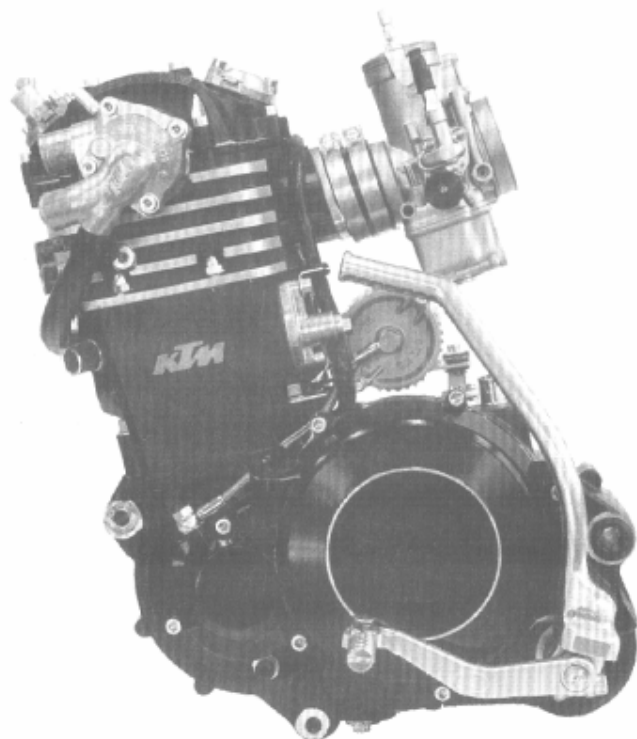




# ERSATZTEILKATALOG SPARE PARTS MANUAL

# '95



## MOTOR/ENGINE 350/400/620

# LC4

**SX, SUPER COMPETITION**

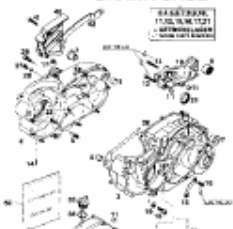
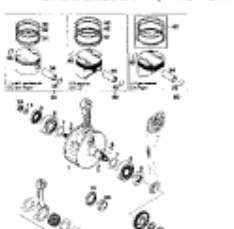
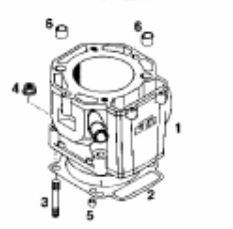
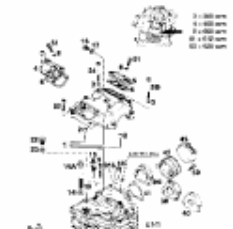

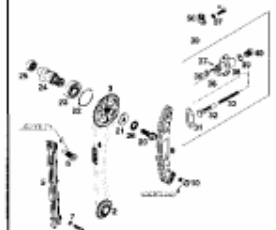


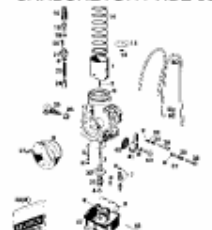
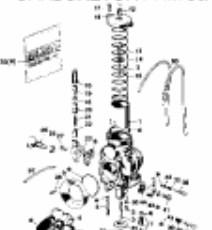
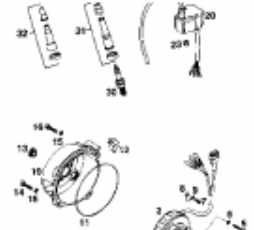
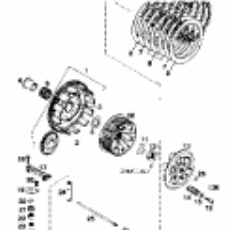
**TECHNISCHE DATEN/TECHNICAL DATA**

ART.NR.3.203.83  
12.94



## INHALTSVERZEICHNIS

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# INHALTSVERZEICHNIS

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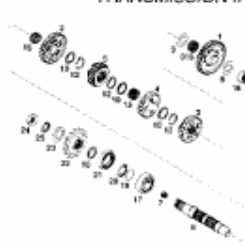
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## GETRIEBE I TRANSMISSION I



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## SCHALTUNG SHIFTING MECHANISM



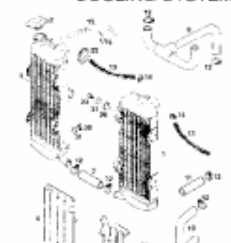
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## SPEZIALWERKZEUGE SPECIAL TOOLS



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## TECHNISCHE DATEN MOTOR TECHNICAL DATA ENGINE



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KONSTRUKTIONS- UND AUSFÜHRUNGSÄNDERUNGEN VORBEHALTEN

SPECIFICATIONS/MODIFICATIONS ARE SUBJECT TO CHANGE WITHOUT NOTICE

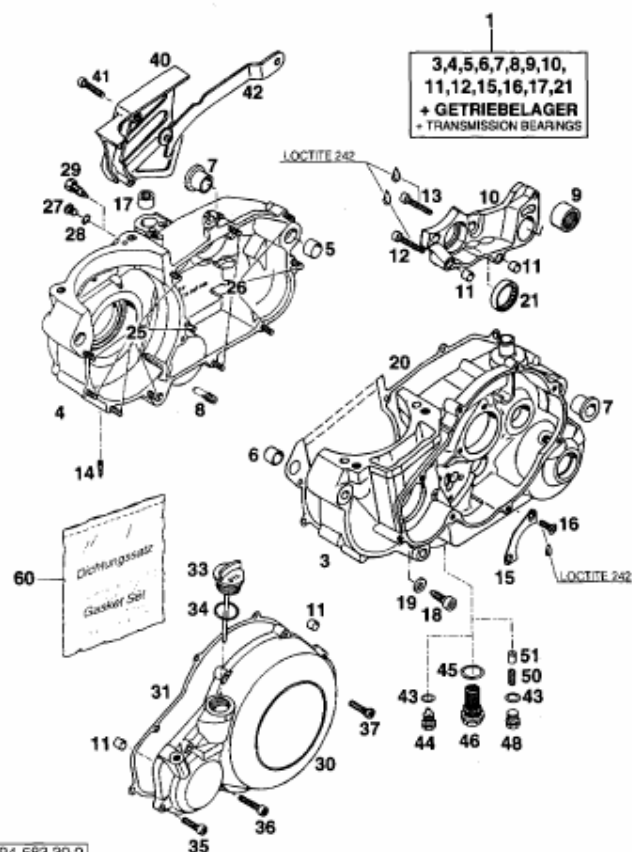


95-583.30.0

## MOTORGEHÄUSE

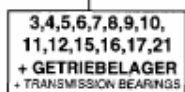
## ENGINE CASE

350/400/620 '95



| BILD / FIG | TEILNR. / PARTNR | BEZEICHNUNG                                       | DESCRIPTION            | STK. / QTY |
|------------|------------------|---------------------------------------------------|------------------------|------------|
| 1          | 580.30.000.944   | MOTORGEHÄUSE KPL. M. GETR. LAG '94<br>350/400/620 | ENGINE CASE            | 1          |
| 5          | 501.30.027.000   | PASSHÜLSE 19 X 15,5 X 12                          | DOWEL                  | 1          |
| 6          | 510.30.026.100   | PASSHÜLSE 17 X 14 X 12                            | DOWEL                  | 1          |
| 7          | 501.30.010.000   | GEHÄUSEBÜCHSE                                     | CRANK CASE BUSH        | 2          |
| 8*         | 583.38.027.044   | KUGELVENTIL KPL.                                  | '94 VALVE ICPL.        | 1          |
| 9          | 580.33.097.000   | NADEL LAGER HK 2216 KSE                           | NEEDLE BEARING         | 1          |
| 10         | 580.30.011.600   | SCHALTUNGSTRÄGER                                  | '94 SHIFTING M. SUPP.  | 1          |
| 11         | 490.30.090.000   | PASSHÜLSE 7 X 9,8 X 10                            | DOWEL                  | 4          |
| 12         | 0912 060353      | ISK-SCHRAUBE DIN912-M6X35                         | A H SCREW              | 1          |
| 13         | 0912 060403      | ISK-SCHRAUBE DIN912-M6X40                         | A H SCREW              | 1          |
| 14         | 491.30.450.050   | DORNPROFIL LW 3                                   | TUBE                   | 1          |
| 15         | 565.30.017.000   | HALTEBLECH                                        | RETAINING PLATE        | 1          |
| 16         | 0991 060163      | ISK-SEKSSCHRAUBE DIN991-M6X16                     | COUNTERSUNK SCREW      | 2          |
| 17         | 503.32.095.000   | NADELHÜLSE HK 1212                                | NEEDLE CAGE            | 2          |
| 18         | 580.30.080.000   | FIXIERSCHRAUBE M8                                 | LOCATING BOLT          | 1          |
| 19         | 580.30.081.000   | CU-DICHRING 8 X 14 X 3                            | SEAL RING              | 1          |
| 20         | 580.30.039.000   | GEHÄUSEDICHTUNG                                   | ENGINE CASE GASKET     | 1          |
| 21         | 501.34.026.100   | NADELHÜLSE 30 X 37 X 7,5                          | NEEDLE CAGE            | 1          |
| 25         | 0912 060553      | ISK-SCHRAUBE DIN912-M6X55                         | A H SCREW              | 6          |
| 26         | 0912 060303      | ISK-SCHRAUBE DIN912-M6X30                         | A H SCREW              | 5          |
| 27         | 490.30.029.000   | ÖLABLASSSCHRAUBE ISK M10X10                       | OIL DRAIN PLUG         | X          |
| 28         | 580.38.032.010   | DICHRING 10 X 14 X 1 CU                           | SEAL RING              | X          |
| 29*        | 580.11.081.000   | KONTAKTSCHRAUBE M10                               | '95 CONTACT SCREW      | 1          |
| 30         | 580.30.001.200   | KUPPLUNGSDECKEL KPL. SCHWARZ '93                  | CLUTCH COVER BLACK     | 1          |
| 31         | 580.30.025.000   | KUPPLUNGSDECKELDICHTUNG                           | CLUTCH COV. GASKET     | 1          |
| 33         | 580.30.020.044   | ÖLMESSSTAB KPL. KURZ                              | PLUG                   | 1          |
| 34         | 0770 160030      | O-RING 16 X 3 NBR 70                              | O-RING                 | 1          |
| 35         | 0912 060253      | ISK-SCHRAUBE DIN912-M6X25                         | A H SCREW              | 5          |
| 36         | 0912 060303      | ISK-SCHRAUBE DIN912-M6X30                         | A H SCREW              | 1          |
| 37         | 0984 060252      | ISK-SCHRAUBE DIN984-M6X25                         | A H SCREW              | 2          |
| 40         | 580.30.050.600   | KETTENABDECKUNG SCHWARZ                           | '91 SPROCKET COVER     | 1          |
| 41         | 0912 060303      | ISK-SCHRAUBE DIN912-M6X30                         | A H SCREW              | 2          |
| 42         | 580.30.047.515   | KETTENDAMPFUNGSSCHEIBCHEN LCA                     | '90 CHAIN DAMPER SHEET | 1          |
| 43         | 580.38.022.000   | DICHRING 12 X 18 X 1,5 CU                         | SEAL RING              | 2          |
| 44*        | 580.30.021.000   | ÖLABLASSSCHRAUBE MIT MAGNET M12                   | OIL DRAIN PLUG         | 1          |
| 45         | 580.38.017.000   | DICHRING 22 X 27 X 1 CU                           | SEAL RING              | 1          |

94-583.30.0



| BILD / FIG | TEILNR. / PARTNR | BEZEICHNUNG                    | DESCRIPTION    | STK. / QTY |
|------------|------------------|--------------------------------|----------------|------------|
| 46         | 580.38.019.000   | ÖLVERSCHLUSSCHRAUBE M22X3,5    | OIL DRAIN PLUG | 1          |
| 48*        | 0910 120153      | VERSCHLUSSCHRAUBE M12X1,5 SW13 | PLUG           | 1          |
| 50         | 580.38.023.300   | DRUCKFEDER L=25MM D=1MM        | SPRING         | 1          |
| 51         | 580.38.028.000   | VENTILKOLBEN D=10MM            | VALVE PISTON   | 1          |
| 60         | 575.30.100.000   | DICHTUNGSSATZ 350/500 LC4      | GASKET SET     | 1          |
| 60         | 580.30.100.000   | DICHTUNGSSATZ 400/600 LC4      | GASKET SET     | 1          |
| 60         | 580.30.900.000   | DICHTUNGSSATZ 612/620 LC4      | GASKET SET     | 1          |

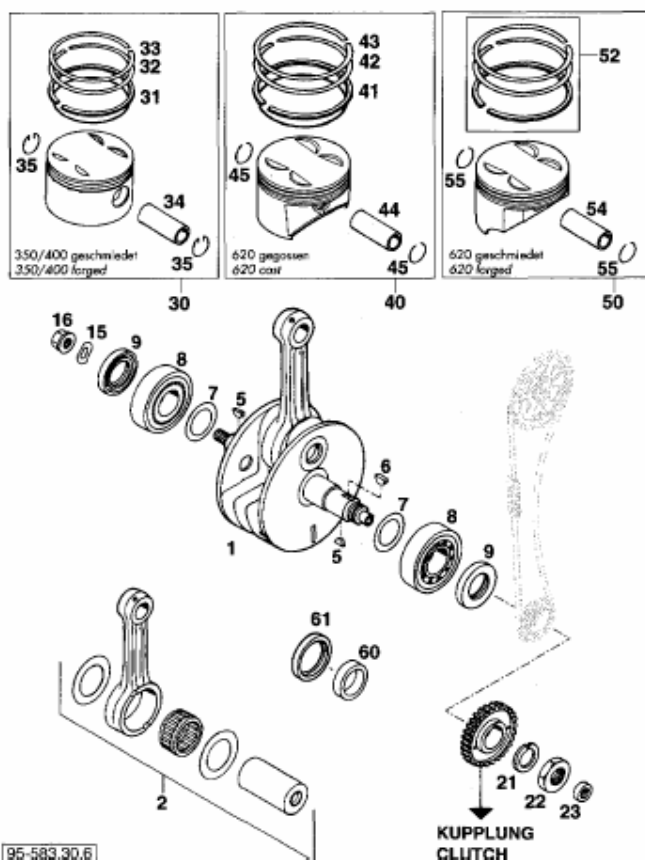


95-583.30.6

KURBELWELLE, KOLBEN

CRANKSHAFT, PISTON

350/400/620 '95



| BILD/FIG | TEILNR./PARTNR | BEZEICHNUNG                                         | DESCRIPTION         | STK./QTY |
|----------|----------------|-----------------------------------------------------|---------------------|----------|
| 1        | 575.30.018.000 | KURBELWELLE KPL. HUB 56,2MM '93<br>350/400 LC4      | CRANKSHAFT CPL.     | 1        |
| 1        | 583.30.018.000 | KURBELWELLE KPL. HUB 76MM '94<br>620 LC4            | CRANKSHAFT CPL.     | 1        |
| 2        | 580.30.015.044 | PLEUEL-REP. SATZ LC4<br>350/400/500/612 CC, L-140MM | CON. ROD REPAIR KIT | 1        |
| 2        | 583.30.015.044 | PLEUEL-REP. SATZ LC4<br>620 CC, L-141,5MM           | CON. ROD REPAIR KIT | 1        |
| 5        | 0888 030050    | SCHNEIDENFEDER DIN6888-3 X 5                        | WOODRUFF KEY        | 2        |
| 6        | 946 005        | SCHNEIDENFEDER GEHÄRTET 5 X 6,5                     | WOODRUFF KEY        | 1        |
| 7        | 560.30.081.000 | PASSSCHEIBE 30 X 42 X 0,1                           | SHIM                | X        |
| 7        | 560.30.081.100 | PASSSCHEIBE 30 X 42 X 0,15                          | SHIM                | X        |
| 7        | 560.30.081.200 | PASSSCHEIBE 30 X 42 X 0,3                           | SHIM                | X        |
| 8        | 580.30.082.000 | ZYLINDERROLLENLAGER NJ 306                          | OLLER BEARING       | 2        |
| 9        | 0760 305272    | WELLENDICHTRING 30X52X7BTL                          | RADIAL SEAL RING    | 2        |
| 15       | 0137 120000    | FEDERSCHNUR DIN137-B12                              | SPRING HASHER       | 1        |
| 16       | 510.30.028.100 | BUNDMUTTER M12X1 LINKS SN-17                        | MAGNETO NUT         | 1        |
| 21       | 580.30.019.000 | SPERRKANTRING VSK 20                                | LOCKING RING        | 1        |
| 22       | 0936 200155    | SK-MUTTER DIN936-M20X1,5                            | H H NUT             | 1        |
| 23       | 0760 122270    | WELLENDICHTRING 12 X 22 X 7 B                       | SEAL RING           | 1        |
| 30       | 576.30.007.000 | KOLBEN 95 MM KPL. 400 LC4<br>(EK2074)               | PISTON CPL.         | 1        |
| 31       | 580.30.631.000 | ÖLABSTREIFR. 95MM 400/600 LC4                       | OIL STRAINER RING   | 1        |
| 32       | 580.30.732.000 | MINUTENRING 95MM 400/600 LC4                        | RECTANGULAR RING    | 1        |
| 33       | 580.30.632.000 | RECHTECKRING 95MM 400/600 LC4                       | SQUARE RING         | 1        |
| 34       | 580.30.033.000 | KOLBENBOLZEN 22 X 13 X 54,2                         | PISTON PIN          | 1        |
| 35       | 580.30.074.100 | DRAHTSPRENGRING A 22 X 1,5                          | CIRCLIP             | 2        |
| 40       | 583.30.007.100 | KOLBEN 101 MM KPL. GEGOSSEN<br>(EK1895/B)           | PISTON CPL. CAST    | 1        |
| 41       | 583.30.831.000 | ÖLABSTREIFRING 101MM 620 LC4                        | OIL STRAINER RING   | 1        |
| 42       | 583.30.932.000 | MINUTENRING 101MM 620 LC4                           | RECTANGULAR RING    | 1        |
| 43       | 583.30.832.000 | RECHTECKRING 101MM 620 LC4                          | SQUARE RING         | 1        |
| 44       | 583.30.833.000 | KOLBENBOLZEN 22 X 13 X 60                           | PISTON PIN          | 1        |
| 45       | 580.30.074.100 | DRAHTSPRENGRING C 22 X 1,5                          | CIRCLIP             | 2        |
| 50*      | 583.30.007.200 | KOLBEN 101 MM KPL. GESCHMIEDET<br>(ARIAS)           | PISTON CPL. FORGED  | 1        |
| 52*      | 583.30.031.244 | KOLBENRINGSATZ KPL. 101MM ARIAS                     | PISTON RINGSET CPL. | 1        |

