
9	840 391	ALLEN SCREW M6X14..... TIGHTENING TORQUE 10 NM (85 IN.LB.)	2
10	260 728	BELLOWS.....	1
11	253 255	EXHAUST VALVE PISTON.....	1
12	239 040	HOSE SPRING 134-2,3-0,4-0,0.....	1
13	239 941	COMPRESSION SPRING 52,5 / 0,8 MM.....	1
14	210 331	VALVE COVER.....	1
15	241 220	ADJUSTMENT SCREW.....	1
16	239 030	SPRING CLIP.....	1
17	250 311	WASHER 8,4.....	4
18	942 671	HEX. NUT M8..... TIGHTENING TORQUE 20 NM (175 IN.LB.)	4
19	241 821	ALLEN SCREW M6X45.....	2
20	831 790	O-RING 78X2.....	1
21	250 750	O-RING 129X2,5-N.....	1

ILL. NO.	PART NO.	D E S C R I P T I O N	QTY
22	223 810	CYLINDER HEAD..... LIGHT GRAY	1
23	940 636	COLLAR-HEX. SCREW M8X45 SW 11..... TIGHTENING TORQUE 20 NM (175 IN.LB.)	6
24	250 020	GASKET.....	1
25	239 950	COMPRESSION SPRING.....	1
26	222 175	THERMOSTAT HOLDER.....	1
27	222 125	THERMOSTAT, 45 DEGR..... STANDARD	1
27	222 122	THERMOSTAT 70 DEGR.,..... OPTION	1
27	222 120	THERMOSTAT, 58 DEGR..... OPTION	1
28	222 360	WATER OUTLET SOCKET.....	1
29	941 925	TAPTITE SCREW M5X16.....	2
30	240 480	PLUG SCREW 1/8-27NPT.....	1
31	250 521	GASKET.....	1
32 - 37	224 387	REED VALVE ASSY.,.....	1
33	 REED VALVE, NOT AVAILABLE AS SPARE PART USE REED VALVE ASSY. 224 387	1
34	224 430	REED PETAL.....	2
35	 REED PETAL STOP, NOT AVAILABLE AS SPARE PART, USE REED VALVE ASSY. 224 387	2
36	945 758	LOCK WASHER A4.....	6
37	940 235	ALLEN SCREW M4X8.....	6
38	267 915	CARBURETOR FLANGE 42,5 MM.....	1
39	840 861	ALLEN SCREW M6X25..... TIGHTENING TORQUE 6 NM (50 IN.LB.)	5
40	251 850	HOSE CLAMP 51.....	1
41	830 271	GASKET.....	1
42	273 692	EXHAUST SOCKET.....	1
43	224 067	SPRING BRACKET.....	2



