


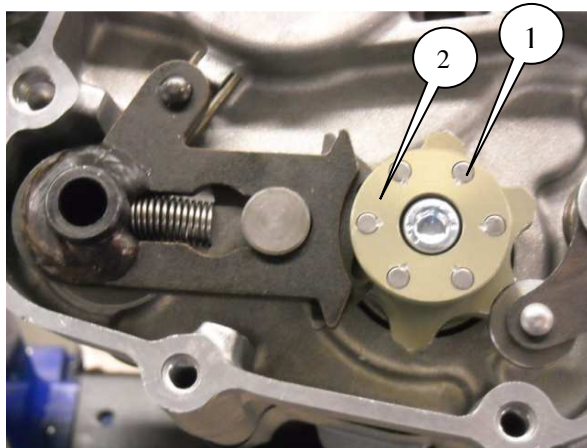
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|  | Information technique Technical information Información técnica | Document n° NT 76-01 |
| Sujet: vérification étoile de sélection 250/300 SE-(R) Subject: verification of 250/300 SE-(R) shift drum locator Asunto: verificación estrella selectora 250/300 SE-(R) | | Date/Fecha 02/06/2014 |

| Motocyclette/Motorcycle/Motocicleta | | | | |
|--|---------------|-------------------|-------------------|-------------------|
| 50 2T | 125 4T | 250/300 4T | 250/300 2T | 450/510 4T |

Due to a manufacturing defect by the supplier, it is possible for the steel needles [1] from the shift drum locator ref 3811 to come out [2] and damage the engine. We ask you to complete the following procedure to replace the star. 1:30 hours of labor is allowed and the necessary parts required are also covered.

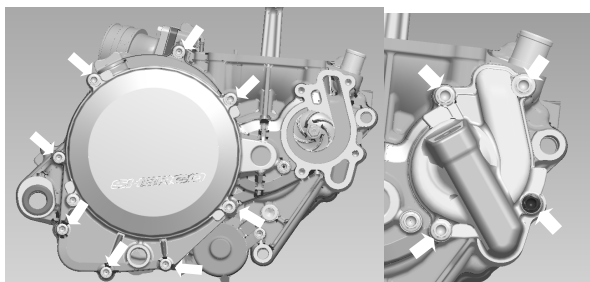
Motorcycles concerned: From serial numbers S8/9-3000359 up to S8/9-3000991 except following numbers :

S634 E3EB000612, S634E3EB000616, S634E3EB000617, S634E3EB000624, S634 E3EB000627, S634E3EB000630, S634E3EB000631, S634E3EB000636, S634E3EB000638, S634E3EB000640, S634E3EB000659, S634E3EB000665, S634E3EB000666, S634E3EB000667, S634E3EB000703, S634E3EB000729, S634E3EB000731, S634E3EB000738, S634E3EB000739, S634E3EB000746, S634E3EB000806, S634E3EB000811, S634E3EB000845, S634E3EB000846, S634E3EB000848, S634E3EB000849, S634E3EB000851, S634E3EB000852, S634E3EB000853, S624E3EB000836, S624E3EB000837, S624E3EB000839, S634E3EB000972 up to S634E3EB000981



Process to change the shift drum locator 3811, engine in the frame:

- Dismount the exhaust pipe.
- Servicing the cooling system (see owner's manual)
- Drain the engine oil (see the manual for details)
- Dismount the rear brake pedal.
- Remove the clutch inner cover. To dismount the crankcase on the frame, only unscrew the screw [3] and don't remove it. Remove all the other M6 screws.
- Dismount the clutch inner cover.