\* = NEUTEIL / NEW PART

X = NACH BEDARF / AS REQUIRED

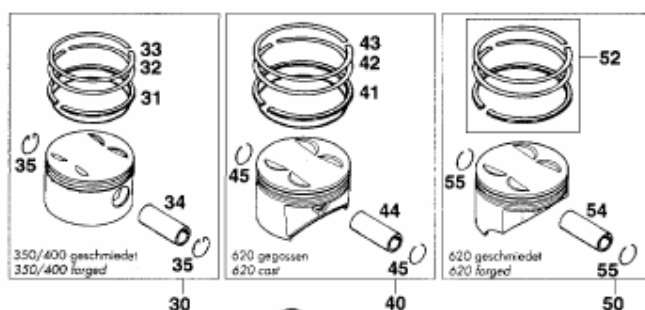


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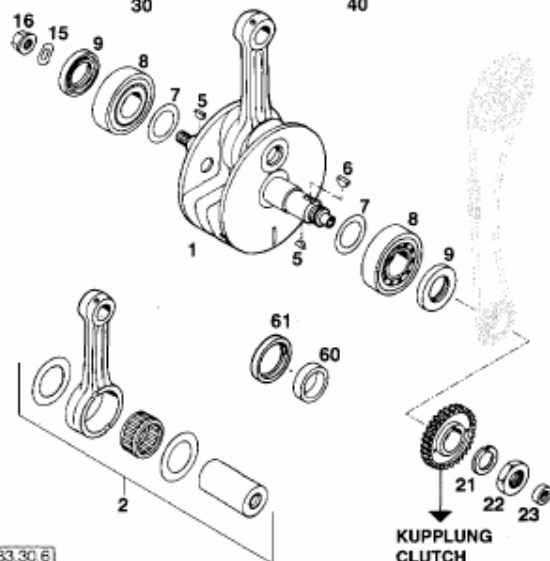
KURBELWELLE, KOLBEN

CRANKSHAFT, PISTON

350/400/620 '95



| BILD/FIG | TEILNR./PARTNR | BEZEICHNUNG                    | DESCRIPTION      | STK./QTY |
|----------|----------------|--------------------------------|------------------|----------|
| 54       | 580.30.833.000 | KOLBENBOLZEN 22 X 13,5 X 63,5  | PISTON PIN       | 1        |
| 55       | 580.30.874.000 | DRAHTSPRENGRING C 22 X 1,2     | CIRCLIP          | 2        |
| 60       | 580.30.018.090 | KURBELW. REP. RING 30X38X9,5   | REP. SEAL RING   | X        |
|          |                | FÜR REP.SATZ KURBELW.SIMMERING |                  |          |
|          |                | FÜR REP.KIT CRANKS.SEAL RING   |                  |          |
| 61       | 0760 385273    | WELLENDICHTRING 38X52X7 BTSL   | RADIAL SEAL RING | X        |
|          |                | FÜR REP.SATZ KURBELW.SIMMERING |                  |          |
|          |                | FÜR REP.KIT CRANKS.SEAL RING   |                  |          |



95-583.30.6

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\* = NEUTEIL / NEW PART

X = NACH BEDARF / AS REQUIRED

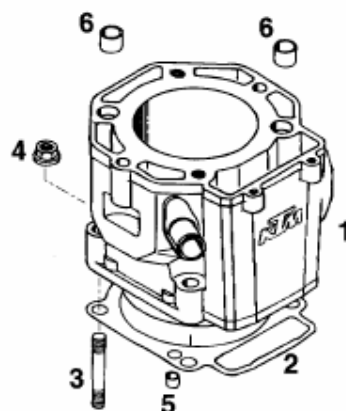


95-583.30.2

ZYLINDER

CYLINDER

350/400/620 '95



| BILD/FIG | TEILNR./PARTNR | BEZEICHNUNG                                           | DESCRIPTION      | STK./QTY |
|----------|----------------|-------------------------------------------------------|------------------|----------|
| 1        | 575.30.005.000 | ZYLINDER 89 MM 350 LC4'93                             | CYLINDER         | 1        |
| 1        | 576.30.005.000 | ZYLINDER 95 MM 400 LC4'93                             | CYLINDER         | 1        |
| 1        | 583.30.005.000 | ZYLINDER 101MM 620 LC4'94                             | CYLINDER         | 1        |
| 2        | 580.30.030.000 | ZYLINDERFUSSDICHTUNG                                  | CYL. BASE GASKET | 1        |
| 3*       | 0835 100456    | STIFTSCHR. DIN934-M10X45-10.9<br>VERZINKT/ZINC COATED | STUD             | 4        |
| 4        | 0331 100003    | BUNDMUTTER M10 SW-15                                  | NUT              | 4        |
| 5        | 490.30.090.000 | PASSHÜLSE 7 X 9,8 X 10                                | DOWEL            | 2        |
| 6        | 510.30.026.100 | PASSHÜLSE 17 X 14 X 12                                | DOWEL            | 2        |

94-583.30.2

7

\* = NEUTEIL / NEW PART X = NACH BEDARF / AS REQUIRED



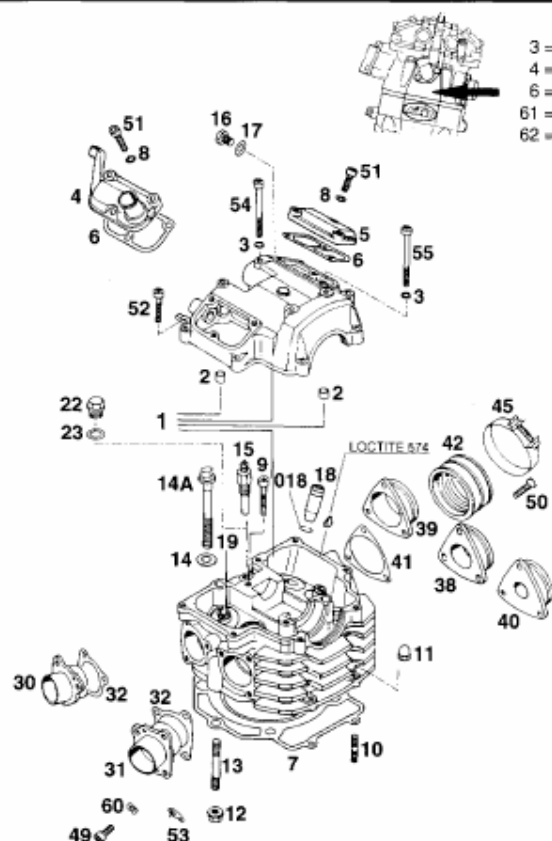


95-583.36.1

## ZYLINDERKOPF

## CYLINDERHEAD

350/400/620 '95



3 = 350 ccm  
4 = 400 ccm  
6 = 600 ccm  
61 = 612 ccm  
62 = 620 ccm

| BILD / FIG | TEILNR. / PARTNR | BEZEICHNUNG                               | DESCRIPTION        | STK. / QTY |
|------------|------------------|-------------------------------------------|--------------------|------------|
| 1          | 575.36.020.000   | ZYLINDERKOPF KPL. 350 LC4'93              | CYLINDER HEAD CPL. | 1          |
| 1          | 576.36.020.000   | ZYLINDERKOPF KPL. 400 LC4'93              | CYLINDER HEAD CPL. | 1          |
| 1          | 583.36.020.000   | ZYLINDERKOPF KPL. 620 LC4'94              | CYLINDER HEAD CPL. | 1          |
| 3*         | 580.36.065.100   | CU-DICHTRING 6 X 10 X 2                   | SEAL RING          | 4          |
| 2          | 490.30.090.000   | PASSMÜSE 7 X 9,8 X 10                     | DOWEL              | 2          |
| 4          | 580.36.152.500   | VENTILDECKEL VORNE MOD '90                | VALVE COVER FRONT  | 1          |
| 5          | 580.36.052.000   | VENTILDECKEL                              | VALVE COVER        | 1          |
| 6          | 580.36.053.000   | VENTILDECKELDICHTUNG                      | VALVE COVER GASKET | 2          |
| 7          | 575.30.036.000   | ZYLINDERKOPFDICHTUNG 90,3 MM 350/500 LC4  | CYL.HEAD GASKET    | 1          |
| 7          | 580.30.136.200   | ZYLINDERKOPFDICHTUNG 95,3 MM 400/600 LC4  | CYL.HEAD GASKET    | 1          |
| 7          | 583.30.036.000   | ZYLINDERKOPFDICHTUNG 101,3 MM 612/620 LC4 | CYL.HEAD GASKET    | 1          |
| 8          | 580.36.065.000   | DICHTRING 6 X 10 X 1 CU                   | SEAL RING          | 6          |
| 9          | 0912 060353      | ISK-SCHRAUBE DIN912-M6X35                 | A H SCREW          | 1          |
| 10         | 0551 060253      | GEWINDESTIFT DIN951-M6X25 350/400 LC4     | STUD               | 2          |
| 10         | 0551 060303      | GEWINDESTIFT DIN951-M6X30 600/612/620 LC4 | STUD               | 2          |
| 11         | 0587 060003      | SK-HEXMUTTER DIN1587-M6                   | HEX NUT            | 2          |
| 12         | 490.30.028.000   | BUNDMUTTER M6 - 8MM HOCH                  | FLANGE NUT         | 2          |
| 13         | 543.30.043.100   | STIFTSCHRAUBE M6X35 350/400 LC4           | STUD               | 2          |
| 13         | 543.30.043.000   | STIFTSCHRAUBE M6X40 600/612/620 LC4       | STUD               | 2          |
| 14         | 580.36.098.000   | CU-DICHTRING 10 X 20 X 1                  | SEAL RING          | 4          |
| 14A        | 580.36.099.100   | BUNDSCHRAUBE M10X80 SK13MM                | FLANGE SCREW       | 4          |
| 15         | 420.11.252.000   | TEMPERATURSCHALTER VDO                    | TEMP. INDICATOR    | 1          |
| 16         | 0933 080123      | SK-SCHRAUBE DIN933-M8X12                  | H H SCREW          | 1          |
| 17         | 580.38.032.000   | DICHTRING 8,2 X 12 X 0,8 CU               | SEAL RING          | 1          |
| 018        | 0993 012000      | SPRENGRING DIN993A-RM12                   | CIRCLIP            | 4          |
| 18         | 580.36.026.600   | VENTILFÜHRUNG EINLASS '91                 | VALVE GUIDE INTAKE | 2          |
| 19         | 580.36.126.600   | VENTILFÜHRUNG AUSLASS '91                 | VALVE GUIDE EXHAUS | 2          |
| 22         | 546.30.021.000   | SK-VERSCHLUSSSCHR. M10X1 SW13             | PLUG               | X          |
| 23         | 580.38.032.010   | DICHTRING 10 X 14 X 1 CU                  | SEAL RING          | X          |
| 30         | 580.36.040.000   | AUSPUFFFLANSCH RECHTS                     | EXHAUST FLANGE R/S | 1          |

95-583.36.1

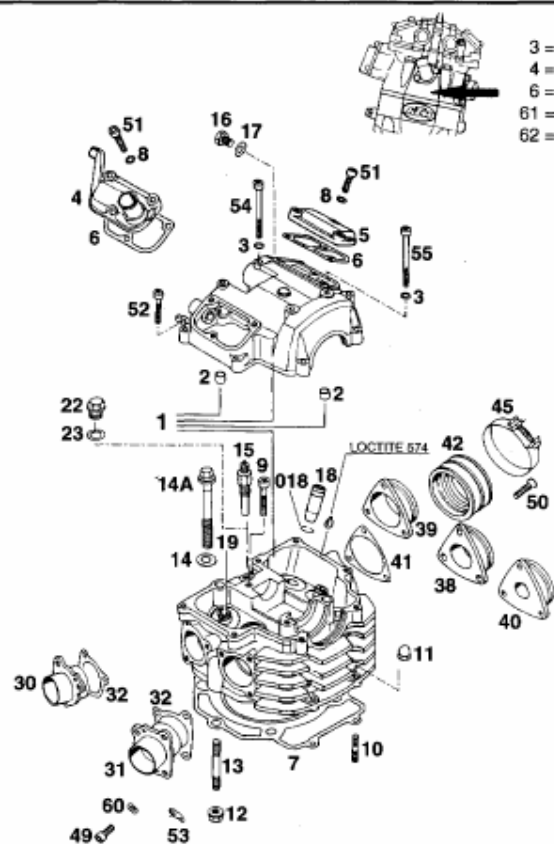


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## ZYLINDERKOPF

## CYLINDERHEAD

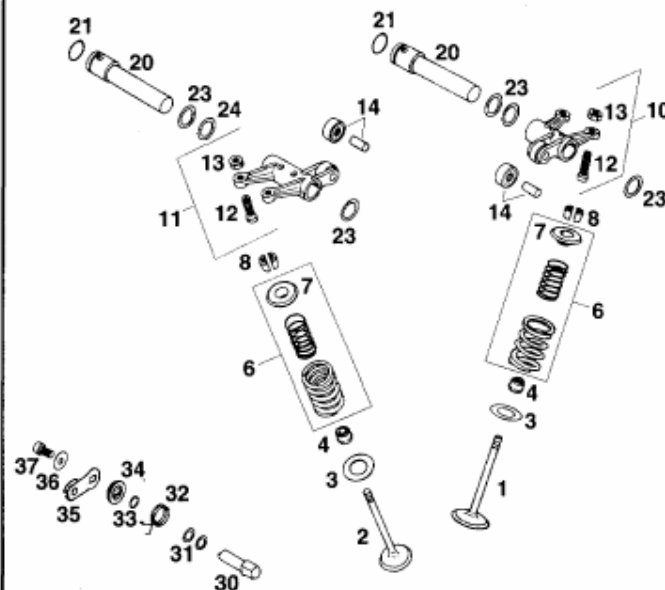
350/400/620 '95



3 = 350 ccm  
4 = 400 ccm  
6 = 600 ccm  
61 = 612 ccm  
62 = 620 ccm

| BILD / FIG | TEILNR. / PARTNR | BEZEICHNUNG                     | DESCRIPTION        | STK. / QTY |
|------------|------------------|---------------------------------|--------------------|------------|
| 31         | 580.36.140.000   | AUSPUFFFLANSCH LINKS            | EXHAUST FLANGE L/S | 1          |
| 32         | 580.36.041.000   | AUSPUFFFLANSCHDICHTUNG          | EXH. FLANGE GASKET | 2          |
| 38         | 581.36.142.026   | ANSAUGSTUTZEN D=26MM            | INTAKE FLANGE      | 1          |
| 38         | 581.36.142.028   | ANSAUGSTUTZEN D=28MM            | INTAKE FLANGE      | 1          |
| 39         | 575.36.042.000   | ANSAUGSTUTZEN D=37MM            | INTAKE FLANGE      | 1          |
| 39         | 581.36.042.000   | ANSAUGSTUTZEN D=38MM            | INTAKE FLANGE      | 1          |
| 39         | 581.36.042.040   | ANSAUGSTUTZEN D=40MM            | INTAKE FLANGE      | 1          |
| 40         | 581.36.142.023   | ANSAUGSTUTZEN D=23,5MM          | INTAKE FLANGE      | 1          |
| 41         | 581.36.043.000   | ANSAUGSTUTZENDICHTUNG           | GASKET             | 1          |
| 42         | 575.36.044.000   | GUMMI-MUFFE D=37MM 350 LC4      | RUBBER             | 1          |
| 42         | 581.36.044.100   | GUMMI-MUFFE D=38MM 400-620 LC4  | RUBBER             | 1          |
| 45         | 565.30.061.000   | SCHELLE 60/12                   | CLAMP              | 2          |
| 49         | 0912 060163      | ISK-SCHRAUBE DIN912-M6X16       | A H SCREW          | 8          |
| 50         | 0991 060163      | ISK-SENK-SCHRAUBE DIN7991-M6X16 | COUNTERSUNK SCREW  | 3          |
| 51         | 0912 060203      | ISK-SCHRAUBE DIN912-M6X20       | A H SCREW          | 6          |
| 52         | 0912 060253      | ISK-SCHRAUBE DIN912-M6X25       | A H SCREW          | 6          |
| 52         | 0912 060353      | ISK-SCHRAUBE DIN912-M6X35       | A H SCREW          | 1          |
| 53         | 510.05.074.000   | FEDERLASCHE                     | RETAINING PLATE    | 2          |
| 54*        | 0912 060601      | ISK-SCHRAUBE DIN912-M6X60 12.9  | A H SCREW          | 2          |
| 55*        | 0912 060651      | ISK-SCHRAUBE DIN912 M6X65 12.9  | A H SCREW          | 2          |
| 60         | 0137 060000      | FEDERSCHEIBE DIN137-B6          | SPRING WASHER      | 6          |