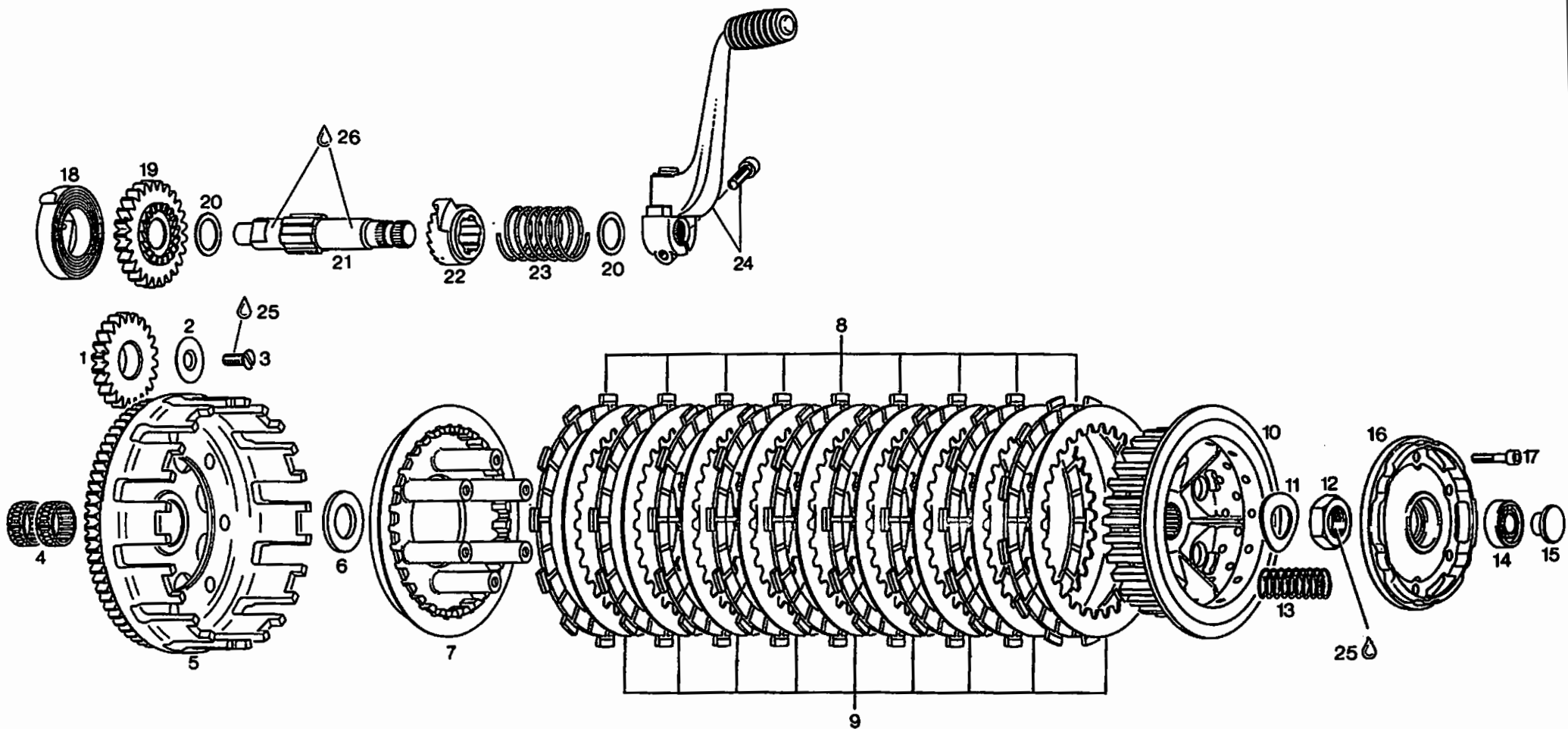
ILL. NO.	PART NO.	D E S C R I P T I O N	QTY.
44	240 081	ALLEN SCREW M8X25..... TIGHTENING TORQUE 20 NM (175 IN.LB.)	2
45	297 431	LOCTITE ANTI-SEIZE 76710 10 GR.,..... TO PREVENT METAL GALLING	AS REQ
46	899 788	LOCTITE 648 GREEN, 5 GR.,..... HIGH STRENGTH BOND	AS REQ
47	899 785	LOCTITE 221 VIOLET 10 CC.,..... LOW STRENGTH BOND	AS REQ

6-SPEED TRANSMISSION

ILL. NO.	PART NO.	DESCRIPTION	QTY.
1 - 23	281 202	TRANSMISSION SET 3.56.....	1
1	220 110	CLUTCH SHAFT 10 T..... 1ST SPEED	1
2	232 662	NEEDLE BEARING 20X24X10.....	3
3	234 886	FREE PINION 22 T.,..... 6TH SPEED, CLUTCH SHAFT	1
4	227 470	THRUST WASHER 24,2/27,5/1,5.....	1
5	245 340	SNAPRING 24.....	4
6	235 262	GEAR PINION 16/19 T.,..... 3RD / 4TH SPEED, CLUTCH SHAFT	1
7	227 440	THRUST WASHER 20,2/27,5/1.....	1
8	234 866	FREE PINION 21 T.,..... 5TH SPEED, CLUTCH SHAFT	1
9	234 826	FIXED GEAR 13 T.,..... 2ND SPEED, CLUTCH SHAFT	1
10	220 120	MAINSHAFT.....	1
11	232 742	NEEDLE BEARING 21X25X10.....	3
12	234 819	FREE PINION 30 T.,..... 2ND SPEED, MAINSHAFT	1
13	227 460	THRUST WASHER 22/30/1,8.....	2
14	234 879	GEAR PINION 23 T.,..... 5TH SPEED, MAINSHAFT	1
15	227 490	ANGULAR RING 22/30/2,8.....	1
16	234 859	FREE PINION 25 T.,..... 4TH SPEED, MAINSHAFT	1
17	234 838	FREE PINION 27 T.,..... 3RD SPEED, MAINSHAFT	1
18	234 994	GEAR PINION 21 T.,..... 6TH SPEED, MAINSHAFT	1
19	944 468	THRUST WASHER 20,5/30/1.....	1