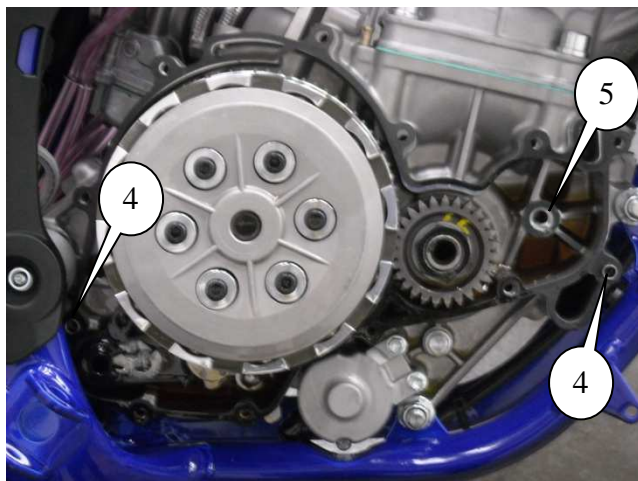
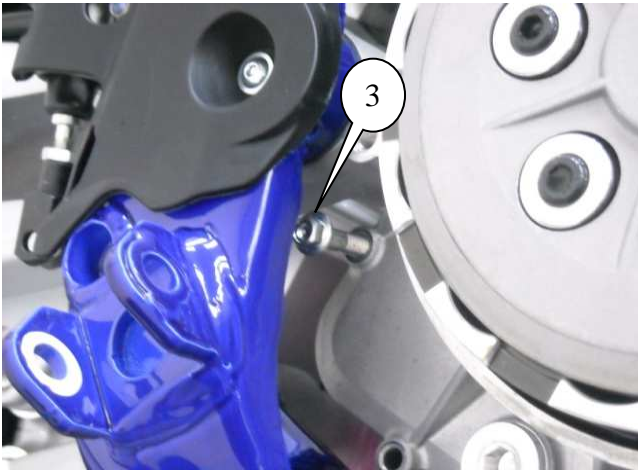


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Be careful with the two dowels [4] and water pump washer [5]

- Remove the pressure clutch plate.
- Remove the clutch hub nut.
- Remove the clutch but washer.
- Remove the clutch hub assembly + discs.
- Remove the shift drum locating screw
- Press locking lever and sliding plate away from the shift drum locating and take off the shift drum locator
- Release the locking lever





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Control the shift drum locating

- Place a CHC M6x35 screw in the shift drum locating and retain in a vise



- Using a pair of cutting pliers, pry the needles and make sure that they do not come out.



- If the needles are loose and come out, degrease them with a degreaser (Minerva brake cleaner and degreaser)
- Use compressed air and blow the assembly clean and dry

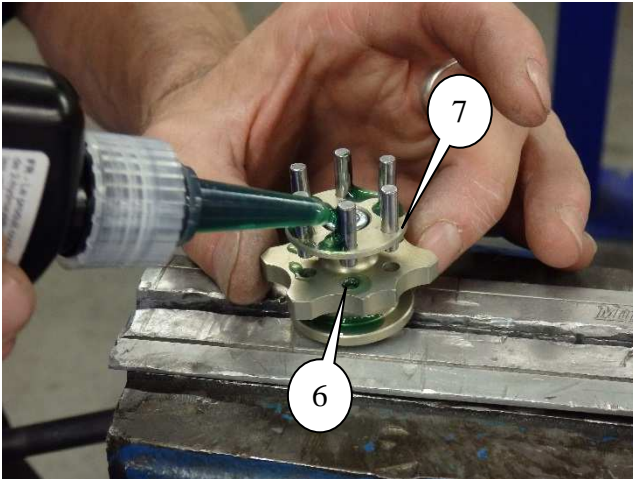


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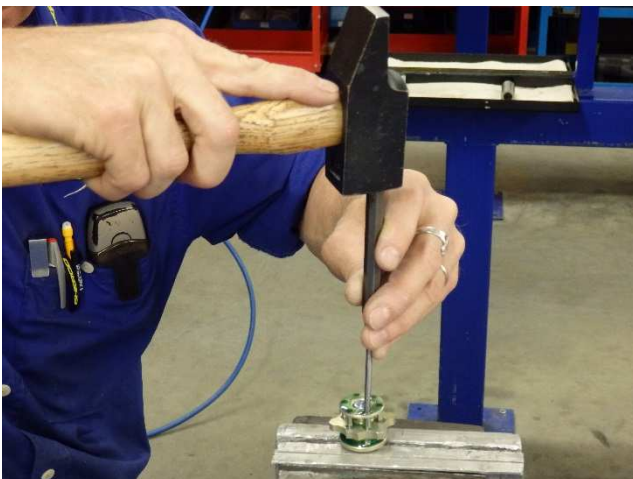
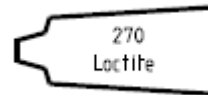
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- Apply strong thread locker to the bottom (6) of the base and to the needles (7).



- Insert the needles with a punch. Verify that they do not protrude above the aluminum part
- Clean off any excess threadlocker
- Wait for the product to take effect (minimum 2 hours)
- Check the star to make sure that the needles remain in place.

If in doubt, replace the star under warranty.



If everything is ok, refit the assembly in reverse order of disassembly, taking care to install a new clutch cover gasket (ref 3831), a new copper washer for the coolant circuit drain plug (ref 2390) and a clutch/ brake washer (ref 4931) .



Be careful with the shift drum locating indexation dowel.