94-583.36.1



| BILD / FIG | TEILNR. / PARTNR | BEZEICHNUNG                    | DESCRIPTION        | STK. / QTY |
|------------|------------------|--------------------------------|--------------------|------------|
| 1          | 580.36.030.000   | EINLASSVENTIL 36 MM            | INTAKE VALVE       | 2          |
| 2          | 580.36.031.000   | AUSLASSVENTIL 30 MM            | EXHAUST VALVE      | 2          |
| 3          | 580.36.027.100   | ANLAUFSCHIBE 12,2X29,5X0,5     | THRUST WASHER      | 4          |
| 4          | 580.36.028.000   | VENTILSCHAFTDICHTUNG           | SEAL FOR VALVE     | 4          |
| 6*         | 580.36.029.044   | VENTILFEDERSATZ PROGRESSIV '95 | VALVE SPRING KIT   | 1          |
| 7*         | 580.36.032.700   | VENTILFEDERTELLER ALU '95      | SPRING RETAINER    | 4          |
| 8          | 580.36.033.000   | VENTILKEGELSTÜCK MK7           | KEY HALF           | 8          |
| 10         | 580.36.060.644   | KIPPEBEL EINLASS KPL.          | ROCKER ARM INTAKE  | 1          |
| 11         | 580.36.061.644   | KIPPEBEL AUSLASS KPL.          | ROCKER ARM EXHAUST | 1          |
| 12         | 580.36.062.600   | EINSTELLSCHRAUBE M7X0,75 '91   | ADJUSTMENT SCREW   | 4          |
| 13         | 0934 070756      | SK-MUTTER DIN934-M7X0,75-10.9  | HEX NUT            | 4          |
| 14         | 580.36.061.090   | KIPPEBELROLLE KPL.             | ROCKER ARM ROLLER  | 2          |
| 20         | 580.36.056.100   | KIPPEBELWELLE L=96MM           | ROCKER ARM SHAFT   | 2          |
| 21         | 580.36.095.000   | O-RING 15,08 X 2,62            | O-RING             | 2          |
| 23         | 0968 162210      | PASSSCHIBE 16 X 22 X 1         | SHIM WASHER        | X          |
| 24         | 0968 162205      | PASSSCHIBE 16 X 22 X 0,5       | SHIM WASHER        | X          |
| 30         | 580.36.050.100   | DEKO-WELLE                     | DECOMPR. SHAFT     | 1          |
| 31         | 543.34.015.000   | ST-SCHIBE 10 X 14 X 0,5        | FLAT WASHER        | X          |
| 31         | 543.34.015.100   | ST-SCHIBE 10 X 14 X 0,3        | WASHER             | X          |
| 31         | 543.34.015.200   | ST-SCHIBE 10 X 14 X 0,15       | WASHER             | X          |
| 32         | 580.36.059.200   | DEKO-HEBELFEDER 1,8 MM         | SPRING             | 1          |
| 33         | 0770 100221      | O-RING 10 X 2,2 SILICON        | O-RING             | 1          |
| 34         | 580.36.048.000   | ABDECKSCHIBE                   | COVER              | 1          |
| 35         | 580.36.049.500   | DEKO-WELLENHEBEL               | DECOMPR. LEVER     | 1          |
| 36         | 0021 060003      | SCHIBE DIN9021-AG,4            | FLAT WASHER        | 1          |
| 37         | 0912 060103      | ISK-SCHRAUBE DIN912-M6X10      | A H SCREW          | 1          |

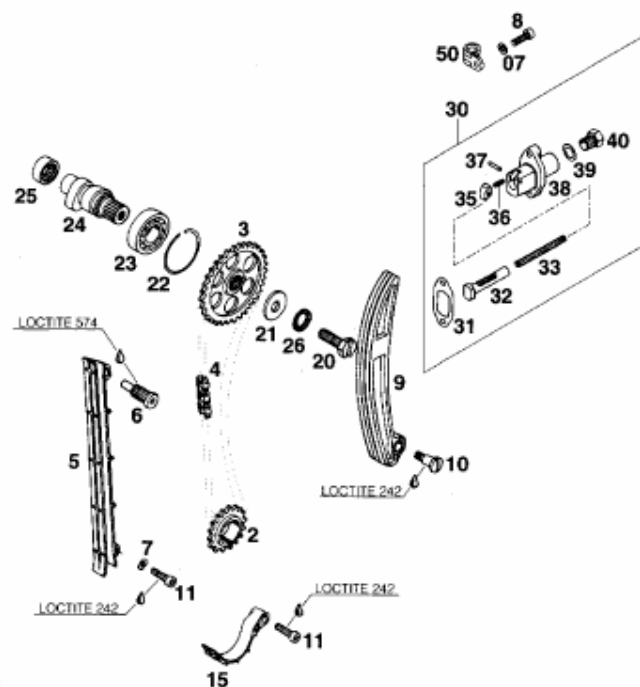


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## STEUERTRIEB

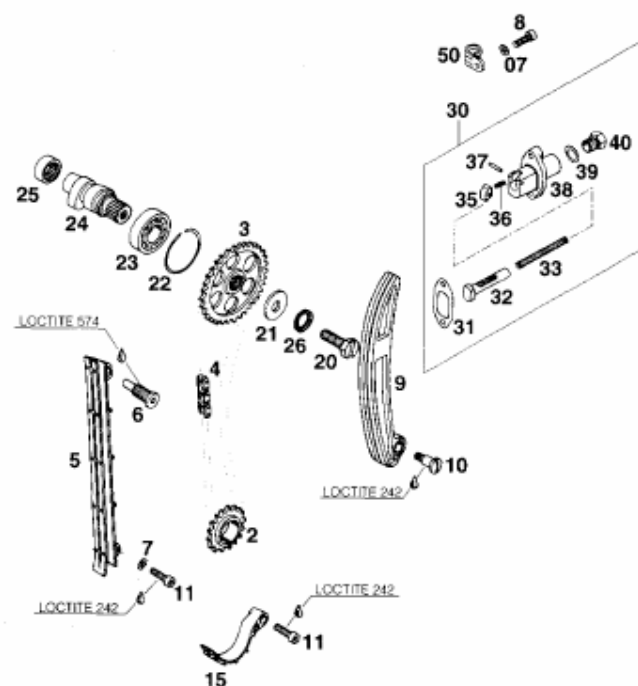
## TIMING DRIVE

350/400/620 '95



| BILD / FIG | TEILNR. / PARTNR | BEZEICHNUNG                                           | DESCRIPTION         | STK. / QTY |
|------------|------------------|-------------------------------------------------------|---------------------|------------|
| 2          | 580.36.014.000   | STEUERRITZEL 17-Z                                     | TIMING SPROCKET     | 1          |
| 3          | 580.36.011.000   | NOCKENWELLENRAD 34-Z<br>350-400 LC4                   | TIMING SPROCKET     | 1          |
| 3          | 583.36.011.001   | NOCKENWELLENRAD 34-Z "01" '94<br>620 LC4              | TIMING SPROCKET     | 1          |
| 4          | 575.36.013.000   | STEUERKETTE C107C / 96 ROLLEN<br>350/400 LC4          | TIMING CHAIN        | 1          |
| 4          | 580.36.013.000   | STEUERKETTE C107C / 100 ROLLEN<br>500/600/612/620 LC4 | TIMING CHAIN        | 1          |
| 5          | 575.36.001.000   | STEUERKETTENFÜHRUNG<br>350/400 LC4                    | TIMING CHAIN GUIDE  | 1          |
| 5          | 580.36.001.000   | STEUERKETTENFÜHRUNG<br>600/612/620 LC4                | TIMING CHAIN GUIDE  | 1          |
| 6          | 580.36.009.000   | KETTENFÜHRUNGSSCHRAUBE                                | CHAIN GUIDE BOLT    | 1          |
| 07         | 580.36.065.000   | DICHTRING 6 X 10 X 1 CU                               | SEAL RING           | 2          |
| 7          | 0137 060090      | FEDERSCHEIBE DIN137-B6                                | SPRING WASHER       | 1          |
| 8          | 0912 060203      | ISK-SCHRAUBE DIN912-M5X20                             | A H SCREW           | 2          |
| 9          | 575.36.002.000   | STEUERKETTENSANNER<br>350/400 LC4                     | CHAIN TENSIONER     | 1          |
| 9          | 580.36.002.000   | STEUERKETTENSANNER<br>600/612/620 LC4                 | CHAIN TENSIONER     | 1          |
| 10         | 0923 080120      | FLACHKOPFSCHRAUBE M 8 X 12                            | FLAT HEAD SCREW     | 1          |
| 11         | 0912 060208      | ISK-SCHRAUBE DIN912-M5X20 SS                          | A H SCREW S LOCK.   | 2          |
| 15         | 583.36.018.000   | AUSFALLSICHERUNG LC4'94                               | SECURING GUIDE      | 1          |
| 20*        | 583.36.112.000   | MITNEHMERSCHRAUBE M10X25 10,9                         | DRIVING SCREW       | 1          |
| 21         | 580.36.012.000   | SCHIBE 10 X 28 X 3 GEHÄRTET                           | WASHER              | 1          |
| 22         | 580.36.096.000   | SPRENGRING 58 42                                      | CIRCLIP             | 1          |
| 23         | 0625 060040      | RIELENKUGELLAGER 6004 C3 KSE                          | BEARING             | 1          |
| 24         | 575.36.010.000   | NOCKENWELLE 995 350/400                               | CAM SHAFT           | 1          |
| 24         | 580.36.010.000   | NOCKENWELLE 249 600/612/620                           | CAM SHAFT           | 1          |
| 25         | 580.36.097.000   | NADELBUCHSE BK 2012                                   | NEEDLE BEARING      | 1          |
| 26         | 360.03.014.200   | SCHNORR-SICHERUNGSSCHIBE 10MM                         | LOCKING WASHER      | 1          |
| 30         | 580.36.003.144   | AUTOMATIKSPANNER KPL. '88                             | AUTOM. TENSIONER CP | 1          |
| 31         | 580.36.005.100   | SPANNERDICHTUNG 1,5 MM                                | GASKET              | 1          |
| 32         | 580.36.004.100   | DRUCKBOLZEN                                           | PRESSURE BOLT       | 1          |
| 33         | 580.36.005.100   | DRUCKFEDER 0,9 MM                                     | SPRING              | 1          |
| 35         | 580.36.007.100   | KLINKE                                                | LOCKING PIECE       | 1          |

95-583.36.0



| BILD / FIG | TEILNR. / PARTNR | BEZEICHNUNG                   | DESCRIPTION    | STK. / QTY |
|------------|------------------|-------------------------------|----------------|------------|
| 36         | 580.36.007.050   | DRUCKFEDER F. KLINKE          | SPRING         | 1          |
| 37         | 0402 031780      | LAGERNADEL 3 X 17,8 G2        | NEEDLE         | 1          |
| 38         | 580.36.003.100   | SPANNERGEHÄUSE                | TENSIONER CASE | 1          |
| 39         | 580.38.022.000   | DICHTRING 12 X 18 X 1,5 CU    | SEAL RING      | 1          |
| 40         | 580.36.008.100   | VERSCHLUSSCHRAUBE M12X1,5 ALU | PLUG           | 2          |
| 50*        | 542.11.052.000   | SCHNELLE RSGU 24/15           | CLAMP          | 1          |

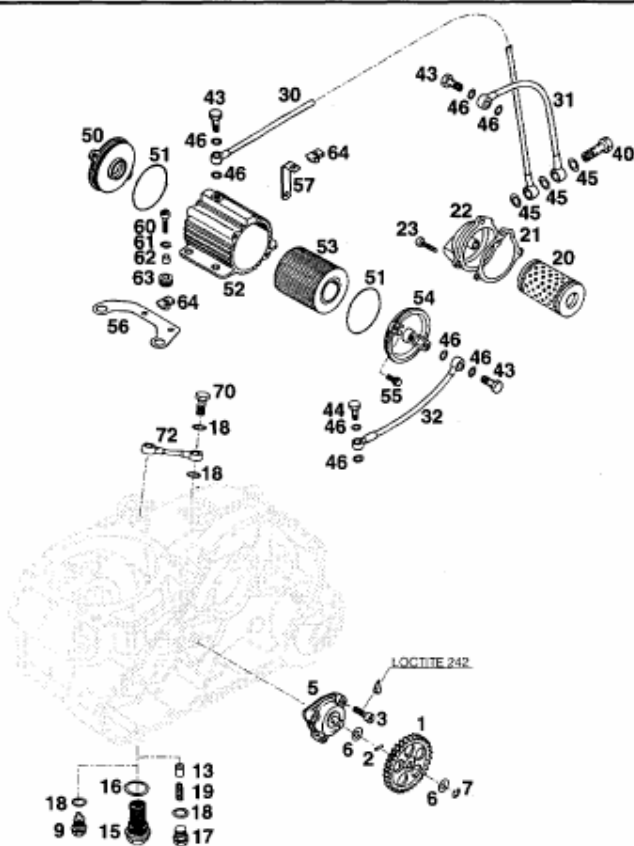


95-583.38.2

## SCHMIERSYSTEM

## LUBRICATING SYSTEM

350/400/620 '95



| BILD / FIG | TEILNR. / PARTNR | BEZEICHNUNG                                  | DESCRIPTION        | STK. / QTY |
|------------|------------------|----------------------------------------------|--------------------|------------|
| 1          | 580.38.001.000   | ÖLPUMPENRAD 31-Z                             | PUMP GEAR          | 1          |
| 2          | 0402 025880      | NADELROLLE NROB 2,5 X 9,8 G2                 | NEEDLE             | 1          |
| 3          | 0912 060203      | ISK-SCHRAUBE DIN912-M5X20                    | A H SCREW          | 3          |
| 5          | 580.38.007.100   | ÖLPUMPE MIKUNI G-73 LC4'92                   | OIL PUMP CPL.      | 1          |
| 6          | 580.38.007.755   | ANLAUFSCHLEIBE 8,1 X 15 X 0,5                | THRUST WASHER      | 2          |
| 7          | 0799 060000      | SICHERUNGSSCHLEIBE DIN6799-R56               | RETAINING CLIP     | 1          |
| 9          | 580.30.021.000   | ÖLABLASSSCHRAUBE MIT MAGNET M12              | OIL DRAIN PLUG     | 1          |
| 13         | 580.38.028.000   | VENTILKOLBEN Ø=10MM                          | VALVE PISTON       | 1          |
| 15         | 580.38.019.000   | ÖLVERSCHLUSSSCHRAUBE M22X1,5                 | OIL DRAIN PLUG     | 1          |
| 16         | 580.38.017.000   | DICHTRING 22 X 27 X 1 CU                     | SEAL RING          | 1          |
| 17         | 0910 120153      | VERSCHLUSSSCHRAUBE M12X1,5 SM13              | PLUG               | 1          |
| 18         | 580.38.022.000   | DICHTRING 12 X 18 X 1,5 CU                   | SEAL RING          | 6          |
| 19         | 580.38.023.300   | DRUCKFEDER L=25MM Ø=1MM                      | SPRING             | 1          |
| 20         | 580.38.005.000   | ÖLFILTER                                     | OIL FILTER ELEMENT | 1          |
| 21         | 580.30.041.000   | FILTERDECKELDICHTUNG                         | GASKET             | 1          |
| 22         | 580.30.008.600   | FILTERDECKEL M10X1 '91                       | FILTERCOVER        | 1          |
| 23         | 0912 060163      | ISK-SCHRAUBE DIN912-M5X16                    | A H SCREW          | 3          |
| 30         | 580.38.234.200   | ÖLLEITUNG FILTER/MIKROFILTER R10/R8 - 300MM  | OIL LINE           | 1          |
| 31         | 580.38.334.600   | ÖLLEITUNG FILTER/GEHÄUSE R10/R8 - 175MM      | OIL LINE           | 1          |
| 32         | 580.38.134.600   | ÖLLEITUNG MICROFILTER/KUPPL.DE R8/R8 - 190MM | OIL LINE           | 1          |
| 40         | 580.38.033.100   | DOPPELHOLLSCHRAUBE M10X1                     | DUAL HOLLOW SCREW  | 1          |
| 43         | 580.38.030.000   | HOLLSCHRAUBE M8X1                            | HOLLOW SCREW       | 3          |
| 44*        | 580.38.130.000   | DÜSENSCHRAUBE M8X1                           | JET SCREW          | 1          |
| 45         | 580.38.032.010   | DICHTRING 10 X 14 X 1 CU                     | SEAL RING          | 3          |
| 46         | 580.38.032.000   | DICHTRING 8,2 X 12 X 0,8 CU                  | SEAL RING          | 8          |
| 50         | 580.38.041.000   | MICROFILTERDECKEL                            | FILTER COVER       | 1          |
| 51         | 0770 056020      | O-RING 56 X 2 (VITON)                        | O-RING             | 2          |
| 52         | 580.38.043.000   | MICROFILTERGEHÄUSE                           | FILTER CASE        | 1          |
| 53         | 580.38.044.000   | MICROFILTERELEMENT                           | FILTER ELEMENT     | 1          |
| 54         | 580.38.042.000   | MICROFILTERDECKEL M8X1                       | FILTER COVER       | 1          |
| 55         | 0010 050163      | TAPTITE SCHRAUBE M5X16                       | TAPTITE SCREW      | 4          |
| 56         | 575.38.090.000   | HALTEBLECH FÜR MICROFILTER '93               | BRACKET            | 1          |
| 57         | 575.38.091.000   | STÜTZBLECH FÜR MICROFILTER '93               | BRACKET            | 1          |
| 60         | 0912 050163      | ISK-SCHRAUBE DIN912-M5X16                    | A H SCREW          | 3          |