ILL. NO.	PART NO.	DESCRIPTION	QTY.
20	234 809	FREE PINION 34 T.,..... 1ST SPEED, MAINSHAFT	1
21	227 430	THRUST WASHER 17,2/30/1.....	1
22	250 050	O-RING 18-2,5.....	1
23	245 650	RETAINING RING AV 20.....	1
24	258 226	SHIFT DRUM ASSY.,.....	1
25	258 133	SHIFT FORK..... 5TH/6TH SPEED	1
26	258 205	FORK SPINDLE..... 5TH/6TH SPEED	1
27	258 123	GEARSHIFT FORK..... 2ND/4TH SPEED	1
28	258 113	GEARSHIFT FORK..... 1ST/3RD SPEED	1
29	258 200	FORK SPINDLE.....	1
30	245 570	RETAINING RING 8X0,8.....	1
31	258 210	INDEX SHIM.....	1
32	840 861	ALLEN SCREW M6X25..... TIGHTENING TORQUE 10 NM (85 IN.LB.)	1
33	248 325	INDEX LEVER ASSY.....	1
34	227 710	STEP RING.....	1
35	239 240	INDEX SPRING.....	1
36	240 580	TAPTITE SCREW M6X16.....	1
37	244 211	WASHER 6,4.....	1
38	220 187	SHIFT SHAFT WITH PAWL ASSY.....	1
39	944 033	WASHER 8,4/14/1.....	1
40	239 251	SPRING.....	1
41	827 265	WASHER 12,5/21,5/2.....	1
42	945 470	RETAINING RING 12X1.....	1
43	227 450	THRUST WASHER 12,5/21,5/0,5.....	1
44	944 382	SHIM 12,1/18,5/0,5.....	AS REQ
44	944 383	SHIM 12,1/18,5/0,3.....	AS REQ

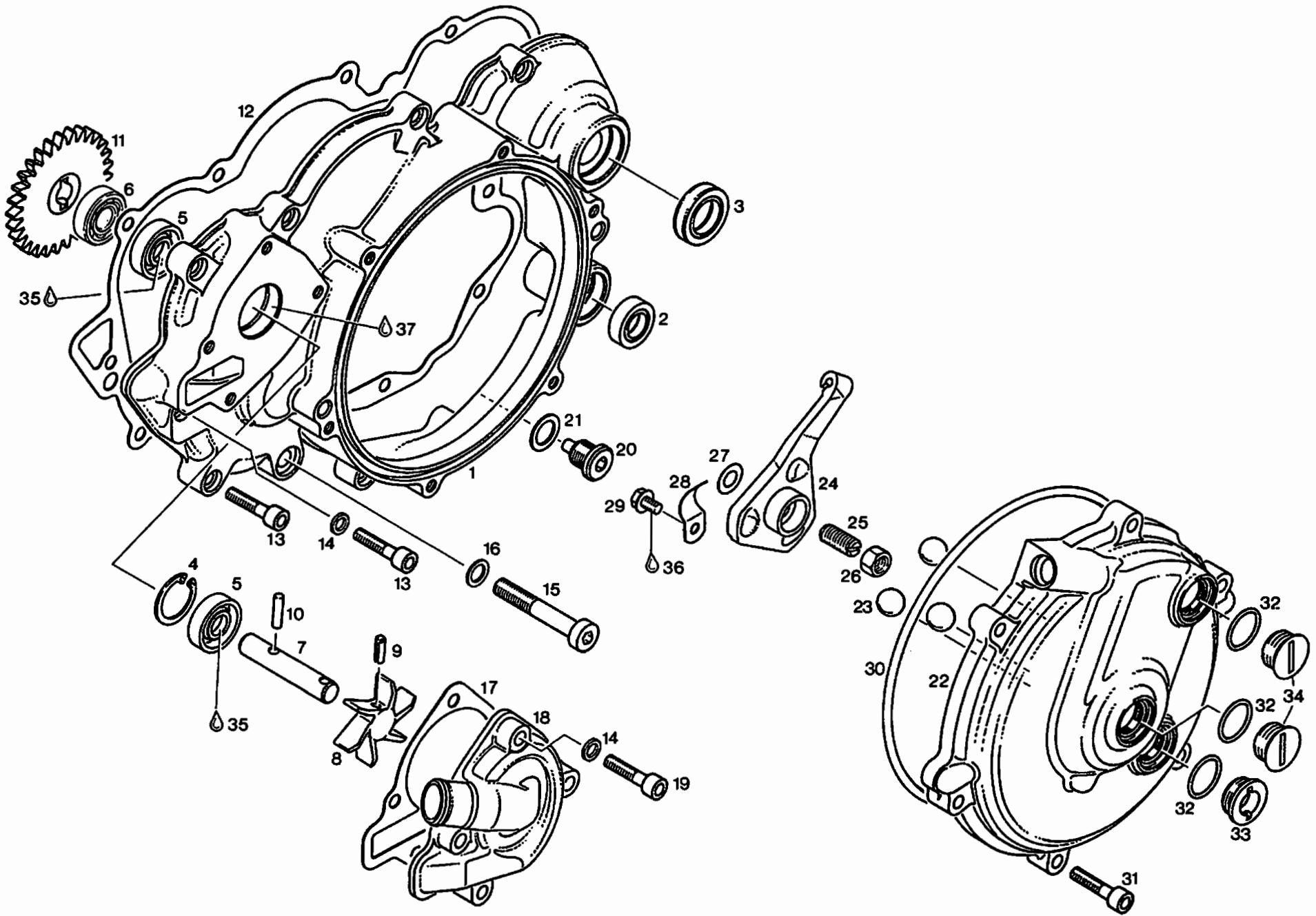
ILL. NO.	PART NO.	D E S C R I P T I O N	QTY.
45	236 061	SPROCKET 14 T., 5/8X1/4X10,16..... MOUNTED AS STANDARD	1
45	236 062	SPROCKET 15 T., 5/8X1/4X10,16.....	1
45	236 063	SPROCKET 16 T., 5/8X1/4X10,16.....	1
45	236 064	SPROCKET 17 T.....	1
46	248 232	SHIFT LEVER ASSY.....	1
47	899 785	LOCTITE 221 VIOLET 10 CC.,..... LOW STRENGTH BOND	AS REQ
48	297 431	LOCTITE ANTI-SEIZE 76710 10 GR.,..... TO PREVENT METAL GALLING	AS REQ
49	897 330	LITHIUM-BASE GREASE, 250 GR.,.....	AS REQ



