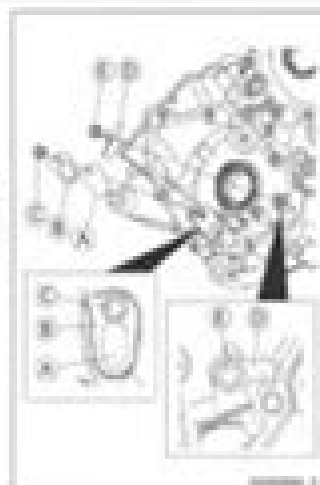


Crankcase

- Install:
Rear Valve (A)
Rear Valve Holder Bolt (B)
Rear Valve Holder Bolt (C)
Oil Separator Plate (D)
Oil Separator Plate Bolt (E)
- Tighten:
Torque - Rear Valve Holder Bolt: 10 Nm (7.5 kg-m, 55 in-lb)
Oil Separator Plate Bolt: 10 Nm (7.5 kg-m, 55 in-lb)



Right Crankcase

- Press the new crankshaft bearing (A) and new drive shaft bearing (B) until they bottom out.
- Press the new output shaft bearing (C) until it bottoms out so that the outer side (D) faces outside of the engine.

Special Tool - Bearing Driver Set: 97001-1120



- Press the new shaft drum ball bearing (A) until it bottoms out.
- Press the new shaft shaft needle bearing (B) so that the bearing surface is flush with the crankcase surface.

Special Tool - Bearing Driver Set: 97001-1120



- Install the right crankcase bearing retainers.
(The right crankcase bearing retainers are larger than left ones.)
- Apply a non-permanent locking agent to the crankcase bearing retainer screws (A).
- Tighten:

Torque - Crankcase Bearing Retainer Screws: 10 Nm (7.5 kg-m, 55 in-lb)

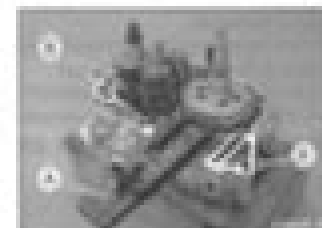


Crankcase

- Install:
Plunger (A)
Spring (B)
- Press the collar (C) so that the collar surface is flush with the crankcase surface.
Special Tool - Bearing Driver Set: 97001-1120
- Install the nut (D)
Outside of the Engine (E)
- Tighten:
Torque - Nut: 1.0 Nm (0.10 kg-m, 10 in-lb)
- Install the piston of nut (F)
- Tighten:
Torque - Piston Oil Nut: 3.0 Nm (0.31 kg-m, 27 in-lb)



- Install:
Crankshaft (see Crankshaft Installation 112)
Transmission Shafts (see Transmission Shaft Installation 113)
Shift Drum (see Transmission Shaft Installation 113)
Shift Fork (see Transmission Shaft Installation 113)
Shift Rod (see Transmission Shaft Installation 113)
Oil Screen (Pump) (see Oil Screen Cleaning and Mounting 112)
- Position the connecting rod in SOC.
- Install the crankshaft pg (A) between the crankshaft flywheels.
Special Tool - Crankshaft pg: 97001-1170
- Check to see that the dowel pins (B) are in place in the mating surfaces of the crankcase halves.



Kx250 2015 Service Manual

Yijin Wang



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