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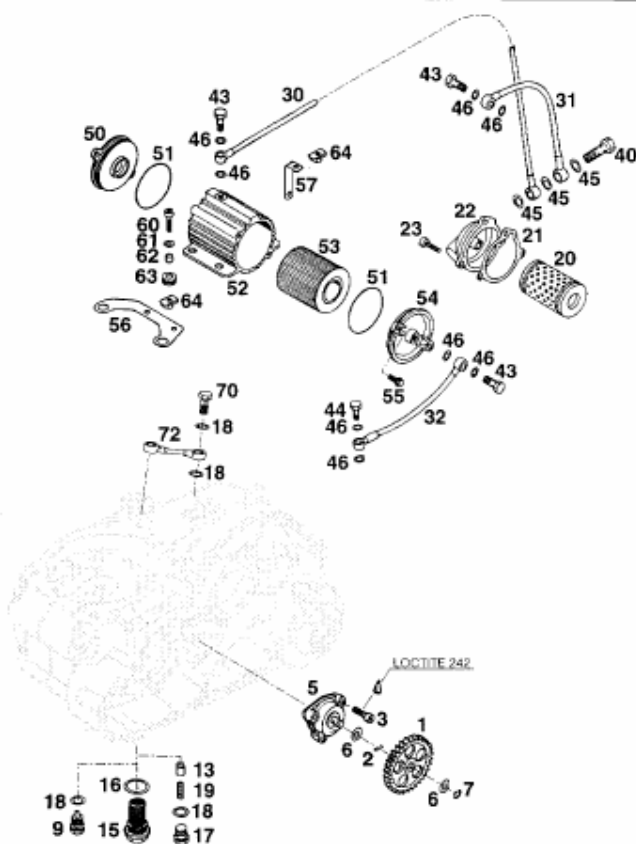


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# SCHMIERSYSTEM

## LUBRICATING SYSTEM

350/400/620 '95



| BILD / FIG | TEILNR. / PARTNR | BEZEICHNUNG                                     | DESCRIPTION     | STK. / QTY |
|------------|------------------|-------------------------------------------------|-----------------|------------|
| 61         | 0021 050003      | SCHEIBE DIN9021-A5,3                            | FLAT WASHER     | 3          |
| 62         | 544.31.032.050   | DISTANZ BÜCHSE 6 X 8 X 8,5                      | SPACER BUSHING  | 3          |
| 63         | 310.08.060.000   | KABELTÜLLE (10MM DURCHM. 8MM)                   | RUBBER SLEEVE   | 3          |
| 64         | 546.03.048.200   | MEHRBEREICHBLECHMUTTER M5                       | SHEET-METAL NUT | 3          |
| 70         | 575.38.030.000   | HOHLSCHRAUBE M12X1,5 DIN7643                    | HOLLOW SCREW    | 2          |
| 72         | 575.39.135.000   | ÖLLEITUNG KURBELGEH./GETRIEBE<br>R12/R12 - 70MM | OIL LINE        | 1          |

94-583.38.2



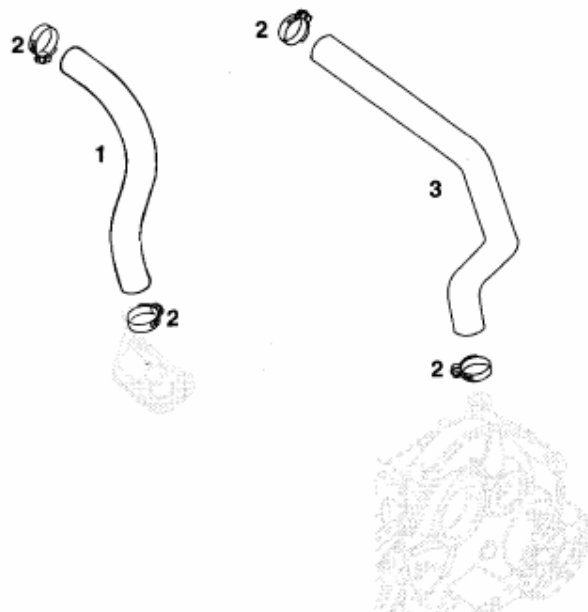
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MOTORENTLÜFTUNG

BREATHER SYSTEM

350/400/620 '95

| BILD / FIG | TEILNR. / PARTNR | BEZEICHNUNG         | DESCRIPTION       | STK. / QTY |
|------------|------------------|---------------------|-------------------|------------|
| 1          | 580.35.025.800   | ENTLÜFTUNGSSCHLAUCH | BREATHER TUBE     | 1          |
| 2          | 100.01.020.000   | SCHLAUCHBINDER A2   | CLAMP             | 4          |
| 3          | 575.30.090.000   | ENTLÜFTUNGSSCHLAUCH | '93 BREATHER TUBE | 1          |

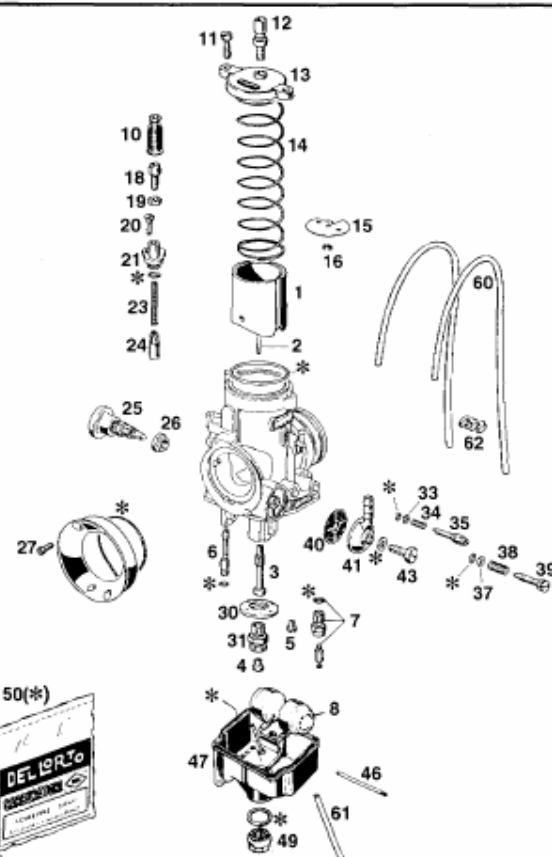


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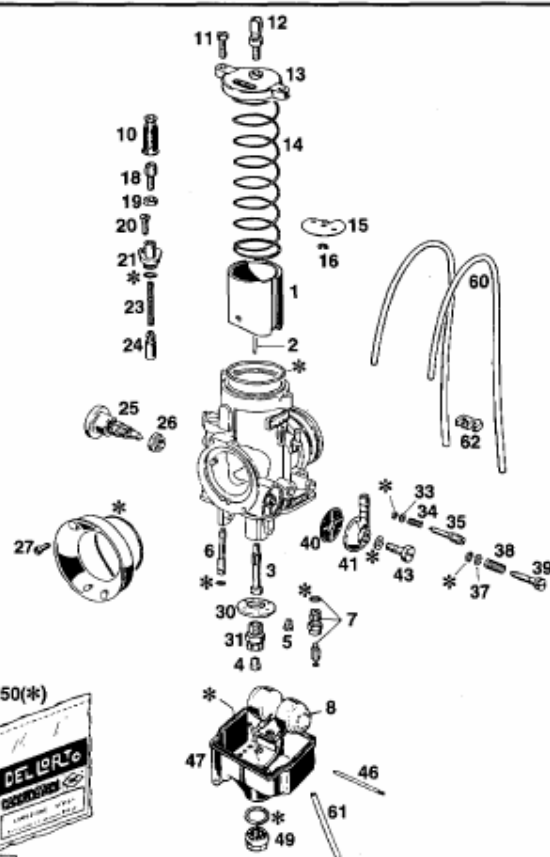
\* = NEUTEIL / NEW PART    X = NACH BEDARF / AS REQUIRED



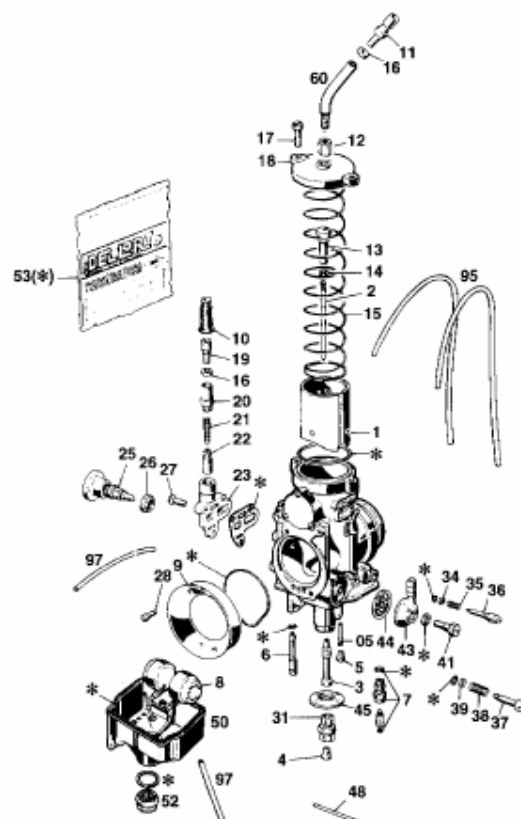


| BILD / FIG | TEILNR. / PARTNR | BEZEICHNUNG                                                  | DESCRIPTION         | STK. / QT* |
|------------|------------------|--------------------------------------------------------------|---------------------|------------|
| 1-49       | 575.31.101.044   | VERGASER PHBE 36 SD (6835)<br>45 / 52 / 180 / DR270 / WS1 11 | CARBURETOR          | 1          |
| 1          | 575.31.135.040   | GASSCHIEBER 40                                               | THROTTLE VALVE      | 1          |
| 2          | 490.31.134.051   | DÜSENNADEL K 51                                              | JET NEEDLE          | 1          |
| 3          | 580.31.121.266   | NADELDÜSE DR 266                                             | NEEDLE JET          | X          |
| 3          | 580.31.121.268   | NADELDÜSE DR 268                                             | NEEDLE JET          | X          |
| 3          | 580.31.121.270   | NADELDÜSE DR 270                                             | NEEDLE JET          | 1          |
| 4          | 570.31.523.135   | HAUPTDÜSE 135                                                | MAIN JET            | X          |
| 4          | 570.31.523.170   | HAUPTDÜSE 170                                                | MAIN JET            | X          |
| 4          | 570.31.523.180   | HAUPTDÜSE 180                                                | MAIN JET            | 1          |
| 4          | 570.31.523.190   | HAUPTDÜSE 190                                                | MAIN JET            | X          |
| 5          | 151.31.123.038   | LEERLAUFDÜSE 38                                              | IDLING JET          | X          |
| 5          | 151.31.123.045   | LEERLAUFDÜSE 45                                              | PILOT JET           | X          |
| 5          | 151.31.123.052   | LEERLAUFDÜSE 52                                              | IDLE JET            | 1          |
| 6          | 570.31.551.045   | STARTDÜSE 45                                                 | STARTING JET        | 1          |
| 7          | 572.31.120.300   | NADELVENTIL 300                                              | NEEDLE VALVE        | 1          |
| 8          | 570.31.509.000   | SCHWIMMER 8,5 GRAMM                                          | FLOAT               | 1          |
| 10         | 520.31.138.000   | GUMMITÜLLE                                                   | RUBBER PLUG         | 2          |
| 11         | 570.31.524.000   | SK-SCHRAUBE M5X16                                            | H H SCREW           | 2          |
| 12         | 570.31.525.100   | STELLSCHRAUBE M6X0,75                                        | ADJ. SCREW          | 1          |
| 13         | 501.31.127.000   | VERGASERBECKEL                                               | MIXT. CHAMBER COVER | 1          |
| 14         | 570.31.130.000   | SCHIEBERFEDER 1,25 X 180                                     | SPRING              | 1          |
| 15         | 544.31.532.000   | HALTESCHNUR                                                  | NEEDLE CLIP         | 1          |
| 16         | 0799 025055      | SICHERUNGSSCHNUR RS 2,5 X 5,5                                | CLIP                | 1          |
| 18         | 570.31.525.000   | STELLSCHRAUBE M6X0,75                                        | ADJ. SCREW          | 1          |
| 19         | 520.31.126.000   | SK-MUTTER M6X0,75                                            | NUT                 | 1          |
| 20         | 0963 045143      | SENK-SCHRAUBE M4,5X14                                        | COUNTERSUNK SCREW   | 1          |
| 21         | 570.31.555.000   | BECKEL FÜR STARTGEHÄUSE                                      | COVER               | 1          |
| 23         | 580.31.153.000   | FEDER                                                        | SPRING              | 1          |
| 24         | 570.31.549.000   | STARTKOLBEN                                                  | STARTING DEVICE     | 1          |
| 25         | 580.31.180.000   | WARMSTARTKNOPF                                               | PUSHBUTTON          | 1          |
| 26         | 580.31.181.000   | SK-MUTTER M8X0,75                                            | NUT                 | 1          |
| 27         | 0912 040123      | ISK-SCHRAUBE DIN912-M8X12                                    | ALLEN HEAD SCREW    | 2          |
| 30         | 501.31.174.000   | PRALLBLECH                                                   | COVER               | 1          |
| 31         | 570.31.522.000   | DÜSENSTOCK                                                   | MAIN JET HOLDER     | 1          |
| 33         | 570.31.572.000   | SCHNUR 3,3 X 5,8 X 0,5                                       | HASHER              | 1          |
| 34         | 570.31.515.000   | FEDER                                                        | SPRING              | 1          |