CLUTCH, KICK START

ILL. NO.	PART NO.	D E S C R I P T I O N	QTY.
1	634 170	IDLE GEAR ASSY. 22 T.....	1
2	227 290	THRUST WASHER.....	1
3	240 300	COUNTERSUNK SCREW M6X20..... TIGHTENING TORQUE 8 NM (65 IN.LB.)	1
4	232 742	NEEDLE BEARING 21X25X10.....	2
5	294 831	PRIMARY DRIVE ASSY..... REPLACE ONLY DRIVE GEAR WITH CLUTCH DRUM ASSY.	1
6	227 600	THRUST WASHER 20,2/35/3.....	1
7	259 889	INNER PLATE.....	1
8	259 905	FRICITION PLATE 2,6 MM.....	9
9	259 910	PLATE, CLUTCH DRIVEN.....	9
10	259 874	CLUTCH HUB.....	1
11	245 680	SPRING WASHER.....	1
12	942 220	HEX. NUT M19X1,5..... TIGHTENING TORQUE 120 NM (1000 IN.LB.)	1
13	239 625	CLUTCH SPRING 34,1 MM..... CHANGE SPRINGS ONLY SETWISE FN= 212 N AT LN= 20,5 MM	6
14	232 400	BALL BEARING 6001 C3, 12-28-8.....	1
15	259 140	THRUST HUB.....	1
16	259 130	RETAINING PLATE.....	1
17	240 136	ALLEN SCREW M5X25..... TIGHTENING TORQUE 6 NM (50 IN.LB.)	6
18	239 260	KICK STARTING SPRING.....	1
19	634 050	KICK START GEAR ASSY. 27 T.....	1
20	244 585	SHIM 17,5/24/1,0.....	2
21	220 130	KICK START SHAFT.....	1
22	228 220	RATCHET GEAR.....	1
23	239 270	COMPRESSION SPRING 42 MM.....	1

