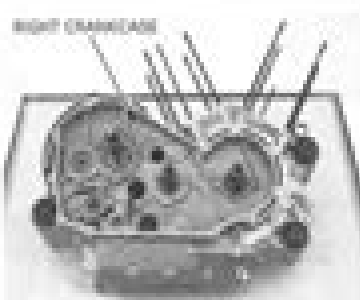


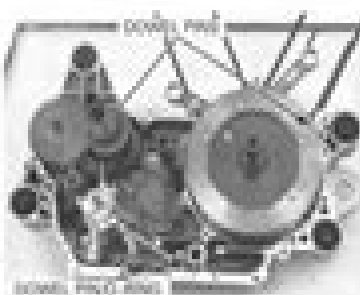
Place the crankcase assembly with the left side down.

Carefully separate the right crankcase from the left crankcase.



Remove the dowel pins and O-ring.

Refer to following pages for service of the each part. For the crankcase assembly, see page 11-12.



PRIMARY SHAFT

REMOVAL/INSTALLATION

Separate the crankcase (page 11-11).

Remove the primary shaft from the left crankcase.

Installation is in the reverse order of removal.

INSPECTION

Inspect the primary shaft for wear or damage. Replace the primary shaft if necessary.

Turn the inner race of each bearing with your finger. The bearings should turn smoothly and quietly. Also check that the bearing outer race fits tightly in the crankcase.

Remove and discard the bearings if the races do not turn smoothly, quietly, or if they fit loosely in the crankcase (page 11-12).



CRANKSHAFT/CONNECTING ROD

CRANKSHAFT REMOVAL

Separate the crankcase (page 11-11).

During removal and connecting rod service, be certain not to damage the main journal or pin bearing and bearing inserts.

Remove the crankshaft from the left crankcase.



CONNECTING ROD REMOVAL

Before removing the connecting rods, check the top and side clearance.

Measure the clearance by inserting the feeler gauge between the crankshaft and connecting rod big end.

SERVICE LIMIT: 0.28 mm (0.011 in)

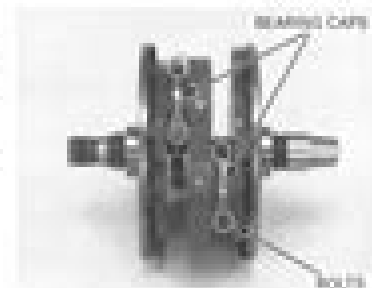


NOTICE

Do not interchange the bearing inserts. They must be installed in their original locations or the correct bearing oil clearance may not be obtained, resulting in engine damage.

For the way to the cap bolts of the bearing cap to turn to remove.

Remove the connecting bearing cap bolts and the bearing caps.



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Jianjun Gao



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1. Understanding the eBook Motorcycle Repair Manual Vtx1800f
 - The Rise of Digital Reading Motorcycle Repair Manual Vtx1800f
 - Advantages of eBooks Over Traditional Books
2. Identifying Motorcycle Repair Manual Vtx1800f
 - 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 Motorcycle Repair Manual Vtx1800f
 - User-Friendly Interface
4. Exploring eBook Recommendations from Motorcycle Repair Manual Vtx1800f
 - Personalized Recommendations
 - Motorcycle Repair Manual Vtx1800f User Reviews and Ratings
 - Motorcycle Repair Manual Vtx1800f and Bestseller Lists
5. Accessing Motorcycle Repair Manual Vtx1800f Free and Paid eBooks

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- Motorcycle Repair Manual Vtx1800f Budget-Friendly Options
- 6. Navigating Motorcycle Repair Manual Vtx1800f eBook Formats
 - ePub, PDF, MOBI, and More
 - Motorcycle Repair Manual Vtx1800f Compatibility with Devices
 - Motorcycle Repair Manual Vtx1800f Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Motorcycle Repair Manual Vtx1800f
 - Highlighting and Note-Taking Motorcycle Repair Manual Vtx1800f
 - Interactive Elements Motorcycle Repair Manual Vtx1800f
- 8. Staying Engaged with Motorcycle Repair Manual Vtx1800f
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Motorcycle Repair Manual Vtx1800f
- 9. Balancing eBooks and Physical Books Motorcycle Repair Manual Vtx1800f
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Motorcycle Repair Manual Vtx1800f
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Motorcycle Repair Manual Vtx1800f
 - Setting Reading Goals Motorcycle Repair Manual Vtx1800f
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Motorcycle Repair Manual Vtx1800f
 - Fact-Checking eBook Content of Motorcycle Repair Manual Vtx1800f
 - 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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