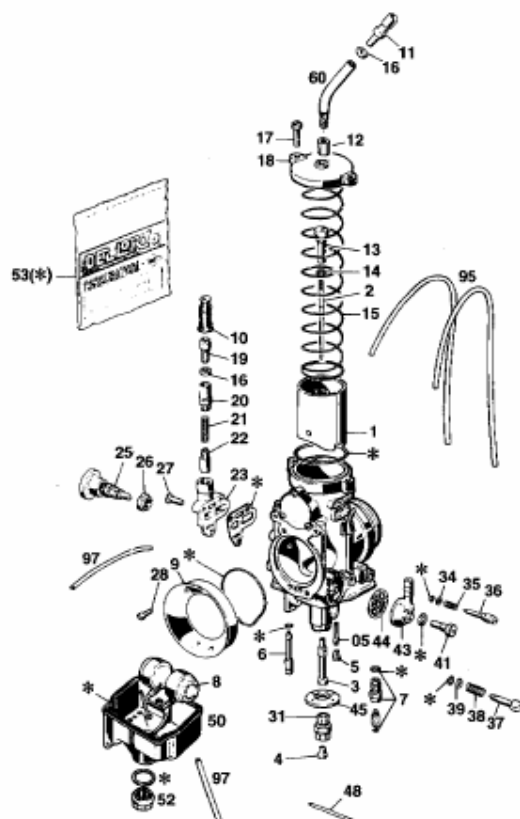
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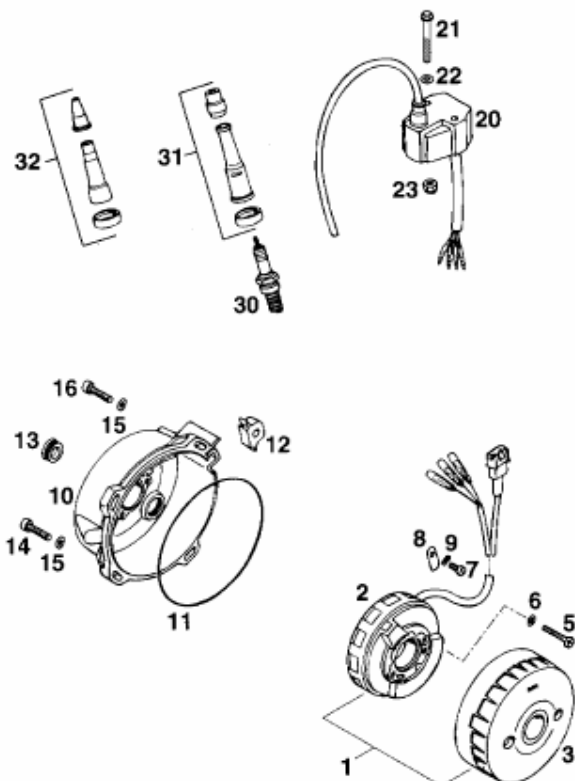
| BILD / FIG | TEILNR / PARTNR | BEZEICHNUNG                   | DESCRIPTION        | STK / QTY |
|------------|-----------------|-------------------------------|--------------------|-----------|
| 35         | 570.31.517.000  | GEMISCHREG. SCHRAUBE M7X0,75  | MIXTURE REG. SCREW | 1         |
| 37         | 570.31.573.000  | SCHEIBE 5,1 X 8 X 0,8         | WASHER             | 1         |
| 38         | 520.31.116.000  | FEDER                         | SPRING             | 1         |
| 39         | 570.31.519.000  | STELLSCHRAUBE M5              | ADJ. SCREW         | 1         |
| 40         | 151.31.112.000  | KRAFTSTOFFFILTER              | FUEL FILTER        | 1         |
| 41         | 570.31.513.000  | SCHLAUCHANSCHLUSS             | FUEL INLET BANJO   | 1         |
| 43         | 0933 060163     | SK-SCHRAUBE DIN933-M6X16      | H H SCREW          | 1         |
| 46         | 570.31.508.000  | STIFT 2 X 47                  | FLOAT PIN          | 1         |
| 47         | 570.31.511.100  | SCHWIMMERGEHÄUSE M ÜBERLAUF.  | FLOAT CHAMBER      | 1         |
| 49         | 570.31.514.000  | VERSCHLUSSSCHRAUBE M12X1      | PLUG               | 1         |
| 50         | 575.31.199.000  | DICHTUNGSSATZ PHBE 36 HD      | GASKET SET         | 1         |
| 60         | 501.31.137.000  | ENTLÜFTUNGSSCHLAUCH 3X5X190   | BREATHER TUBE      | 2         |
| 61         | 520.31.137.001  | PVC-SCHLAUCH 3X6 (ÜBERLAUF)   | TUBE 3X6           | 0,45      |
| 62         | 830.13.096.000  | KABELKLAMMER, 3-FACH, SCHWARZ | CLAMP              | 1         |



| BILD/FIG | TEILNR./PARTNR | BEZEICHNUNG                    | DESCRIPTION                | STK./QTY |
|----------|----------------|--------------------------------|----------------------------|----------|
| 1-52     | 580.31.601.644 | VERGASER PHM 38 SD (4920)      | CARBURETOR                 | 1        |
|          |                | 45 / 38 / 135 / DR266 / K51 II |                            |          |
| 1-52     | 580.31.601.844 | VERGASER PHM 38 SD (4894/6)    | CARBURETOR                 | 1        |
|          |                | 45 / 45 / 190 / DR270 / K51 II |                            |          |
| 1-52     | 580.31.901.244 | VERGASER PHM 40 SD (4922/3)    | CARBURETOR                 | 1        |
|          |                | 45 / 45 / 135 / DR268/K51 III  |                            |          |
| 1-52     | 580.31.901.444 | VERGASER PHM 40 SD (4922/3 CH) | CARBURETOR                 | 1        |
|          |                | 45 / 45 / 135 / DR268/K51 III  |                            |          |
| 1-52     | 580.31.901.544 | VERGASER PHM 40 SD (4922)      | CARBURETOR                 | 1        |
|          |                | 45 / 45 / 195 / DR272 /K51 II  |                            |          |
| 1        | 580.31.135.040 | GASSCHIEBER NR.40              | THROTTLE VALVE             | 1        |
| 2        | 490.31.134.051 | DÜSENNADEL K 51                | JET NEEDLE                 | 1        |
| 3        | 580.31.121.272 | NADELDÜSE DR 272               | NEEDLE JET                 | 1        |
| 3        | 580.31.121.270 | NADELDÜSE DR 270               | NEEDLE JET                 | 1        |
| 3        | 580.31.121.268 | NADELDÜSE DR 268               | NEEDLE JET                 | 1        |
| 3        | 580.31.121.266 | NADELDÜSE DR 266               | NEEDLE JET                 | 1        |
| 4        | 570.31.523.195 | HAUPTDÜSE 195                  | MAIN JET                   | 1        |
| 4        | 570.31.523.190 | HAUPTDÜSE 190                  | MAIN JET                   | 1        |
| 4        | 570.31.523.170 | HAUPTDÜSE 170                  | MAIN JET                   | X        |
| 4        | 570.31.523.145 | HAUPTDÜSE 145                  | MAIN JET                   | X        |
| 4        | 570.31.523.140 | HAUPTDÜSE 140                  | MAIN JET                   | X        |
| 4        | 570.31.523.135 | HAUPTDÜSE 135                  | MAIN JET                   | 1        |
| 5        | 151.31.123.045 | LEERLAUFDÜSE 45                | PILOT JET                  | 1        |
| 5        | 151.31.123.038 | LEERLAUFDÜSE 38                | IDLING JET                 | 1        |
| 05       | 490.31.122.000 | LEERLAUFMISCHROHR NR.1 CD      | IDLE EMULSION TUBE         | 1        |
| 6        | 580.31.151.045 | STARTDÜSE 45                   | STARTING JET               | 1        |
| 7        | 572.31.120.300 | NADELVENTIL 300                | NEEDLE VALVE               | 1        |
| 8        | 570.31.509.050 | SCHWIMMER 8,5 GRAMM            | FLOAT                      | X        |
| 8        | 583.31.509.000 | SCHWIMMER 6,5 GRAMM            | FLOAT                      | 1        |
| 9        | 580.31.140.038 | ANSAUGTRICHTER 38              | 400 LC4 CONNECT.AIR INTAKE | 1        |
| 9        | 580.31.140.040 | ANSAUGTRICHTER 40              | 620 LC4 CONNECT.AIR INTAKE | 1        |
| 10       | 520.31.138.000 | GUMMITÜLE                      | RUBBER PLUG                | 1        |
| 11       | 570.31.525.100 | STELLSCHRAUBE M6X0,75          | ADJ. SCREW                 | 1        |
| 12*      | 580.31.528.000 | STÜTZHÜLSE M6X0,75             | SU-10 SUPPORT BUSHING      | 1        |
| 13       | 490.31.131.000 | NIPPEL                         | NIPPLE                     | 1        |
| 14       | 0799 025055    | SICHERUNGSSCHEIBE RS 2,5 X 5,5 | CLIP                       | 1        |
| 15       | 544.31.530.000 | SCHIEBERFEDER 1,25 X 190       | SPRING                     | 1        |



| BILD / FIG | TEILNR. / PARTNR | BEZEICHNUNG                   | DESCRIPTION        | STK. / QTY |
|------------|------------------|-------------------------------|--------------------|------------|
| 16         | 520.31.126.000   | SK-MUTTER M6X0,75             | NUT                | 2          |
| 17         | 570.31.524.000   | SK-SCHRAUBE M5X16             | H H SCREW          | 2          |
| 18         | 580.31.127.000   | VERGASERDECKEL                | COVER PLATE        | 1          |
| 19         | 570.31.525.000   | STELLSCHRAUBE M6X0,75         | ADJ. SCREW         | 1          |
| 20         | 572.31.155.000   | VERSCHRAUBUNG                 | PLUG               | 1          |
| 21         | 580.31.153.000   | FEDER                         | SPRING             | 1          |
| 22         | 570.31.549.000   | STARTKOLBEN                   | STARTING DEVICE    | 1          |
| 23         | 572.31.150.100   | KALTSTARTVERGASERGEHÄUSE 4-T. | START_DEVICE BODY  | 1          |
| 25         | 580.31.180.000   | WARMSTARTKNOPF                | PUSHBUTTON         | 1          |
| 26         | 580.31.181.000   | SK-MUTTER M6X0,75             | NUT                | 1          |
| 27         | 0964 040143      | LINSENSCHRAUBE DIN964-M4X14   | FLAT HEAD SCREW    | 3          |
| 28         | 0912 040123      | ISK-SCHRAUBE DIN912-M4X12     | ALLEN HEAD SCREW   | 2          |
| 31         | 570.31.522.000   | DÜSENSTOCK                    | MAIN JET HOLDER    | 1          |
| 34         | 570.31.572.000   | SCHETBE 3,3 X 5,8 X 0,5       | WASHER             | 1          |
| 35         | 570.31.515.000   | FEDER                         | SPRING             | 1          |
| 36         | 570.31.517.000   | GEMISCHREG. SCHRAUBE M7X0,75  | MIXTURE REG. SCREW | 1          |
| 37         | 570.31.519.000   | STELLSCHRAUBE M5              | ADJ. SCREW         | 1          |
| 38         | 520.31.116.000   | FEDER                         | SPRING             | 1          |
| 39         | 570.31.573.000   | SCHETBE 5,1 X 8 X 0,8         | WASHER             | 1          |
| 41         | 0933 060163      | SK-SCHRAUBE DIN933-M6X16      | H H SCREW          | 1          |
| 43         | 570.31.513.000   | SCHLAUCHANSCHLUSS             | FUEL INLET BANJO   | 1          |
| 44         | 151.31.112.000   | KRAFTSTOFFFILTER              | FUEL FILTER        | 1          |
| 45         | 501.31.174.000   | FRALLBLECH                    | COVER              | 1          |
| 48         | 570.31.508.000   | STIFT 2 X 47                  | FLOAT PIN          | 1          |
| 50         | 570.31.511.100   | SCHWIMMERGEHÄUSE M ÜBERLAUF.  | FLOAT CHAMBER      | 1          |
| 52         | 570.31.514.000   | VERSCHLUSSSCHRAUBE M12X1      | PLUG               | 1          |
| 53         | 580.31.199.000   | DICHTUNGSSATZ PHM38SD/PHM40SD | GASKET SET         | 1          |
| 60         | 580.31.160.000   | ROHRBOGEN 41'92               | TUBE WITH THREAD   | 1          |
| 95         | 310.07.007.001   | SCHLAUCH 5 X 8 PER METER      | BREATHING HOSE 5X8 | 0,5        |
| 97         | 520.31.137.001   | PVC-SCHLAUCH 3X6 (ÜBERLAUF)   | TUBE 3X6           | 0,6        |



| BILD/FIG | TEILNR / PARTNR | BEZEICHNUNG                    | DESCRIPTION        | STK / QTY |
|----------|-----------------|--------------------------------|--------------------|-----------|
| 1        | 580.31.002.100  | ZÜNDANLAGE SEM K11/605-DB L1.  | IGNITION CPL.      | 1         |
| 2        | 580.31.002.050  | STATOR LOSE "13"               | STATOR LOOSE       | 1         |
| 3        | 580.31.002.051  | ROTOR LOSE                     | FLYWHEEL LOOSE     | 1         |
| 5        | 0084 050303     | ZYL.-SCHRAUBE DIN913-M5X30     | FLY.WHEEL SCREW    | 3         |
| 6        | 0125 050003     | SCHEIBE DIN125-A5,3            | FLAT WASHER        | 3         |
| 7        | 0500 050083     | TAPETITE SCHRAUBE M5X8         | TAPETITE SCREW     | 1         |
| 8        | 500.31.003.000  | HALTEPLÄTTCHEN                 | RETAINING PLATE    | 1         |
| 9        | 0137 050003     | FEDERSCHNUR DIN137-B5          | SPRING WASHER      | 1         |
| 10       | 580.30.002.200  | ZÜNDUNGSDECKEL SCHWARZ         | IGNITION COVER     | 1         |
| 11       | 0770 020490     | O-RING 2-49 (126,72 X 1,78)    | O-RING             | 1         |
| 12       | 580.31.004.000  | GUMMIDURCHFÜHRUNG              | RUBBER SLEEVE      | 1         |
| 13       | 580.30.002.050  | VERSCHLUSSSCHRAUBE M18X1,5     | SCREW PLUG         | 1         |
| 14       | 0912 060203     | ISK-SCHRAUBE DIN912-M6X20      | A/H SCREW          | 1         |
| 15       | 0125 060003     | SCHEIBE DIN125-A6,4            | FLAT WASHER        | 4         |
| 16       | 0912 060253     | ISK-SCHRAUBE DIN912-M6X25      | A/H SCREW          | 3         |
| 20       | 580.31.006.000  | ZÜNDSPULE TN 14-05             | IGNITION COIL      | 1         |
| 21       | 0015 060453     | SK-BUNDSCHRAUBE M6X45 SW-8     | H/H COLLAR SCREW   | 2         |
| 22       | 0125 060003     | SCHEIBE DIN125-A6,4            | FLAT WASHER        | 2         |
| 23       | 0985 060003     | SS-MUTTER DIN985-M6            | S/L NUT            | 2         |
| 30       | 580.31.093.005  | ZÜNDKERZE NGK DB EA            | SPARKING PLUG      | 1         |
| 31       | 580.31.010.000  | ZÜNDKERZENSTECKER SD 05 F NGK  | SPARK PLUG PROTECT | 1         |
| 32       | 580.31.410.044  | ZÜNDKERZENSTECKER 103000 MERIT | SPARK PLUG PROTECT | 1         |