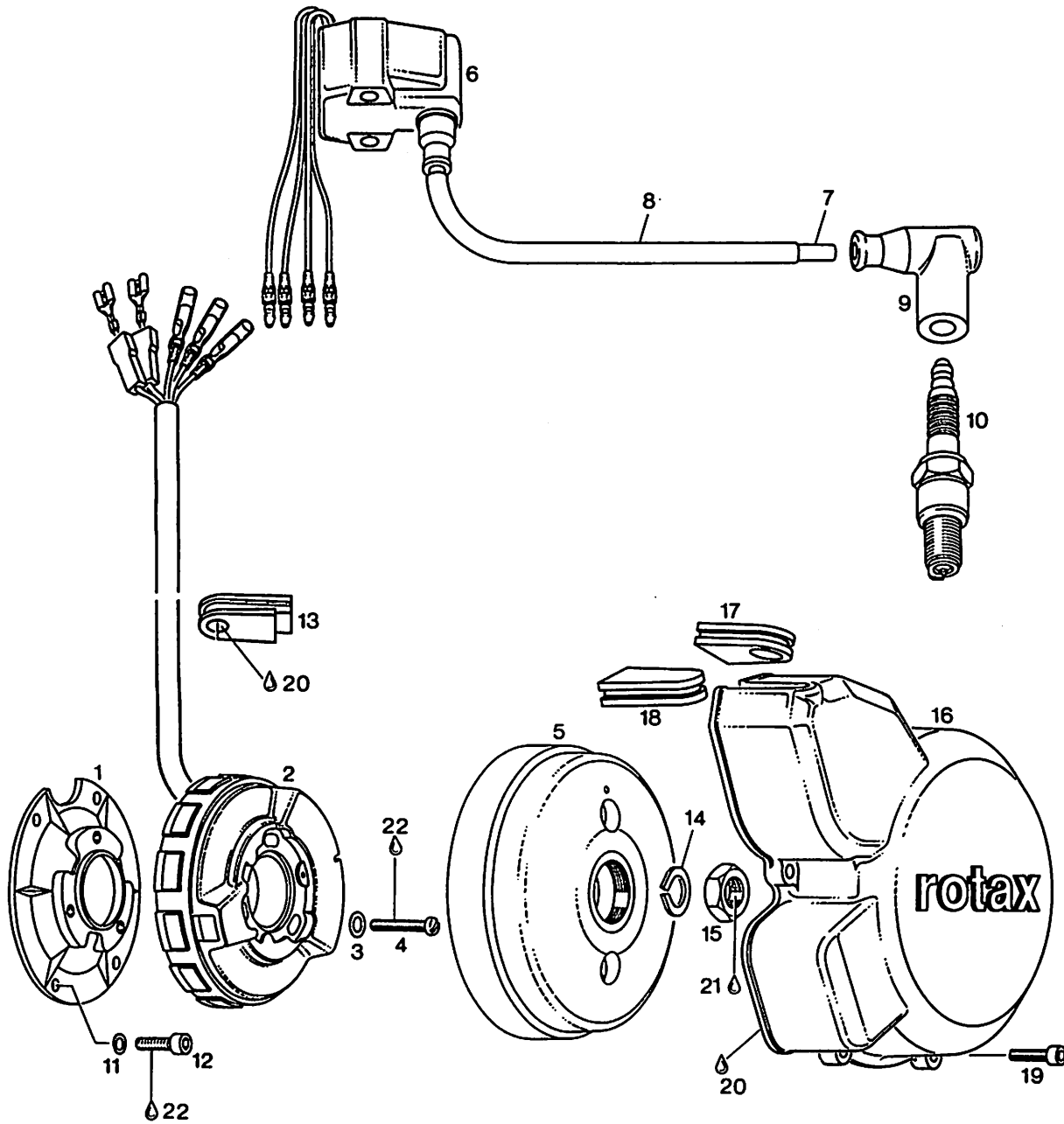
24	248 330	KICK START LEVER ASSY.....	1
25	899 785	LOCTITE 221 VIOLET 10 CC..... LOW STRENGTH BOND	AS REQ
26	297 431	LOCTITE ANTI-SEIZE 76710 10 GR..... TO PREVENT METAL GALLING	AS REQ



