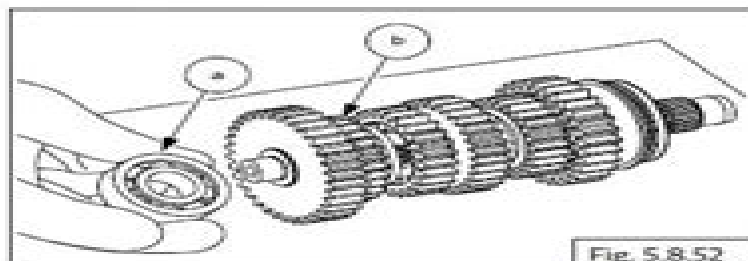
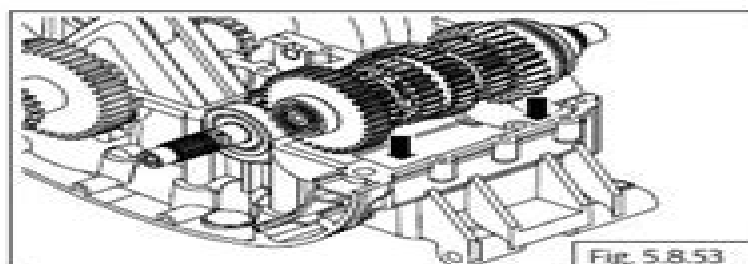


- Assemble ball bearing **(a)** on driveshaft **(b)** and ensure it is properly seated against thrust washer on driveshaft.

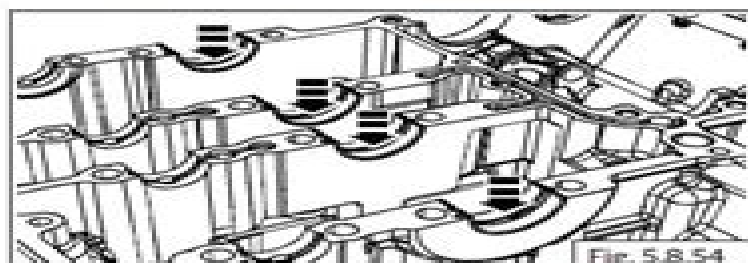


- Locate drive shaft assembly with gears on crankcase upper duly ensuring that the splines of the drive shaft are towards the LH side (Magneto side) of upper crankcase and the gears on counter shaft and drive shaft are properly meshed.



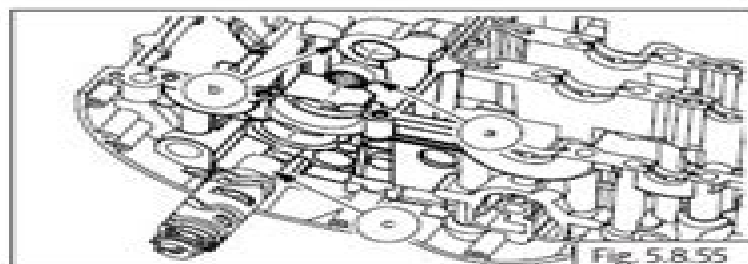
Journal bearings in lower crankcase

- Install crankshaft journal bearings into crankcase. Refer journal bearing chart ([section 5.7](#)).



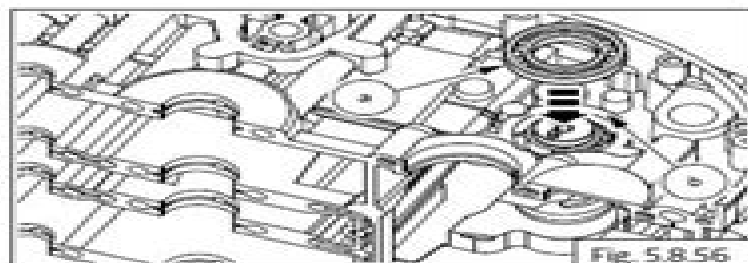
5.8.7. Gear Shift Cam Drum

- Assemble needle roller bearing **(a)** in lower crankcase **(b)** from the inside on LH side (Magneto side).
- Insert gear shift cam drum **(c)** into lower crankcase **(b)** from the RH side (clutch side), duly ensuring the 2 pegs to the gear shift cam drum are towards the RH side (clutch side).



SPL	Part No: ST-27543-1
	Part Name: Gear shifter Drum NRB Installer

- Assemble big bearing **(a)** on lower crankcase RH side **(b)** (clutch side) over the gear shift cam drum.



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Raffaella Di Napoli



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