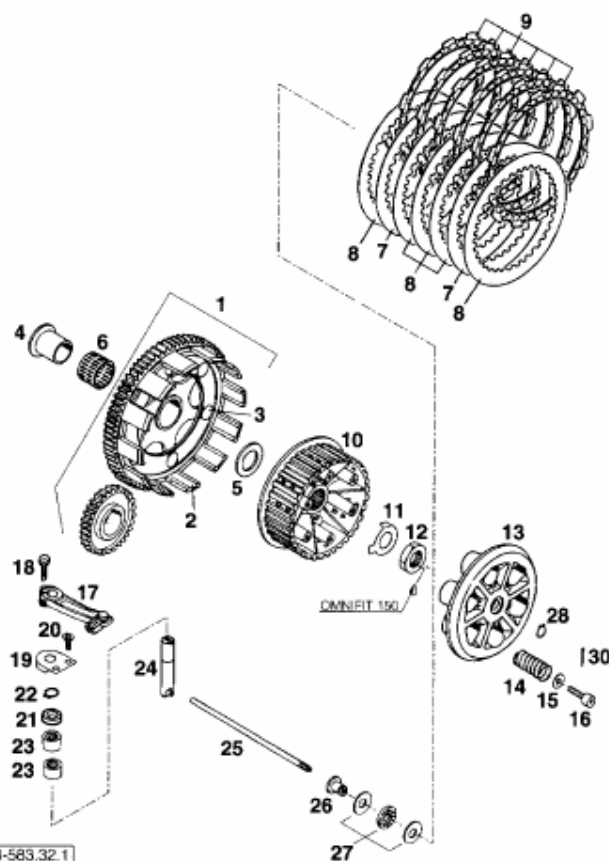


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## KUPPLUNG

## CLUTCH

350/400/620 '95



| BILD/FIG | TEILNR./PARTNR | BEZEICHNUNG                    | DESCRIPTION        | STK./QTY |
|----------|----------------|--------------------------------|--------------------|----------|
| 1        | 580.32.101.144 | KUPPLUNGSKORB 81/22-Z M.PR.30Z | OUTER CLUTCH HUB   | 1        |
| 2        | 580.32.001.000 | KUPPLUNGSKORB LOSE D=150MM     | OUTER CL.HUB LOOSE | 1        |
| 3        | 580.32.007.000 | NIET DIN 7338 8 X 11,2         | RIVET              | 6        |
| 4        | 503.32.070.000 | INNENRING MIT BUND             | INNER BUSHING      | 1        |
| 5        | 575.32.013.000 | STÜTZSCH. GEHÄRTET 22,2X35X3   | THRUST WASHER      | 1        |
| 6        | 565.32.095.000 | NADELKÄFIG K 26 X 30 X 22      | NEEDLE CAGE        | 1        |
| 7        | 580.32.112.000 | STAHLAMELLE 4 TAKT 1,4 MM      | CLUTCH DISC        | 2        |
| 8        | 580.32.012.500 | STAHLAMELLE 2 MM               | STEEL DISC         | 5        |
| 9        | 580.32.011.100 | BELAGLAMELLE 3 MM ORGANISCH    | ORGANIC DISC       | 6        |
| 10       | 565.32.002.500 | MITNEHMER "5" LC4'90           | INNER CLUTCH HUB   | 1        |
| 11       | 565.32.018.000 | SICHERUNGSBLECH                | FLAT WASHER        | 1        |
| 12       | 0936 181505    | SK-MUTTER DIN936-M18X1,5 - 8.8 | HEX NUT            | 1        |
| 13       | 565.32.003.100 | DRUCKKAPPE                     | PRESSURE PLATE     | 1        |
| 14*      | 502.32.002.000 | KUPPL.DRUCKFEDER 2,6 X 38      | CLUTCH SPRING      | 6        |
| 15       | 502.32.050.000 | SCHLEIBE 6,2 X 18 X 2          | WASHER             | 6        |
| 16       | 0912 060203    | ISK-SCHRAUBE DIN912-M6X20      | A H SCREW          | 6        |
| 17       | 580.32.014.000 | AUSRÜCKHEBEL 4-T.              | DISENGAGING LEVER  | 1        |
| 18       | 0912 060203    | ISK-SCHRAUBE DIN912-M6X20      | A H SCREW          | 1        |
| 19       | 545.32.013.000 | HALTEBLECH F.AUSRÜCKUNG        | RETAINING PLATE    | 1        |
| 20       | 0991 060122    | SENK-SCHRAUBE DIN7991-M6X12    | ALLEN FLATHEAD SCR | 2        |
| 21       | 545.32.093.000 | NUTRING N 12 X 20 X 5,5        | SEAL RING          | 1        |
| 22       | 0471 120010    | SEEGERRING DIN471-12X1         | CIRCLIP            | 1        |
| 23       | 503.32.095.000 | NADELHÜLSE HK 1212             | NEEDLE CAGE        | 2        |
| 24       | 575.32.015.000 | AUSRÜCKWELLE 12 X 66 '93       | DISENGAGING SHAFT  | 1        |
| 25       | 575.32.017.000 | DRUCKSTANGE 206 MM '93         | PUSH ROD           | 1        |
| 26       | 565.32.032.300 | AUFLAGEBOLZEN                  | PRESSURE BOLT      | 1        |
| 27       | 543.32.030.000 | AXIAL-NADELKRAUZ AXK 1024 KPL. | AXIAL NEEDLE BEARG | 1        |
| 28       | 0471 100010    | SEEGERRING DIN471-10X1         | CIRCLIP            | 1        |
| 30       | 0094 150223    | SPLINT DIN94-1,5X22            | PIN                | 1        |

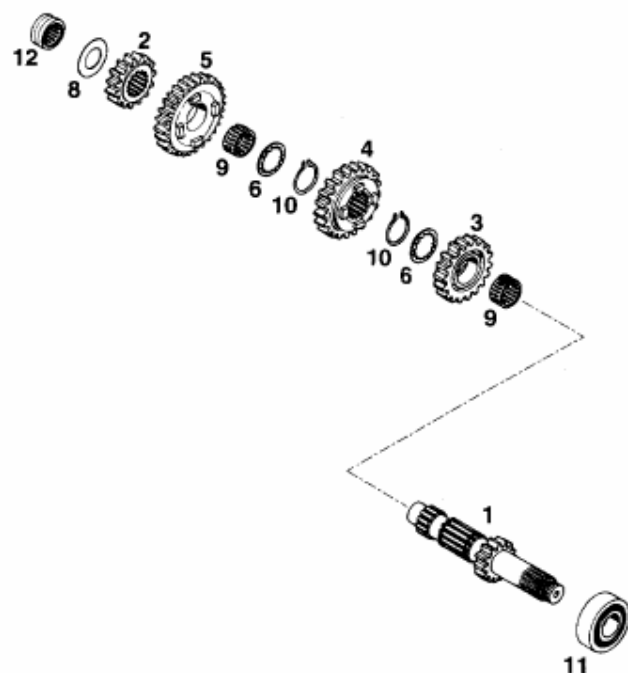
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21

\* = NEUTEIL / NEW PART

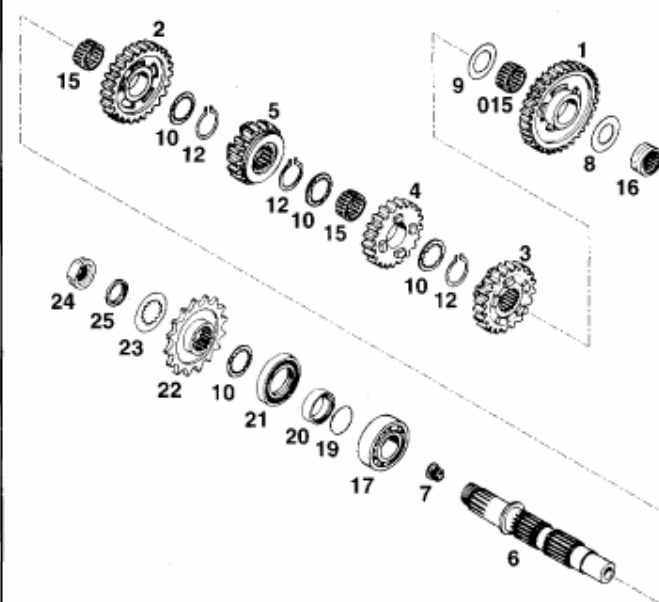
X = NACH BEDARF / AS REQUIRED

| 9LD / PG | TEILNR. / PARTNR | BEZEICHNUNG                    | DESCRIPTION           | STK. / QTY |
|----------|------------------|--------------------------------|-----------------------|------------|
| 1        | 580.33.026.200   | MITNEHMERNABE                  | '94 DRIVING HUB       | 1          |
| 2        | 580.33.020.000   | STARTERFEDER                   | KICKSTARTER SPRING    | 1          |
| 3        | 520.33.096.000   | SPRENGRING 25 X 1,6            | CIRCLIP               | 1          |
| 03       | 520.33.090.100   | SPRENGRING SM25                | CIRCLIP               | 1          |
| 4        | 580.33.037.000   | FEDERFÜHRUNG                   | SPRING BUSHING        | 1          |
| 5        | 580.33.028.000   | SPERRADFEDER 1,2 MM            | SPRING                | 1          |
| 6        | 580.33.023.100   | SPERRRAD 18-Z                  | KICKST. RATCHET       | 1          |
| 7        | 580.38.022.000   | DICHTRING 12 X 18 X 1,5 CU     | SEAL RING             | 1          |
| 8        | 580.33.033.000   | ANSCHLAGSCHRAUBE M12X1,5       | ADJUSTING BOLT        | 1          |
| 9        | 546.32.090.000   | DICHTRING 6 12 X 16 X 3        | SEAL RING             | 1          |
| 10       | 580.33.021.300   | KICKSTARTERWELLE               | '94 KICKSTARTER SHAFT | 1          |
| 11       | 580.33.031.000   | ANLAUFSCHNEIBE 22 X 30 X 1,5   | WASHER                | 1          |
| 12       | 565.33.098.000   | NADELKÄFIG K 22 X 26 X 13      | NEEDLE CAGE           | 1          |
| 13       | 580.33.022.600   | STARTERWELLENRAD 36 Z          | KICKSTARTER GEAR      | 1          |
| 14       | 580.33.024.000   | STARTERZWISCHENRAD 37-Z        | INTERMEDIATE GEAR     | 1          |
| 15       | 565.32.012.000   | ANLAUFSCHNEIBE 22,2 X 35 X 2   | THRUST WASHER         | 1          |
| 16       | 580.33.090.000   | NADELLAGER RWA 4903            | NEEDLE BEARING        | 1          |
| 17       | 0760 223270      | HELLENDICHTRING 22X32X2 BSL    | SEAL RING             | 1          |
| 20       | 583.33.036.044   | KICKSTARTER KPL. ALU LC4'94    | KICKSTARTER CPL.      | 1          |
| 21       | 0912 080253      | ISK-SCHRAUBE DIN912-M8X25      | A H SCREW             | 1          |
| 22       | 360.03.014.000   | SCHNORR-SICHERUNGSSCHNEIBE BMM | LOCK WASHER           | 1          |



| BLD./FIG | TEILNR./PARTNR | BEZEICHNUNG                    | DESCRIPTION        | STK./QTY |
|----------|----------------|--------------------------------|--------------------|----------|
| 1        | 575.33.002.000 | ANTRIEBSWELLE 15Z              | '93 MAIN SHAFT     | 1        |
| 2        | 565.33.110.400 | FESTRAD 2.G 16 Z (2M4)         | 2ND G. MAINSHAFT   | 1        |
|          |                | 400-620 EGS/RXC                |                    |          |
| 2        | 565.33.010.300 | FESTRAD 2.G 15 Z (2G3)         | 2ND G. MAINSHAFT   | 1        |
|          |                | 350-620 SX/EXC                 |                    |          |
| 3        | 565.33.004.300 | LOSRAU 3.G 18 Z (3M3)          | 3RD GEAR COUNTERS. | 1        |
| 4        | 565.33.006.300 | SCHIEBERAD 4.G 20 Z (4M3)      | 4TH GEAR MAINSHAFT | 1        |
| 5        | 565.33.008.300 | LOSRAU 5.G 27 Z (5M3)          | 5TH GEAR COUNTERS. | 1        |
| 6        | 565.33.016.300 | ANLAUFSCHIEBE 22,7 X 32 X 1,5  | THRUST WASHER      | 2        |
| 8        | 565.33.015.000 | ANLAUFSCHIEBE 20,2 X 35 X 1    | THRUST WASHER      | 1        |
| 9        | 565.33.099.000 | NADELKÄFIG K22X26X13 GETEILT   | NEEDLE CAGE        | 2        |
| 10       | 520.33.096.000 | SPRENGRING 25 X 1,6            | CIRCLIP            | 2        |
| 11       | 0625 201029    | RILLENKUGELLAGER 6304/22/C4QE6 | BALL BEARING       | 1        |
| 12       | 565.33.093.000 | NADELLAGER RNA 4902 KSE        | NEEDLE BEARING     | 1        |





| BILD/FIG | TEILNR / PARTNR | BEZEICHNUNG                    | DESCRIPTION            | STK / QTY |
|----------|-----------------|--------------------------------|------------------------|-----------|
| 1        | 575.33.005.000  | LOSAD 1.G 33 Z (1M4)           | *93 1ST GEAR COUNTERS. | 1         |
| 2        | 565.33.013.400  | LOSAD 2.G 24 Z (2M4)           | 2ND GEAR COUNTERS.     | 1         |
| 2        | 565.33.013.300  | LOSAD 2.G 24 Z (2G3)           | 2ND GEAR COUNTERS.     | 1         |
| 3        | 565.33.007.300  | SCHIEBERAD 3.G 21 Z (3M3)      | 3RD GEAR COUNTERS.     | 1         |
| 4        | 565.33.009.300  | LOSAD 4.G 19 Z (4M3)           | 4TH GEAR MAINSH.       | 1         |
| 5        | 565.33.011.300  | SCHIEBERAD 5.G 21 Z (5M3)      | 5TH GEAR COUNTERS.     | 1         |
| 6        | 580.33.003.100  | ABTRIEBSWELLE                  | COUNTER SHAFT          | 1         |
| 7        | 500.33.001.000  | VERSCHLUSSPFROPFEN             | PLASTIC CAP            | 1         |
| 8        | 565.33.015.000  | ANLAUFSCHEIBE 20,2 X 35 X 1    | THRUST WASHER          | 1         |
| 9        | 565.33.018.300  | ANLAUFSCHEIBE 22,2 X 35 X 1,5  | THRUST WASHER          | 1         |
| 10       | 565.33.016.300  | ANLAUFSCHEIBE 22,7 X 32 X 1,5  | THRUST WASHER          | 4         |
| 12       | 520.33.096.000  | SPRENGRING 25 X 1,6            | CIRCLIP                | 3         |
| 15       | 565.33.099.000  | NADELKÄFIG K22X26X13 GEREILT   | NEEDLE CAGE            | 2         |
| 015      | 565.33.098.000  | NADELKÄFIG K 22 X 26 X 13      | NEEDLE CAGE            | 1         |
| 16       | 565.33.093.000  | NADELLAGER RNA 4902 KSE        | NEEDLE BEARING         | 1         |
| 17       | 490.30.023.000  | ZYLINDERROLLENLAG. NJ205ECF/C3 | ROLLER BEARING         | 1         |
| 19       | 0770 250021     | O-RING 2 X 25 SILICON          | O-RING                 | 1         |
| 20       | 580.33.017.000  | DISTANZBUCHSE 25 X 32 X 9      | SPACER BUSHING         | 1         |
| 21       | 0760 324771     | WELLENDICHTRING 32X47X7 BSL    | SEAL RING              | 1         |
| 22       | 580.33.029.014  | KETTENRAD 14 Z                 | SPROCKET               | 1         |
| 22       | 580.33.029.015  | KETTENRAD 15 Z                 | SPROCKET               | 1         |
| 22       | 580.33.029.016  | KETTENRAD 16 Z                 | SPROCKET               | 1         |
| 23       | 510.33.031.000  | SICHERUNGSBLECH                | LOCK WASHER            | 1         |
| 24       | 580.33.032.100  | KETTENRADMUTTER                | LO4'91 SPROCKET NUT    | 1         |
| 25       | 580.33.030.000  | DISTANZRING                    | SPACER                 | 1         |



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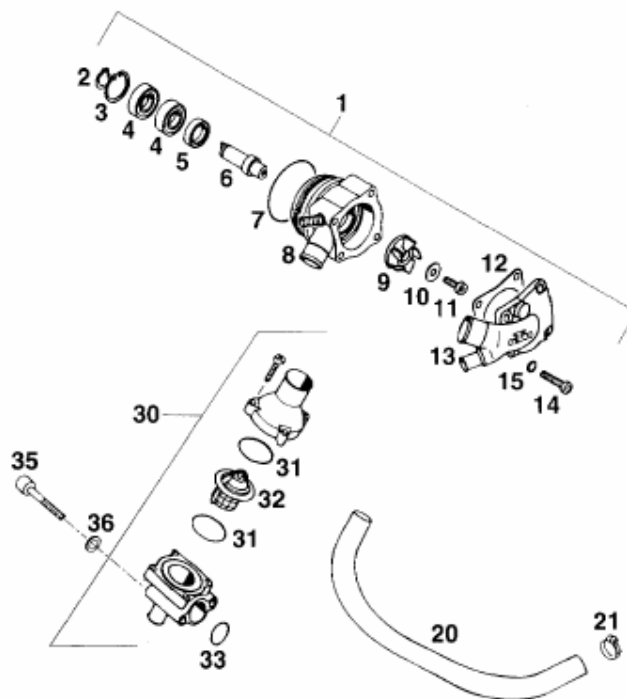
## SCHALTUNG

