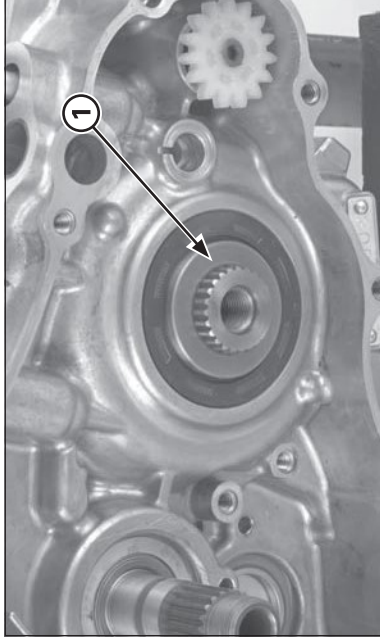


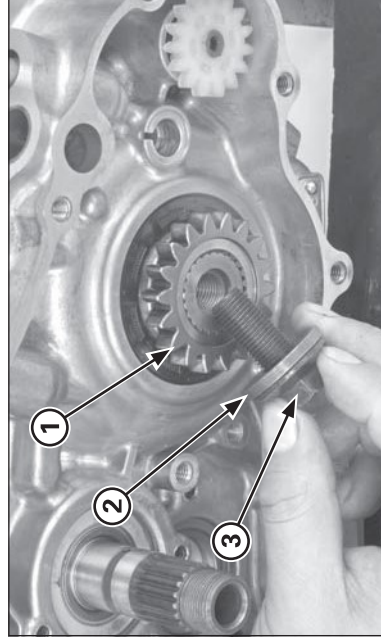
(1) CRANKCASE BOLTS  
(2) NEW SEALING WASHER/OIL DRAIN BOLT

Install the crankcase bolts.  
Tighten the crankcase bolts in a crisscross pattern in 2 – 3 steps.  
Install the transmission oil drain bolt with a new sealing washer, and tighten it to the specified torque.

**Torque: 22 N•m (2.2 kgf•m, 16 lbf•ft)**

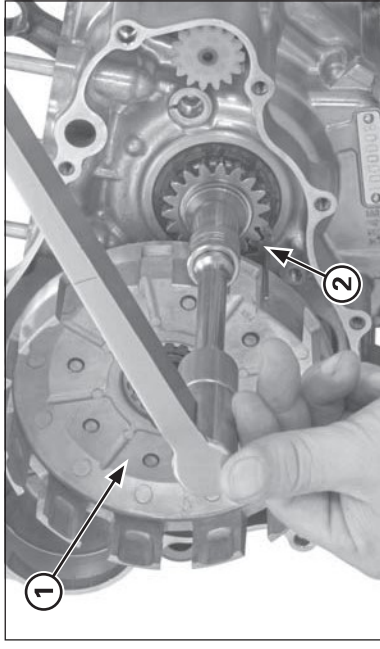


(1) DRIVE GEAR COLLAR



(1) PRIMARY DRIVE GEAR  
(2) WASHER  
(3) SPECIAL BOLT

Install the primary drive gear collar onto the crankshaft.  
Install the primary drive gear with its groove side facing out.  
Apply oil to the primary drive gear special bolt threads and seating surface.  
Install the washer and special bolt.



(1) CLUTCH OUTER  
(2) GEAR HOLDER

Temporarily install the clutch outer guide, needle bearing and clutch outer onto the mainshaft and attach the gear holder between the primary drive and driven gears.

**Tool:**  
**Gear holder**                    **07724-0010100**

Tighten the primary drive gear bolt to the specified torque.

**Torque: 108 N•m (11.0 kgf•m, 80 lbf•ft)**