CLUTCH COVER, WATER PUMP

ILL. NO.	PART NO.	D E S C R I P T I O N	QTY.
1	210 972	CLUTCH COVER..... LIGHT-GRAY	1
2	250 455	OIL SEAL 12X22X7.....	1
3	930 725	OIL SEAL 17X28X7.....	1
4	245 555	SNAPRING 26X1,2.....	1
5	230 195	OIL SEAL 10X26X7.....	2
6	232 100	BALL BEARING 6000 10-26-8.....	1
7	220 090	PUMP SHAFT.....	1
8	222 390	IMPELLER.....	1
9	229 280	SLOTTED SPRING PIN 4X16.....	1
10	232 730	PEG 4X15,3.....	1
11	634 152	PUMP GEAR 29 T.....	1
12	250 700	GASKET.....	1
13	840 861	ALLEN SCREW M6X25..... TIGHTENING TORQUE 10 NM (88 IN.LB.)	11
14	230 415	GASKET RING A 6X10.....	2
15	240 711	ALLEN SCREW M8X50..... TIGHTENING TORQUE 18 NM (160 IN.LB.)	1
16	950 141	GASKET RING A 8X13.....	1
17	250 691	GASKET.....	1
18	222 370	WATER PUMP HOUSING..... LIGHT-GRAY	1
19	840 861	ALLEN SCREW M6X25..... TIGHTENING TORQUE 10 NM (88 IN.LB.)	4
20	241 782	MAGNETIC DRAIN PLUG M12X1,5.....	1
21	250 641	GASKET RING A 12X18.....	1
22	210 965	CLUTCH RELEASE COVER..... LIGHT GRAY	1
23	232 150	BALL 12 MM.....	3
24	259 325	RELEASE CAM.....	1

ILL. NO.	PART NO.	D E S C R I P T I O N	QTY.
25	240 310	ADJUSTMENT SCREW M8X19,5.....	1
26	942 671	HEX. NUT M8.....	1
27	227 945	THRUST WASHER 8,1/15/0,5.....	1
28	239 905	LEAF SPRING.....	1
29	841 685	TAPTITE-SCREW M5X10.....	1
30	250 710	O-RING 150X4.....	1
31	941 691	CYL.-SCREW M6X25..... TIGHTENING TORQUE 10 NM (88 IN.LB.)	6
32	250 890	O-RING DIN 3771-17X1,5-N.....	3
33	240 820	OIL LEVEL SCREW M18X1,5.....	1
34	241 801	PLUG SCREW M18X1,5.....	2
35	397 161	MOLYKOTE 111, 100 GR.,..... SILICONE GREASE	AS REQ
36	899 785	LOCTITE 221 VIOLET 10 CC.,..... LOW STRENGTH BOND	AS REQ
37	 LUBRICATING OIL	AS REQ

