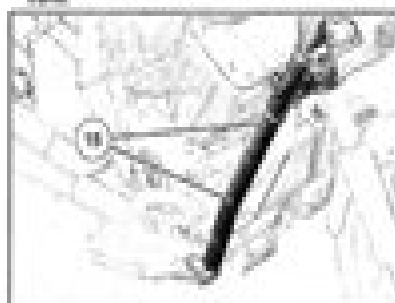


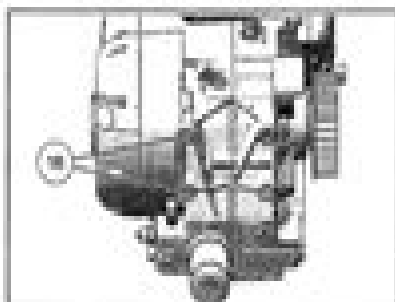
- Rotate engine carefully and remove from right side of frame.

**NOTE**

Protect right side of frame (1) while removing engine.

NOTE

Attach engine securely to an engine stand to prevent damage and/or loss of accessibility. Use spacers as needed for the stand you are using. Forklifts will be required; use the two-lift crane/lift mounts (2) only.

**IMPORTANT**

Debris could have collected in and around injector carrier. If injector removal is required, clean cavity and surrounding area with compressed air before removing injectors. If removed, injectors must be returned properly to the fuel rail (aligned) to ensure proper spray pattern. See Fuel Rail Installation, page 5.27.

PREPARATION

Refer to Engine Mounting, page 5.2 - (Suspension Mount Plate (Upper Bracket) - Rear Engine, page 5.4 for torque values and assembly views.

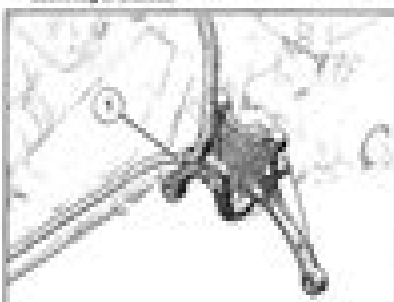
CAUTION

Arrange for assistance when installing engine. The engine must be held securely to prevent damage to engine, frame, wiring, or hoses. The engine is very heavy and could cause severe personal injury if not handled properly. Be sure engine is properly supported before proceeding.

IMPORTANT

Be sure alignment dowel pins are in place on frame, frame cradles and suspension bracket.

1. Clean mating surfaces of frame, suspension bracket, and engine crankcase. Grease dowel pins.
2. Be sure reservoir hose (3) is routed below frame and above leg of bracket.

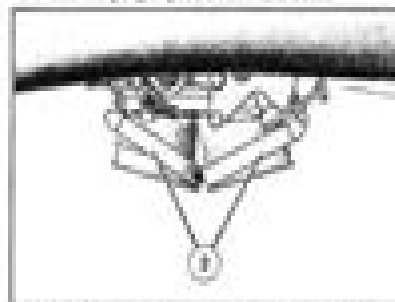


3. Raise rear wheel / frame off the bench to increase clearance of engine to frame tubes and bracket.

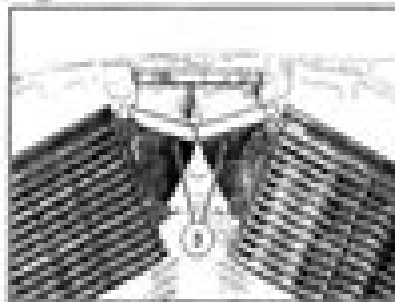
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ENGINE REMOVAL / INSTALLATION

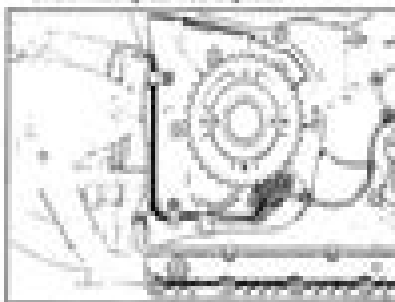
4. Place clamps (1) in position on intake boots.



5. Slide and rotate engine into frame and position engine in center of frame. Adjust height of engine as needed to align rear mounts and down pins.
6. Raise engine and start intake boots on intake ports (2).

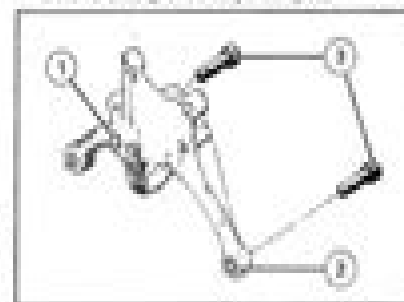


7. Slide engine back onto down pins and adjust engine height as needed to align the pins and fully seat the intake boots on intake ports.
8. Be sure all wiring and hoses are properly routed before installing rear mounting bolts.



9. Loosely install all accessories near engine mounting bolts in frame (3 left side) and spider bracket (lower left and right).

10. Carefully and evenly draw engine back onto down pins using the left side main frame bolts (1 & 2) and the tower bolts (3) on the suspension plate.



11. Tighten bolts (2) evenly until engine is drawn flat against frame and suspension plate bracket. Do not torque fully at this time.

CAUTION

Be sure engine is aligned at the proper height and angle with the down pins. DO NOT force engine alignment using the mounting bolts, or the suspension bracket and down pins may be damaged! Adjust engine height and angle continuously as required while drawing up the bolts.

12. Loosely install all bolts in the sequence shown on Engine Mounting, page 5.2 - removing and replacing the shock to access the right side bolts as in removal process (refer to Chapter 13 for rear suspension feature torque).

13. Install starter motor (if crankcase was disconnected) the starter motor should be torqued to the crankcase during engine assembly.

14. Long bolt is installed in bottom hole (for 130) and shorter bolt (for 110) in top hole.

TORQUE

Torque from 10 to 15 ft-lbs then to 25 ft-lbs

15. Install forked supports Assembly View - Footings, Order (Hops, Hammer, Jackpot, High-Roll), page 5.5.

16. Be sure inlet boots are seated properly to cylinder head intake ports. Torque clamps to spec.

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