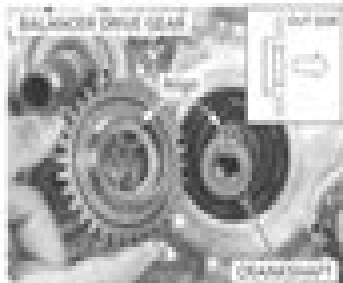


INSTALLATION

Engage the balancer shaft gear portion with oil pump drive gear.



Install the balancer drive gear while aligning its wide cutout in the splines with the punch mark on the crankshaft.



Install the driven gear into the balancer shaft while aligning its wide cutout in the splines with the punch mark on the balancer shaft.



Align the punch mark of the driven gear with the punch mark of the drive gear.



Install the water pump drive gear while aligning its wide cutout in the splines with the punch mark on the balancer shaft.

Insert the gear holder between the balancer drive and driven gears.

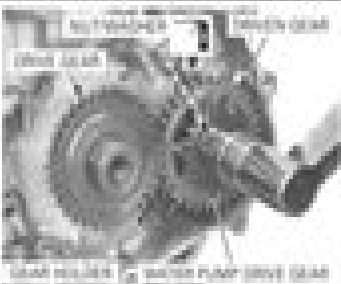
**TOOL:**  
Gear holder, 9023 07734-000100 or 07734-001A100 (U.S.A. only)

Apply oil to the balancer shaft nut seating surface, insert and tighten the balancer shaft nut to the specified torque.

**TORQUE:** 44 Nm (4.1 kg-m, 32 ft-lb)

Remove the gear holder.

Install the primary drive gear aligning its wide cutout in the driver gear with the punch mark on the crankshaft.



Temporarily install the clutch outer gear, needle bearing and clutch nut into the manifold.

Insert the gear holder between the primary drive and driven gears.

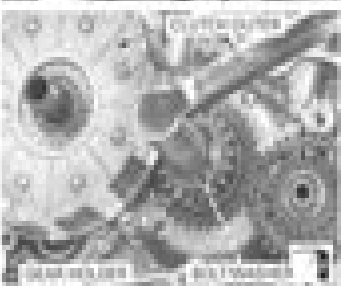
**TOOL:**  
Gear holder, 9023 07734-000100 or 07734-001A100 (U.S.A. only)

Apply oil to the primary drive gear ball threads, insert the washer and bolt, and tighten the bolt to the specified torque.

**TORQUE:** 100 Nm (7.5 kg-m, 74 ft-lb)

Remove the gear holder.

Install the flywheel (page 16-10).  
Install the clutch (page 17-10).  
Install the right crankcase cover (page 17-10).



CRANKCASE SEPARATION

Refer to service information (page 12-5) for removal of necessary parts before separating the crankcase.

Loosen the drive pinion lock while rotating the spreader with the special tool as shown.

**TOOL:**  
Universal holder 07706-000000

(v) Remove the bolt, washer and drive pinion.



# Honda Manual Crf250r

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## **Table of Contents Honda Manual Crf250r**

1. Understanding the eBook Honda Manual Crf250r
  - The Rise of Digital Reading Honda Manual Crf250r
  - Advantages of eBooks Over Traditional Books
2. Identifying Honda Manual Crf250r
  - 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 Honda Manual Crf250r
  - User-Friendly Interface
4. Exploring eBook Recommendations from Honda Manual Crf250r
  - Personalized Recommendations
  - Honda Manual Crf250r User Reviews and Ratings
  - Honda Manual Crf250r and Bestseller Lists
5. Accessing Honda Manual Crf250r Free and Paid eBooks
  - Honda Manual Crf250r Public Domain eBooks
  - Honda Manual Crf250r eBook Subscription Services
  - Honda Manual Crf250r Budget-Friendly Options

6. Navigating Honda Manual Crf250r eBook Formats
  - ePub, PDF, MOBI, and More
  - Honda Manual Crf250r Compatibility with Devices
  - Honda Manual Crf250r Enhanced eBook Features
7. Enhancing Your Reading Experience
  - Adjustable Fonts and Text Sizes of Honda Manual Crf250r
  - Highlighting and Note-Taking Honda Manual Crf250r
  - Interactive Elements Honda Manual Crf250r
8. Staying Engaged with Honda Manual Crf250r
  - Joining Online Reading Communities
  - Participating in Virtual Book Clubs
  - Following Authors and Publishers Honda Manual Crf250r
9. Balancing eBooks and Physical Books Honda Manual Crf250r
  - Benefits of a Digital Library
  - Creating a Diverse Reading Collection Honda Manual Crf250r
10. Overcoming Reading Challenges
  - Dealing with Digital Eye Strain
  - Minimizing Distractions
  - Managing Screen Time
11. Cultivating a Reading Routine Honda Manual Crf250r
  - Setting Reading Goals Honda Manual Crf250r
  - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of Honda Manual Crf250r
  - Fact-Checking eBook Content of Honda Manual Crf250r
  - 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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