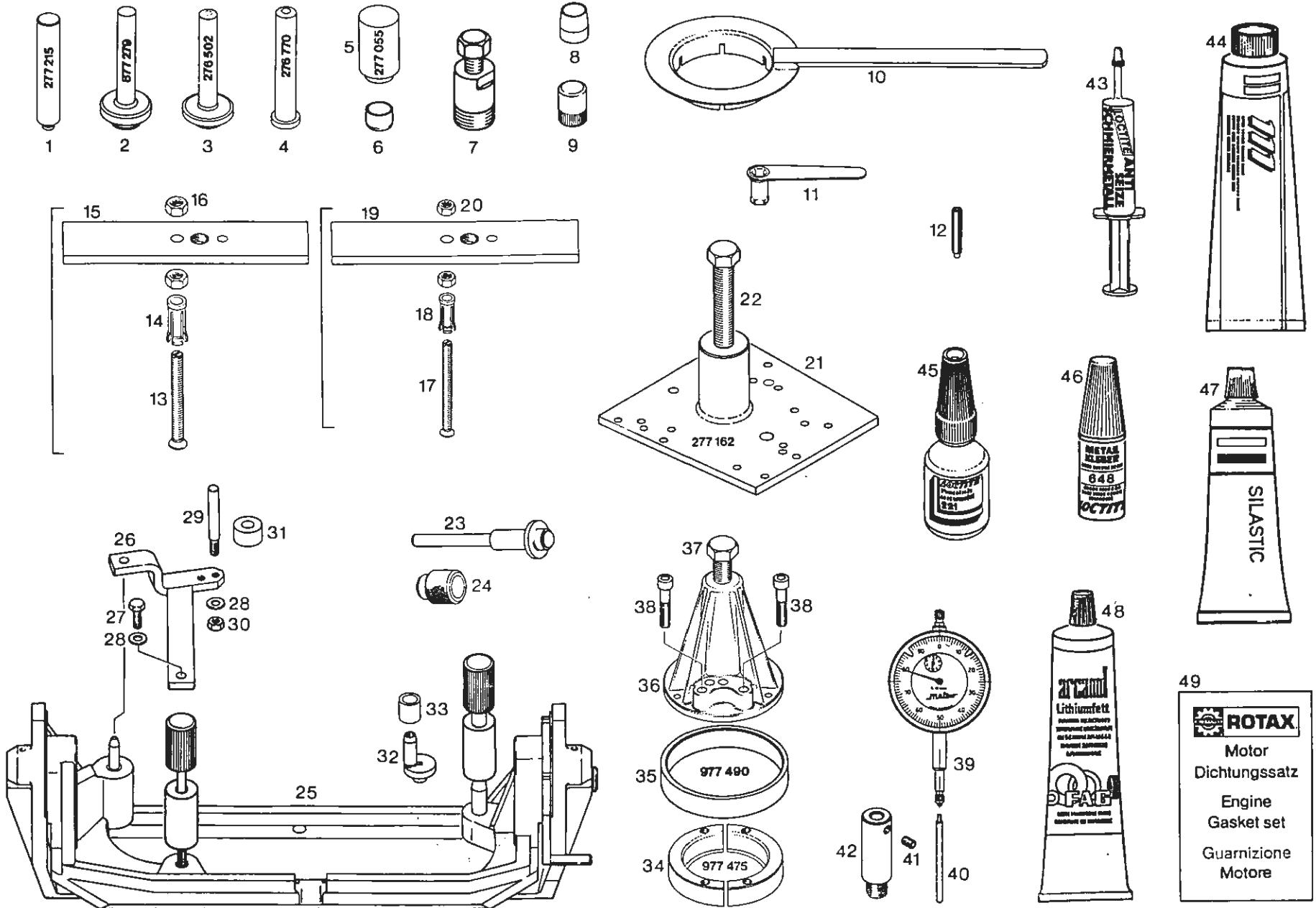


S E M MAGNETO GENERATOR, IGNITION COVER

ILL. NO.	PART NO.	D E S C R I P T I O N	QTY.
1 - 9	294 452	MAGNETO GENERATOR SEM WG.....	1
1	265 965	STATOR PLATE.....	1
2	293 377	STATOR WG ASSY.,.....	1
3	927 571	WASHER 5,3.....	3
4	241 591	SLOTTED HEAD SC EW M5X30..... TIGHTENING TORQUE 6 NM (55 IN.LB.)	3
5	294 095	MAGNETO FLYWHEEL.....	1
6	265 987	IGNITION COIL WG..... BLUE	1
7	964 180	IGNITION CABLE 200 MM.....	1
8	260 434	PROTECTION HOSE 140 MM.....	1
9	866 708	SPARK PLUG CONNECTOR.....	1
10	897 050	SPARK PLUG 14 MM..... NGK B8ES	1
11	945 750	LOCK WASHER A5.....	4
12	240 150	ALLEN SCREW M5X14..... TIGHTENING TORQUE 6 NM (55 IN.LB.)	4
13	260 840	GROMMET.....	1
14	945 754	LOCK WASHER A12.....	1
15	642 051	HEX. NUT M12X1..... TIGHTENING TORQUE 70 NM (620 IN.LB.)	1
16	211 040	IGNITION COVER, LIGHT-GRAY.....	1
17	260 070	OIL CABLE GROMMET.....	1
18	260 060	RUBBER GROMMET.....	1
19	240 181	ALLEN SCREW M5X20..... TIGHTENING TORQUE 4,5 NM (38 IN.LB.)	6
20	297 386	SILASTIC 732 RTV, 100 GR.,.....	AS REQ
21	899 788	LOCTITE 648 GREEN, 5 GR.,..... HIGH STRENGTH BOND	AS REQ

