

1. Verify that two ring dowels are in place on side door flange. Hang a new gasket on the ring dowels.
2. Squirt a liberal amount of clean transmission lubricant into the main drive gear to prelube needle bearings. Install the assembled side door into the transmission case. See Figure 7-22.

## NOTE

Be sure the transmission lubricant filler plug/dipstick is completely removed before attempting to install the side door. Contact with the filler plug/dipstick will prevent side door removal and may cause parts damage.

3. Start the two longer socket head screws (with captive washers) to fasten transmission exhaust bracket and bottom of side door to the transmission case. Start the six remaining screws. Alternately tighten eight screws to 13-18 ft-lbs (17.6-24.4 Nm) in the pattern shown in Figure 7-23.
4. Rotate shifter pawl forward and then lower free end to engage shifter cam. Remove and discard the cover gasket.
5. Obtain a **new** top cover gasket and align the holes with those in the transmission case. Align the holes in the top cover with those in the gasket. Install the six socket head screws and tighten to 8-13 ft-lbs (9.5-14.9 Nm).
6. Install preformed vent hose to top cover fitting, if removed.
7. Insert push rod into mainshaft bore. Install oil slinger.
8. Install the clutch release cover. See Section 7.4 CLUTCH RELEASE COVER, ASSEMBLY/INSTALLATION.

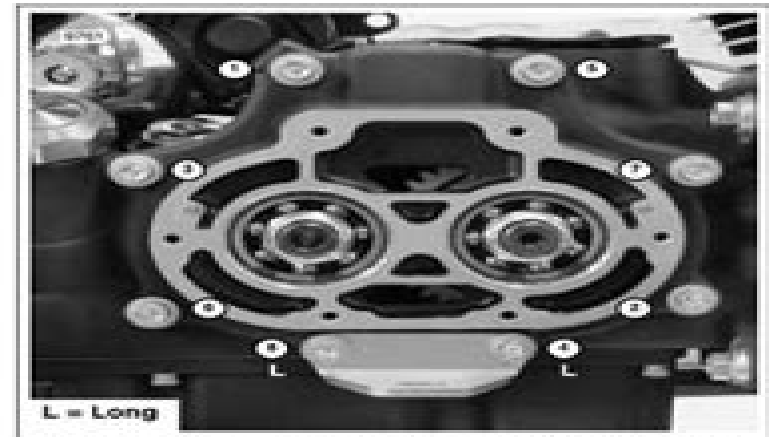


Figure 7-23. Transmission Side Door Screw Size and Torque Sequence

9. Install the bearing inner race on the transmission mainshaft. See Section 6.5 PRIMARY CHAINCASE, MAINSHAFT BEARING INNER RACE, INSTALLATION.
10. Install the primary chaincase. Install the clutch assembly, primary chain, and compensating sprocket components. Install the primary chaincase cover. See Section 6.5 PRIMARY CHAINCASE, INSTALLATION.
11. Install the exhaust system. See Section 2.38 EXHAUST SYSTEM, INSTALLATION.

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**Robert Maddox**



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## **Table of Contents Flhtcu 2007 Service Manual**

1. Understanding the eBook Flhtcu 2007 Service Manual
  - The Rise of Digital Reading Flhtcu 2007 Service Manual
  - Advantages of eBooks Over Traditional Books
2. Identifying Flhtcu 2007 Service 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 Flhtcu 2007 Service Manual
  - User-Friendly Interface
4. Exploring eBook Recommendations from Flhtcu 2007 Service Manual
  - Personalized Recommendations

- Flhtcu 2007 Service Manual User Reviews and Ratings
- Flhtcu 2007 Service Manual and Bestseller Lists
- 5. Accessing Flhtcu 2007 Service Manual Free and Paid eBooks
  - Flhtcu 2007 Service Manual Public Domain eBooks
  - Flhtcu 2007 Service Manual eBook Subscription Services
  - Flhtcu 2007 Service Manual Budget-Friendly Options
- 6. Navigating Flhtcu 2007 Service Manual eBook Formats
  - ePub, PDF, MOBI, and More
  - Flhtcu 2007 Service Manual Compatibility with Devices
  - Flhtcu 2007 Service Manual Enhanced eBook Features
- 7. Enhancing Your Reading Experience
  - Adjustable Fonts and Text Sizes of Flhtcu 2007 Service Manual
  - Highlighting and Note-Taking Flhtcu 2007 Service Manual
  - Interactive Elements Flhtcu 2007 Service Manual
- 8. Staying Engaged with Flhtcu 2007 Service Manual
  - Joining Online Reading Communities
  - Participating in Virtual Book Clubs
  - Following Authors and Publishers Flhtcu 2007 Service Manual
- 9. Balancing eBooks and Physical Books Flhtcu 2007 Service Manual
  - Benefits of a Digital Library
  - Creating a Diverse Reading Collection Flhtcu 2007 Service Manual
- 10. Overcoming Reading Challenges
  - Dealing with Digital Eye Strain
  - Minimizing Distractions
  - Managing Screen Time
- 11. Cultivating a Reading Routine Flhtcu 2007 Service Manual
  - Setting Reading Goals Flhtcu 2007 Service Manual
  - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Flhtcu 2007 Service Manual
  - Fact-Checking eBook Content of Flhtcu 2007 Service 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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