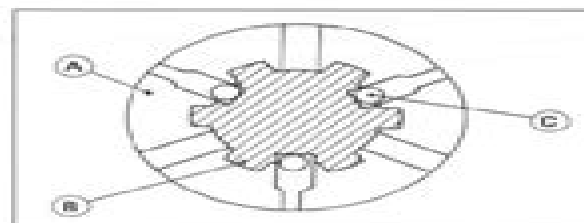


- Fit the steel balls into the 5th gear holes as shown.
View A – A' (see the output shaft illustration)
- [A] Gear (5th)
- [B] Shaft
- [C] Steel Balls

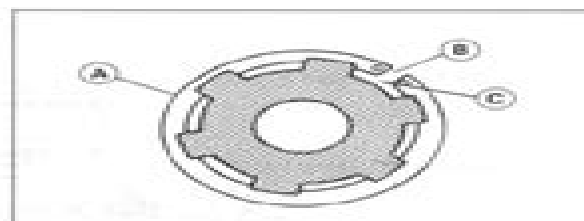
CAUTION

Do not apply grease to the steel balls to hold them in place. This will cause the positive neutral finder mechanism to malfunction.

- Check the ball-locking effect that the 5th gear does not come out of the output shaft when moving it up and down by hand.

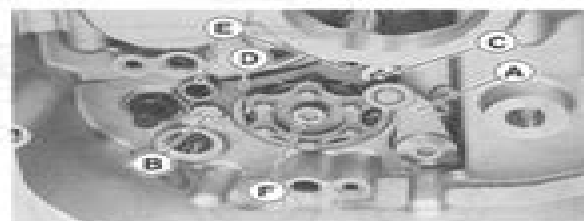


- Replace any circlip that were removed with new ones.
- Install the circlips [A] so that the opening is aligned with a spline groove [B].
- Check that each gear spins or slides freely on the transmission shafts without binding after assembly.



Shift Drum and Fork Removal

- Remove:
 - Lower Crankcase Half (see Crankcase Splitting)
 - External Shift Mechanism (see External Shift Mechanism Removal)
 - Gear Positioning Lever [A]
 - Bolt [B] and Screw [C]
 - Shift Drum Bearing Holder [D]
- Pull out the shift rods [E], and take off the shift forks.
- Pull out the shift drum [F].



Shift Drum and Fork Installation

- Install the shift rods [A], noting the groove position. The rods are identical.
- Position the one with shortest ears [B] on the drive shaft and place the pin in the center groove in the shift drum [C].
- The two forks [D] on the output shaft are identical.
- Install the forks as shown.
- Apply a non-permanent locking agent to the threads of the shift drum bearing holder bolt and screws, and tighten them.



Torque – Shift Drum Bearing Holder Bolt: 12 N·m (1.2 kg-m, 104 in-lb)
Shift Drum Bearing Holder Screw: 5.4 N·m (0.55 kg-m, 48 in-lb)

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