ILL. NO. PART NO. DESCRIPTION QTY.

22 899 785 LOCTITE 221 VIOLET 10 CC.,..... AS REQ
LOW STRENGTH BOND



REPAIR TOOLS, GASKET SETS

ILL. NO.	PART NO.	D E S C R I P T I O N	QTY.

1	277 215	INSERTION JIG..... FOR OIL SEAL 250 455, SHIFT SHAFT	1
2	877 279	INSERTION JIG ASSY.,..... FOR OIL SEAL 230 425, CRANKSHAFT, CLUTCH SIDE	1
3	276 502	INSERTION JIG ASSY.,..... FOR OIL SEAL 930 675 AND 830 602, CRANKSHAFT AND MAIN SHAFT MAGNETO-SIDE	1
4	276 770	INSERTION JIG..... FOR OIL SEAL 230 195 AND 930 725 PUMP SHAFT AND KICKSTART SHAFT ALBERO POMPA E ALBERO M/M	1
5	277 055	INSERTION JIG..... TO REMOVE BALL BEARING 932 825 AND 232 766 MAIN SHAFT MAGNETO SIDE AND CLUTCH SHAFT CLUTCH SIDE	1
6	276 790	PROTECTION CAP 12/15..... FOR CRANKSHAFT, MAGNETO SIDE	1
7	276 807	PULLER ASSY., 26X1,5..... FOR FLYWHEEL	1
8	277 970	GUIDE SLEEVE..... FOR OIL SEAL 830 602, MAIN SHAFT	1
9	276 920	PROTECTION CAP..... FOR CRANKSHAFT, CLUTCH-SIDE	1
10	276 825	CLUTCH HUB LOCKING TOOL ASSY.,.....	1
11	276 040	WRENCH 11 MM..... FOR CLUTCH PLAY ADJUSTMENT	1
12	240 890	THREAD BOLT M8X50..... FOR CRANKSHAFT LOCKING	1
13 - 16	 PULLER ASSY., FOR NEEDLE BEARING 232 600 BALANCE SHAFT MAGNETO-SIDE	1
13	276 380	BOLT M10.....	1
14	276 375	EXTRACTOR SLEEVE..... FOR BALL BEARING 6304	1
15	276 390	SUPPORT PLATE.....	1
16	242090	HEX. NUT M10.....	2

ILL. NO.	PART NO.	DESCRIPTION	QTY.
17 - 20	 PULLER ASSY., FOR BALL BEARING 232 290 CLUTCH SHAFT MAGNETO-SIDE	1
17	276 385	BOLT.....	1
18	276 372	EXTRACTOR SLEEVE..... FOR BALL BEARING 6302	1
19	276 390	SUPPORT PLATE.....	1
20	242 200	HEX.NUT M8.....	2
21 - 22	277 162	PULLER PLATE ASSY.,..... FOR REMOVE CRANKSHAFT	1
22	940 755	HEX. SCREW M16X1,5X150.....	1
23 - 24	877 015	CIRCLIP INSTALLATION TOOL ASSY.,..... TO MOUNT PISTON PIN CIRCLIPS	1
23	877 010	CIRCLIP INSTALLATION PUSHER.....	1
24	877 020	CIRCLIP INSTALLATION SLEEVE.....	1
25	277 917	TRESTLE ASSY.,.....	1
26 - 32	277 107	INSERT KIT FOR TRESTLE.....	1
26	277 100	ADAPTOR ASSY.,.....	1
27	940 590	HEX. SCREW M8X20.....	1
28	250 311	WASHER 8,4.....	2
29	277 110	BOLT.....	1
30	242 206	HEX. NUT M8.....	1
31	847 160	SPACER 10,5/24/15.....	1
32	276 662	ECCENTRIC SLEEVE.....	1
33	847 230	DISTANCE SLEEVE 15,2/22/18.....	1
34	977 475	RING HALF..... FOR BALL BEARING 6306, CRANKSHAFT	2
35	977 490	RING..... FOR RING HALVES	1
36 - 38	876 298	PULLER ASSY.,..... FOR BALL BEARING 6306, CRANKSHAFT PER CUSCINETTO 6306, ALBERO MOTORE	1
37	940 755	HEX. SCREW M16X1,5X150.....	1

ILL. NO.	PART NO.	DESCRIPTION	QTY.
38	840 681	ALLEN SCREW M8X40..... FOR PULLER	4
39	876 950	PRECISION DIAL GAUGE.....	1
40	876 947	GAUGE PIN 52 MM.....	1
41	841 771	SET SCREW M6X8.....	1
42	876 940	GAUGE ADAPTER.....	1
43	297 431	LOCTITE ANTI-SEIZE 76710 10 GR.,..... TO PREVENT METAL GALLING, 10 GR.,	1
44	897 161	MOLYKOTE 111, 100 GR.,..... SILICONE GREASE, 100 GR.,	1
45	899 785	LOCTITE 221 VIOLET 10 CC.,..... LOW STRENGTH BOND	1
46	899 788	LOCTITE 648 GREEN, 5 GR.,..... HIGH STRENGTH BOND	1
47	297 386	SILASTIC 732 RTV, 100 GR.,.....	1
48	897 330	LITHIUM-BASE GREASE, 250 GR.,.....	1
49	295 090	GASKET SET.....	1