



- Blow out lubrication bore 6 with compressed air and check that it is clear.

- Insert the new cold bearings in the bearing seats of the heated section of the engine case; if necessary, use a suitable mandrel to push them all the way in and make them flush.

**Info**

When pressing in, ensure that the section of the engine case lies flat in order to prevent damage.

Only press the bearings in using the outer bearing race; otherwise, the bearings will be damaged when they are pressed in.

- After the section of the engine case has cooled, check that the bearings are firmly seated.

**Info**

If the bearings are not firmly seated after cooling, it is likely that they will rotate in the engine case when warm. In this case, the engine case must be replaced.

- Press in radial shaft seal ring 1 of the crankshaft with the open side facing inward so that it is flush.
- Press in radial shaft seal ring 2 of the shift shaft so it is flush with the open side facing inward.
- Press in radial shaft seal ring 3 of the countershaft so it is flush with the open side facing in.
- Mount lock ring 5.
- Press in radial shaft seal ring 4 of the balancer shaft so it is flush with the open side facing in.

18.4.3 Removing the crankshaft bearing inner race



- Fixate the crankshaft in the vice with special tool 1.

Guideline

Use soft jaws.

Separator plate (54829009000) (CP p. 320)

- Warm up special tool 2.

Guideline

180 °C (356 °F)

Puller (58429037043) (CP p. 321)

- Push the warmed up special tool 2 onto the crankshaft bearing inner race, press firmly together, and pull jointly from the crankshaft.

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Table of Contents Ktm 250 Xcw Engine Manual

1. Understanding the eBook Ktm 250 Xcw Engine Manual
 - The Rise of Digital Reading Ktm 250 Xcw Engine Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying Ktm 250 Xcw Engine Manual
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Ktm 250 Xcw Engine Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from Ktm 250 Xcw Engine Manual
 - Personalized Recommendations
 - Ktm 250 Xcw Engine Manual User Reviews and Ratings
 - Ktm 250 Xcw Engine Manual and Bestseller Lists
5. Accessing Ktm 250 Xcw Engine Manual Free and Paid eBooks
 - Ktm 250 Xcw Engine Manual Public Domain eBooks
 - Ktm 250 Xcw Engine Manual eBook Subscription Services
 - Ktm 250 Xcw Engine Manual Budget-Friendly Options

6. Navigating Ktm 250 Xcw Engine Manual eBook Formats
 - ePub, PDF, MOBI, and More
 - Ktm 250 Xcw Engine Manual Compatibility with Devices
 - Ktm 250 Xcw Engine Manual Enhanced eBook Features
7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Ktm 250 Xcw Engine Manual
 - Highlighting and Note-Taking Ktm 250 Xcw Engine Manual
 - Interactive Elements Ktm 250 Xcw Engine Manual
8. Staying Engaged with Ktm 250 Xcw Engine Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Ktm 250 Xcw Engine Manual
9. Balancing eBooks and Physical Books Ktm 250 Xcw Engine Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Ktm 250 Xcw Engine Manual
10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
11. Cultivating a Reading Routine Ktm 250 Xcw Engine Manual
 - Setting Reading Goals Ktm 250 Xcw Engine Manual
 - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of Ktm 250 Xcw Engine Manual
 - Fact-Checking eBook Content of Ktm 250 Xcw Engine Manual
 - Distinguishing Credible Sources
13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
14. Embracing eBook Trends
 - Integration of Multimedia Elements

- Interactive and Gamified eBooks

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