## SHIFTING MECHANISM

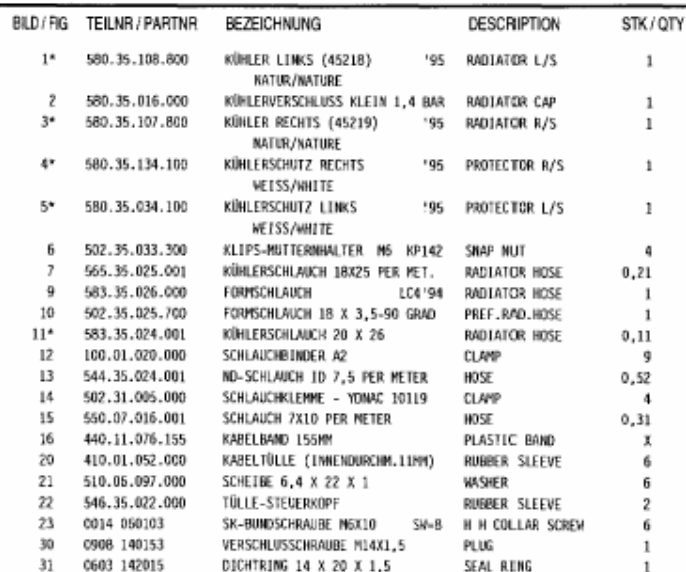
350/400/620 '95

| BILD/FG | TEILNR./PARTNR | BEZEICHNUNG                    | DESCRIPTION            | STK./QTY |
|---------|----------------|--------------------------------|------------------------|----------|
| 1       | 580.34.005.344 | SCHALTWELLE KPL.               | '93 SHIFTING SHAFT CPL | 1        |
| 2       | 565.34.013.100 | SPANNFEDER                     | SPRING                 | 1        |
| 3       | 580.34.010.000 | STAHLSCHEIBE 14 X 28 X 2       | WASHER                 | 1        |
| 4       | 580.34.014.000 | RÜCKHOLFFEDER                  | RETURN SPRING          | 1        |
| 5       | 580.34.020.000 | FEDERHÜLSE                     | SPRING BUSHING         | 1        |
| 6       | 0770 125020    | O-RING 12,5 X 2 NBR 70         | O-RING                 | 2        |
| 7       | 580.33.027.000 | V-DICHTRING VA 0014            | SEAL RING              | 1        |
| 10      | 580.34.002.200 | SCHALTGABEL 1./4. U. 2. GANG   | SHIFT FORK 1/4 + 2     | 2        |
| 11      | 580.34.004.000 | SCHALTSCHIENE 1./4. U. 2. GANG | SHIFTING ROD           | 1        |
| 12      | 580.34.001.100 | SCHALTGABEL 3./5. GANG         | SHIFT FORK 3RD/5TH     | 1        |
| 13      | 580.34.003.000 | SCHALTSCHIENE 3./5. GANG       | SHIFTING ROD           | 1        |
| 14      | 0912 060603    | ISK-SCHRAUBE DIN912-M6X60      | A H BOLT               | 1        |
| 15      | 580.34.024.544 | ARRETIERHEBEL KPL.             | LOCATING LEVER CPL     | 1        |
| 16      | 580.34.023.500 | ARRETIERHEBELFEDER             | SPRING                 | 1        |
| 17      | 580.34.017.500 | ARRETIERFEDERHÜLSE             | BUSH                   | 1        |
| 20      | 580.34.012.000 | SCHALTWALZE 5 GANG             | SHIFTING DRUM          | 1        |
| 22      | 501.34.026.100 | NADELHÜLSE 30 X 37 X 7,5       | NEEDLE CAGE            | 1        |
| 23      | 580.34.015.544 | SCHALTARRETIERUNG KPL.         | SHIFT LOCAT. DRUM      | 1        |
| 24      | 565.34.015.000 | SENKSCHRAUBE M6X30 SELBSTSICH. | COUNTERSUNK SCREW      | 1        |
| 25      | 580.34.015.500 | SCHALTKNOPF                    | SHIFTING BUTTON        | 1        |
| 30      | 580.34.022.000 | SCHALTHEBEL 4-TAKT KPL.        | SHIFTING LEVER         | 1        |
| 31      | 502.32.050.000 | SCHEIBE 6,2 X 18 X 2           | WASHER                 | 1        |
| 32      | 0933 060163    | SK-SCHRAUBE DIN933-M6X16       | H H SCREW              | 1        |
| 33      | 502.33.041.000 | NORDLOCK SCHEIBEN MG (PAAR)    | PAIR OF WASHERS        | 1        |

92-580.34.0

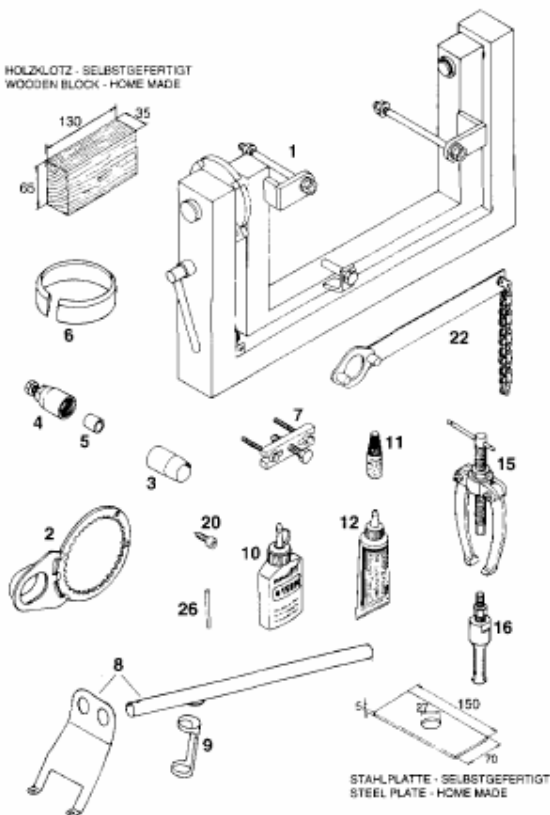


| BILD / FIG | TEILNR. / PARTNR | BEZEICHNUNG                     | DESCRIPTION       | STK / QTY |
|------------|------------------|---------------------------------|-------------------|-----------|
| 1          | 583.35.050.044   | NASSERPUMPE MECHANISCH KPL. '94 | WATER PUMP CPL.   | 1         |
| 2          | 0471 120010      | SEEGERRING DIN471-12X1          | CIRCLIP           | 1         |
| 3          | 0472 280120      | SEEGER-RING DIN472-28X1,2       | SEEGER RING       | 1         |
| 4          | 0625 060016      | RILLENKUGELLAGER 6001 RSR       | BEARING           | 2         |
| 5          | 0760 152472      | WELLENDICHTRING 15X24X7 A-D100  | SEAL RING         | 1         |
| 6          | 544.35.010.000   | WASSERPUMPEWELLE                | WATER PUMP SHAFT  | 1         |
| 7          | 0770 047015      | O-RING 47 X 1,5 NBR 70          | O-RING            | 1         |
| 8          | 580.35.002.600   | WASSERPUMPENGEHÄUSE LOSE '92    | WATER PUMP CASE   | 1         |
| 9          | 565.35.006.300   | WASSERPUMPENRAD                 | PUMP ROTOR        | 1         |
| 10         | 0021 050003      | SCHLEIBE DIN9021-A5,3           | FLAT WASHER       | 1         |
| 11         | 0912 050123      | ISK-SCHRAUBE DIN912-M5X12       | A H SCREW         | 1         |
| 12         | 565.35.003.300   | PUMPENDECKELDICHTUNG            | WATER PUMP GASKET | 1         |
| 13         | 583.35.001.000   | NASSERPUMPENDECKEL LC4'94       | WATERPUMP COVER   | 1         |
| 14         | 0984 060203      | ISK-SCHRAUBE DIN6912-M6X20      | H H SCREW         | 4         |
| 15         | 580.36.065.000   | DICHTRING 6 X 10 X 1 CM         | SEAL RING         | 4         |
| 20         | 583.35.025.001   | KÜHLERGEWEBESCHLAUCH 12 X 3     | RADIATOR HOSE     | 1         |
| 21         | 583.35.099.000   | SCHLAUCHBINDER AFS1 14-24       | CLAMP             | 2         |
| 30         | 583.35.013.044   | THERMOSTAT KPL. 70 GRAD LC4'94  | THERMOSTAT CPL.   | 1         |
| 31         | 0770 320020      | O-RING 32 X 2                   | O-RING            | 2         |
| 32         | 583.35.017.000   | THERMOSTAT 70 GRAD LC4'94       | THERMOSTAT        | 1         |
| 33         | 0770 021020      | O-RING 21 X 2 NBR 70            | O-RING            | 1         |
| 35         | 0912 060453      | ISK-SCHRAUBE DIN912-M6X45       | A H SCREW         | 2         |
| 36         | 0125 060003      | SCHLEIBE DIN125-A6,4            | FLAT WASHER       | 2         |



\* = NEUTEIL / NEW PART      X = NACHBEDARF / AS REQUIRED

HOLZKLOTZ - SELBSTGEFERTIGT  
WOODEN BLOCK - HOME MADE



STAHLPLATTE - SELBSTGEFERTIGT  
STEEL PLATE - HOME MADE

| BILD/RG | TEILNR./PARTNR | BEZEICHNUNG                                                                      | DESCRIPTION          | STK./QTY |
|---------|----------------|----------------------------------------------------------------------------------|----------------------|----------|
| 1       | 580.12.001.000 | MONTAGEBOCK                                                                      | REPAIR STAND         | 1        |
| 2       | 580.12.003.000 | KUPPLUNGSHALTER D=153MM                                                          | HOLDING PLATE        | 1        |
| 3       | 580.12.005.025 | MONTAGEHÜLSE D=25MM<br>FÜR KURBELN, SIMPERRING LINKS<br>FOR CRANKSHAFT SEAL L/S  | GUIDE SLEEVE         | 1        |
| 4       | 580.12.009.000 | SCHNUNGRADABZIEHER                                                               | MAGNETO EXTRACTOR    | 1        |
| 5       | 510.12.016.000 | SCHUTZKAPPE                                                                      | PROTECTION CAP       | 1        |
| 6       | 580.12.015.089 | KOLBEN-MONTAGERING D=89MM<br>390 LC4                                             | PISTON RINGSPANNER   | 1        |
| 6       | 580.12.015.090 | KOLBEN-MONTAGERING D=90MM<br>500 LC4                                             | PISTON RINGSPANNER   | 1        |
| 6       | 580.12.015.095 | KOLBEN-MONTAGERING D=95MM<br>400/600 LC4                                         | PISTON RINGSPANNER   | 1        |
| 6       | 580.12.015.100 | KOLBEN-MONTAGERING D=100MM<br>612 LC4                                            | PISTON RINGSPANNER   | 1        |
| 6       | 580.12.015.101 | KOLBEN-MONTAGERING D=101MM<br>620 LC4                                            | PISTON RINGSPANNER   | 1        |
| 7       | 580.12.021.000 | ABZIEHER<br>F. PRIMÄRRAD U. KUPPL. MITNEHMER<br>F. PRIM. GEAR D. INNER CLUTCHHUB | EXTRACTOR            | 1        |
| 8       | 580.12.019.000 | VENTIL-MONTAGEVORRICHTUNG                                                        | VALVE MOUNTING SET   | 1        |
| 9       | 6 276 470      | VENTILFEDER-SPANNEINSATZ                                                         | PUSH INSERT          | 1        |
| 10      | 090.43         | OMNIFIT 150 M                                                                    | OMNIFIT 150 M        | X        |
| 11      | 6 899 785      | LOCTITE BLAU 242                                                                 | 6 CCM LOCTITE BLUE   | X        |
| 12      | 6 899 784      | LOCTITE ROT 174                                                                  | 50 CCM LOCTITE RED   | X        |
| 15      | 151.12.017.000 | LAGERAUSZIEHER                                                                   | BEARING EXTRACTOR    | 1        |
| 16      | 151.12.018.000 | EINSATZ 12-16 MM                                                                 | INTERN. BEAR. PULLER | 1        |
| 16      | 151.12.018.100 | EINSATZ 18-23 MM                                                                 | INTERN. BEAR. PULLER | 1        |
| 20      | 580.30.080.000 | FIXIERSCHRAUBE M8                                                                | LOCATING BOLT        | 1        |
| 22      | 510.12.012.000 | HALTESCHLÜSSEL                                                                   | HOLDING SPANNER      | 1        |
| 26      | 580.29.026.007 | GRENZLEHRDORN F. VENTILFÜHRUNG<br>D=7,05MM                                       | LIMIT PLUG GAUGE     | 1        |

## TECHNISCHE DATEN – MOTOR

|                       | 350 LC4                                                                                       | 400 LC4      | 620 LC4     |
|-----------------------|-----------------------------------------------------------------------------------------------|--------------|-------------|
| Bauart                | 1-Zylinder 4-Takt Otto-Motor, Flüssigkeitsgekühlt                                             |              |             |
| Hubraum               | 349 cm³                                                                                       | 398 cm³      | 609 cm³     |
| Bohrung/Hub           | 89 / 56,2 mm                                                                                  | 95 / 56,2 mm | 101 / 76 mm |
| Verdichtung           | 10,4 : 1                                                                                      | 10,0 : 1     | 10,5 : 1    |
| Kraftstoff            | bleifreier Superkraftstoff mit mindestens ROZ 95                                              |              |             |
| Steuerung             | 4 Ventile über Kipphebel u. 1 Nockenwelle gesteuert; Antrieb der Nockenwelle mit Einfachkette |              |             |
| Nockenwelle           | Einlaß 249° Auslaß 225° [995]                                                                 |              |             |
| Steuerzeiten bei 1 mm | EO 17° v.OT AO 46° v.UT                                                                       |              |             |
| Ventilspiel           | EO 52° n.UT AS 1° v.OT                                                                        |              |             |
| Ventildurchmesser     | Einlaß: 36 mm Auslaß: 30 mm                                                                   |              |             |
| Ventilspiel kalt      | Einlaß: 0,10 mm Auslaß: 0,10 mm                                                               |              |             |
| Kurbelwellenlagerung  | 2 Zylinderrollenlager                                                                         |              |             |
| Flauellager           | Nadelager                                                                                     |              |             |
| Kolbenbolzenlager     | Bronzebüchse                                                                                  |              |             |
| Kolben                | leichtmetall – geschmiedet                                                                    |              |             |
| Kolbenringe           | 1 Kompressionsring, 1 Minuterring, 1 Ölabstreifring                                           |              |             |
| Motorschmierng        | Druckumlaufschmierung mittels Eatonpumpe                                                      |              |             |
| Motoröl               | siehe unten *                                                                                 |              |             |
| Füllmenge Motoröl     | Ölkreislauf nur im Motor: 1,7 Liter                                                           |              |             |
| Primärtrieb           | gerade verzahnte Stirnräder 30:81 Z                                                           |              |             |
| Kupplung              | Mehrscheibenkupplung im Ölbad                                                                 |              |             |
| Getriebe              | 5-Gang klauengeschaltet                                                                       |              |             |
| Zündanlage            | kontaktlos gesteuerte Thyristor-Zündanlage mit elektronischer Zündverstellung, Typ SEM        |              |             |
| Zündzeitpunkt         | Verstellung bis max. 38° v. OT bei 6000/min                                                   |              |             |
| Generator             | 12V 130W                                                                                      |              |             |
| Zündkerze             | NGK D8EA                                                                                      |              |             |
| Elektrodenabstand     | 0,6 mm                                                                                        |              |             |
| Kühlung               | Flüssigkeitskühlung, permanente Umröhrung der Kühlflüssigkeit durch Wasserpumpe               |              |             |
| Kühlflüssigkeit       | 1 Liter, Mischungsverhältnis 40% Frostschutz, 60% Wasser, mindestens -25° C                   |              |             |
| Starthilfe            | DeKompressor handbetätigt, Kalt- und Heißstarteinrichtung am Vergaser                         |              |             |

## VERGASER-GRUNDEINSTELLUNG

|                            | 350 SUPER-COMP.<br>DIV., G8 | 400 SUPER-COMP.<br>DIV., J, G8, E, B, NL<br>P, AUS, USA | 400 SUPER-COMP.<br>D, A, CH, F | 620 SI DIV., F, J, G8, B, NL<br>620 SUPER-COMP.<br>DIV., J, G8, E, B, NL, P, AUS, USA | 620 SUPER-COMP.<br>D, A, CH, F |
|----------------------------|-----------------------------|---------------------------------------------------------|--------------------------------|---------------------------------------------------------------------------------------|--------------------------------|
| Vergasertyp                | PHB 36 HD                   | PHW 38 SD                                               | PHW 38 SD                      | PHW 40 SD                                                                             | PHW 40 SD                      |
| Regulierungsnr.            | 6835                        | 4894/6                                                  | 4920                           | 4922                                                                                  | 4922/3                         |
| Hauptlöse                  | 180                         | 190                                                     | 135                            | 195                                                                                   | 135                            |
| Nadelöse                   | DR 270                      | DR 270                                                  | DR 266                         | DR 272                                                                                | DR 268                         |
| Leerlöse                   | 52                          | 45                                                      | 38                             | 45                                                                                    | 45                             |
| Düsenadel                  | K 51                        | K 51                                                    | K 51                           | K 51                                                                                  | K 51                           |
| Nadelposition              | 2. von oben                 | 2. von oben                                             | 2. von oben                    | 2. von oben                                                                           | 3. von oben                    |
| Gemischreg. Schraube offen | 1 Umdr.                     | 2 Umdr.                                                 | 2 Umdr.                        | 1,5 Umdr.                                                                             | 1,5 Umdr.                      |
| Gemischreg. Schraube       | 40                          | 40                                                      | 40                             | 40                                                                                    | 40                             |
| Startlöse                  | 45                          | 45                                                      | 45                             | 45                                                                                    | 45                             |

## GETRIEBEÜBERSETZUNG

| Primär-<br>übersetzung | Getriebeübersetzung | Original-<br>übersetzung<br>Hinterrad | Lieferbare<br>Kettenritzel | Lieferbare Ketten-<br>räder hinten |
|------------------------|---------------------|---------------------------------------|----------------------------|------------------------------------|
| 30:81                  | 350/400<br>S.COMP.  | 350/400<br>S.COMP.                    | 13 Z                       | 38 Z                               |
|                        | 620 SI<br>S.COMP.   | 16:50/15:45/16:45                     | 14 Z                       | 40 Z                               |
|                        | 1. Gang 15:33 15:33 |                                       | 15 Z                       | 42 Z                               |
|                        | 2. Gang 15:24 16:24 |                                       | 16 Z                       | 43 Z                               |
|                        | 3. Gang 18:21 18:21 |                                       | 15 Z                       | 45 Z                               |
|                        | 4. Gang 20:19 20:19 | 620 SI<br>S.COMP.                     | 16 Z                       | 48 Z                               |
|                        | 5. Gang 27:21 27:21 | 15:50/16:40                           |                            | 50 Z                               |
|                        |                     |                                       |                            | 52 Z                               |

## TOLERANZEN, EINBAUSPIELE

|                       |                                |                   |
|-----------------------|--------------------------------|-------------------|
| Kurbelwelle           | Axialspiel                     | max. 0,1 - 0,2 mm |
| Flauellager           | Kurbelzapfenschlag             | max. 0,04 mm      |
|                       | Radialspiel                    | max. 0,05 mm      |
|                       | Axialspiel                     | max. 1,00 mm      |
| Kolben                | Einbauspil 350/400/620         | max. 0,12 mm      |
| Kolbenringe Stoßspiel | Kompressionsringe              | max. 0,60 mm      |
|                       | Ölabstreifring                 | max. 0,80 mm      |
| Ventile               | Dichtsitzbreite Einlaß         | max. 1,50 mm      |
|                       | Auslaß                         | max. 2,00 mm      |
|                       | Ventillift Schloß              | max. 0,03 mm      |
|                       | Ventillift Durchmesser         | max. 7,05 mm      |
| Ölpumpe               | Spiel Außenrotor - Gehäuse     | max. 0,20 mm      |
|                       | Spitzenspiel Außen- Innenrotor | max. 0,20 mm      |
| Bypaßventil           | Druckfeder Mindestlänge        | 25 mm             |
| Kupplungsstempel      | Mindeststärke Organisch        | 2,8 mm            |
| Getriebewellen        | Axialspiel                     | 0,1 - 0,3 mm      |

## ANZUGSDREHMOMENTE – MOTOR

|                                       |             |                 |
|---------------------------------------|-------------|-----------------|
| Sechskantmutter Primärrod             | M20x1,5     | Lochte + 170 Nm |
| Bundmutter Schwungrad                 | M12x1 links | 60 Nm           |
| Sechskantmutter für Kupplungsminehmer | M18x1,5     | 80 Nm           |
| Kickstarter-Anschlagschraube          | M12x1,5     | 70 Nm           |
| Innensechskantschrauben der Ölpumpe   | M6          | 8 Nm            |
| Sechskantschraube Nockenwellenrad     | M10         | 50 Nm           |
| Schrauben Zylinderkopf-Oberteil       | M6x25       | 8 Nm            |
| Schrauben Zylinderkopf-Oberteil       | M6x60/M6x65 | 16 Nm           |
| Zylinderkopfschrauben                 | M10         | 50 Nm           |
| Bundmutter am Zylinderfuß             | M10         | 40 Nm           |
| Sechskantmutter Kettenrod             | M20x1,5     | 70 Nm           |
| Ölablaßschraube                       | M22x1,5     | 50 Nm           |
| Magnetschraube                        | M12x1,5     | 20 Nm           |
| Verschlußschraube Bypaßventil         | M12x1,5     | 20 Nm           |
| Hohlsschrauben Ölleitungen            | M8          | 10 Nm           |
| Hohlsschrauben Ölleitungen            | M12         | 20 Nm           |
| Düsen-schraube Kupplungsdeckel        | M8          | 10 Nm           |
| Verschlußschraube Steuerkettenspanner | M12x1,5     | 20 Nm           |
| Konturmutter Ventileinstellschrauben  | M7x0,75     | 20 Nm           |

## TECHNICAL DATA - ENGINE

| Engine                               | 350 LC4                                                                                | 400 LC4             | 620 LC4             |
|--------------------------------------|----------------------------------------------------------------------------------------|---------------------|---------------------|
| Design                               | Liquid-cooled single cylinder 4-stroke engine                                          |                     |                     |
| Displacement                         | 349 cm <sup>3</sup>                                                                    | 398 cm <sup>3</sup> | 609 cm <sup>3</sup> |
| Bore / Stroke                        | 89 / 56,2 mm                                                                           | 95 / 56,2 mm        | 101 / 76 mm         |
| Ratio                                | 10,4 : 1                                                                               | 10,0 : 1            | 10,5 : 1            |
| Fuel                                 | unleaded premium gasoline with a least RON 95                                          |                     |                     |
| Valve timing                         | 4 valves over rocker arm and 1 overhead camshaft, camshaft drive through single chain  |                     |                     |
| Camshaft                             | Intake: 249° Exhaust: 225° (995)                                                       |                     |                     |
| Valve timing by 1 mm valve clearance | IO 17° BTDC EO 46° BBDC IC 52° ABDC EC 1° BTDC                                         |                     |                     |
| Valve diameter                       | Intake: 36 mm Exhaust: 30 mm                                                           |                     |                     |
| Valve clearance cold                 | Intake: 0,10 mm Exhaust: 0,10 mm                                                       |                     |                     |
| Crank shaft bearing                  | 2 cylinder roller bearing                                                              |                     |                     |
| Connecting rod bearing               | needle bearing                                                                         |                     |                     |
| Top end bearing                      | bronze bushing                                                                         |                     |                     |
| Piston                               | forged aluminium-alloy                                                                 |                     |                     |
| Piston rings                         | 1 compression ring, 1 taper face ring, 1 oil scraper ring                              |                     |                     |
| Engine lubrication                   | forced-feed lubrication through Eaton-Oilpump with oil pump                            |                     |                     |
| Engine oil                           | see below *                                                                            |                     |                     |
| Engine oil quantity                  | oil flow also thru engine: 1,7 liters                                                  |                     |                     |
| Primary ratio                        | straight geared spur wheels 30 : 81 teeth                                              |                     |                     |
| Clutch                               | multi disc clutch in oil bath                                                          |                     |                     |
| Transmission                         | 5-speed claw shifted                                                                   |                     |                     |
| Ignition system                      | contactless thyristor ignition with electronic advanced system type SEM                |                     |                     |
| Ignition timing                      | adjustment to max. 38° BTDC at 6000 rpm                                                |                     |                     |
| Generator                            | 12V 130W                                                                               |                     |                     |
| Spark plug                           | NGK D8EA                                                                               |                     |                     |
| Spark plug gap                       | 0,6 mm                                                                                 |                     |                     |
| Cooling system                       | liquid cooled, permanent rotation of cooling liquid through mechanic driven water pump |                     |                     |
| Cooling liquid                       | 1 liter, 40% antifreeze, 60% water, at least -25° C (-13° F)                           |                     |                     |
| Starting equipment                   | decompressor hand actuated, cold and hot start knob on carburetor                      |                     |                     |

### BASIC CARBURETOR SETTING

|                               | 350 SUPER-COMP.<br>DIV.,GB | 400 SUPER-COMP.<br>DIV.,I,GB,E,B,NL<br>P,AUS,USA | 400 SUPER-COMP.<br>DIV.,A,CH,F | 620 SX DIV.,F,I,GB,B,NL<br>620 SUPER-COMP.<br>DIV.,I,GB,E,B,NL,P,AUS,USA | 620 SUPER-COMP.<br>DIV.,A,CH,F |
|-------------------------------|----------------------------|--------------------------------------------------|--------------------------------|--------------------------------------------------------------------------|--------------------------------|
| Type                          | PHB 36 HD                  | PHM 38 SD                                        | PHM 38 SD                      | PHM 40 SD                                                                | PHM 40 SD                      |
| Carburetor setting number     | 6835                       | 4894/6                                           | 4920                           | 4922                                                                     | 4922/3                         |
| Main jet                      | 180                        | 190                                              | 135                            | 195                                                                      | 135                            |
| Needle jet                    | DR 270                     | DR 270                                           | DR 266                         | DR 272                                                                   | DR 268                         |
| Idle jet                      | 52                         | 45                                               | 38                             | 45                                                                       | 45                             |
| Jet needle                    | K 51                       | K 51                                             | K 51                           | K 51                                                                     | K 51                           |
| Needle clip position from top | 2. von oben                | 2. von oben                                      | 2. von oben                    | 2. von oben                                                              | 3. von oben                    |
| Mixture adjusting screw open  | 1 Umdr.                    | 2 Umdr.                                          | 2 Umdr.                        | 1,5 Umdr.                                                                | 1,5 Umdr.                      |
| Throttle valve                | 40                         | 40                                               | 40                             | 40                                                                       | 40                             |
| Starting jet                  | 45                         | 45                                               | 45                             | 45                                                                       | 45                             |

### GEAR RATIOS

| Primary ratio | Transmission   | Original final drive ratio | Available chain drive sprockets | Available final drive sprockets |
|---------------|----------------|----------------------------|---------------------------------|---------------------------------|
| 30:81         | 350/400        | 350/400                    | 13 t                            | 38 t                            |
|               | S.COMP. 620    | S.COMP. 1430/1543/1643     | 14 t                            | 40 t                            |
|               | 620 SX S.COMP. | 15:33 15:33                | 15 t                            | 42 t                            |
|               | 1st gear       | 15:24 16:24                | 16 t                            | 43 t                            |
|               | 2nd gear       | 18:21 18:21                | 15 t                            | 45 t                            |
|               | 3rd gear       | 20:19 20:19                | 16 t                            | 48 t                            |
|               | 4th gear       | 27:21 27:21                |                                 | 50 t                            |
|               | 5th gear       |                            |                                 | 52 t                            |

### TOLERANCE, ASSEMBLY CLEARANCE

|                        |                                     |              |
|------------------------|-------------------------------------|--------------|
| Crank shaft            | axial play                          | 0,1 - 0,2 mm |
|                        | run out of crank stud               | max. 0,04 mm |
| Connecting rod bearing | radial play                         | max. 0,05 mm |
|                        | axial play                          | max. 1,00 mm |
| Piston                 | assembly clearance 350/400/620      | max. 0,12 mm |
| Piston rings and gap   | compression rings                   | max. 0,60 mm |
|                        | oil scraper ring                    | max. 0,80 mm |
| Valves                 | seat sealing intake                 | max. 1,50 mm |
|                        | seat sealing exhaust                | max. 2,00 mm |
|                        | run out of valve heads              | max. 0,03 mm |
|                        | valve guides diameter               | max. 7,05 mm |
| Oil pump               | clearance outer rotor - housing     | max. 0,20 mm |
|                        | clearance outer rotor - inner rotor | max. 0,20 mm |
| Bypass valve           | minimum spring length               | 25 mm        |
| Clutch discs           | wear limit organic                  | 2,8 mm       |
| Transmission shafts    | axial play                          | 0,1 - 0,3 mm |

### TIGHTENING TORQUES - ENGINE

|                                          |                 |                 |
|------------------------------------------|-----------------|-----------------|
| Hexagon nut of primary gear              | M20x1,5         | Lochte + 170 Nm |
| Collar nut flywheel                      | M12x1 LH thread | 60 Nm           |
| Hexagon nut for inner clutch hub         | M18x1,5         | 80 Nm           |
| Kickstarter stop screw                   | M12x1,5         | 70 Nm           |
| Allen head screws oil pump               | M6              | 8 Nm            |
| Hexagon screw camshaft gear              | M10             | 50 Nm           |
| Allen head screw cylinder head top sect. | M6x25           | 8 Nm            |
| Allen head screw cylinder head top sect. | M6x40/M6x65     | 16 Nm           |
| Cylinder head screws                     | M10             | 50 Nm           |
| Collar nuts at cylinder base             | M10             | 40 Nm           |
| Hexagon nut chain sprocket               | M20x1,5         | 70 Nm           |
| Oil drain plug                           | M22x1,5         | 50 Nm           |
| Magnetic plug                            | M12x1,5         | 20 Nm           |
| Plug bypass valve                        | M12x1,5         | 20 Nm           |
| Hollow screws oil lines                  | M8              | 10 Nm           |
| Hollow screws oil lines                  | M12             | 20 Nm           |
| Jet screw clutch cover                   | M8              | 10 Nm           |
| Screw plug timing-chain tensioner        | M12x1,5         | 20 Nm           |
| Counternuts valve adjusting screws       | M7x0,75         | 20 Nm           |

## TECHNICAL DATA - ENGINE

| Engine                               | 350 LC4                                                                                | 400 LC4             | 620 LC4             |
|--------------------------------------|----------------------------------------------------------------------------------------|---------------------|---------------------|
| Design                               | Liquid-cooled single cylinder 4-stroke engine                                          |                     |                     |
| Displacement                         | 349 cm <sup>3</sup>                                                                    | 398 cm <sup>3</sup> | 609 cm <sup>3</sup> |
| Bore / Stroke                        | 89 / 56,2 mm                                                                           | 95 / 56,2 mm        | 101 / 76 mm         |
| Ratio                                | 10,4 : 1                                                                               | 10,0 : 1            | 10,5 : 1            |
| Fuel                                 | unleaded premium gasoline with a least RON 95                                          |                     |                     |
| Valve timing                         | 4 valves over rocker arm and 1 overhead camshaft, camshaft drive through single chain  |                     |                     |
| Camshaft                             | Intake: 249° Exhaust: 225° (995)                                                       |                     |                     |
| Valve timing by 1 mm valve clearance | IO 17° BTDC EO 46° BBDC IC 52° ABDC EC 1° BTDC                                         |                     |                     |
| Valve diameter                       | Intake: 36 mm Exhaust: 30 mm                                                           |                     |                     |
| Valve clearance cold                 | Intake: 0,10 mm Exhaust: 0,10 mm                                                       |                     |                     |
| Crank shaft bearing                  | 2 cylinder roller bearing                                                              |                     |                     |
| Connecting rod bearing               | needle bearing                                                                         |                     |                     |
| Top end bearing                      | bronze bushing                                                                         |                     |                     |
| Piston                               | forged aluminium-alloy                                                                 |                     |                     |
| Piston rings                         | 1 compression ring, 1 taper face ring, 1 oil scraper ring                              |                     |                     |
| Engine lubrication                   | forced-feed lubrication through Eaton-Oilpump with oil pump                            |                     |                     |
| Engine oil                           | see below *                                                                            |                     |                     |
| Engine oil quantity                  | oil flow also thru engine: 1,7 liters                                                  |                     |                     |
| Primary ratio                        | straight geared spur wheels 30 : 81 teeth                                              |                     |                     |
| Clutch                               | multi disc clutch in oil bath                                                          |                     |                     |
| Transmission                         | 5-speed claw shifted                                                                   |                     |                     |
| Ignition system                      | contactless thyristor ignition with electronic advanced system type SEM                |                     |                     |
| Ignition timing                      | adjustment to max. 38° BTDC at 6000 rpm                                                |                     |                     |
| Generator                            | 12V 130W                                                                               |                     |                     |
| Spark plug                           | NGK D8EA                                                                               |                     |                     |
| Spark plug gap                       | 0,6 mm                                                                                 |                     |                     |
| Cooling system                       | liquid cooled, permanent rotation of cooling liquid through mechanic driven water pump |                     |                     |
| Cooling liquid                       | 1 liter, 40% antifreeze, 60% water, at least -25° C (-13° F)                           |                     |                     |
| Starting equipment                   | decompressor hand actuated, cold and hot start knob on carburetor                      |                     |                     |

### BASIC CARBURETOR SETTING

|                               | 350 SUPER-COMP.<br>DIV.,GB | 400 SUPER-COMP.<br>DIV.,I,GB,E,B,NL<br>P,AUS,USA | 400 SUPER-COMP.<br>DIV.,A,CH,F | 620 SX DIV.,F,I,GB,B,NL<br>620 SUPER-COMP.<br>DIV.,I,GB,E,B,NL,P,AUS,USA | 620 SUPER-COMP.<br>DIV.,A,CH,F |
|-------------------------------|----------------------------|--------------------------------------------------|--------------------------------|--------------------------------------------------------------------------|--------------------------------|
| Type                          | PHB 36 HD                  | PHM 38 SD                                        | PHM 38 SD                      | PHM 40 SD                                                                | PHM 40 SD                      |
| Carburetor setting number     | 6835                       | 4894/6                                           | 4920                           | 4922                                                                     | 4922/3                         |
| Main jet                      | 180                        | 190                                              | 135                            | 195                                                                      | 135                            |
| Needle jet                    | DR 270                     | DR 270                                           | DR 266                         | DR 272                                                                   | DR 268                         |
| Idle jet                      | 52                         | 45                                               | 38                             | 45                                                                       | 45                             |
| Jet needle                    | K 51                       | K 51                                             | K 51                           | K 51                                                                     | K 51                           |
| Needle clip position from top | 2. von oben                | 2. von oben                                      | 2. von oben                    | 2. von oben                                                              | 3. von oben                    |
| Mixture adjusting screw open  | 1 Umdr.                    | 2 Umdr.                                          | 2 Umdr.                        | 1,5 Umdr.                                                                | 1,5 Umdr.                      |
| Throttle valve                | 40                         | 40                                               | 40                             | 40                                                                       | 40                             |
| Starting jet                  | 45                         | 45                                               | 45                             | 45                                                                       | 45                             |

### GEAR RATIOS

| Primary ratio | Transmission   | Original final drive ratio | Available chain drive sprockets | Available final drive sprockets |
|---------------|----------------|----------------------------|---------------------------------|---------------------------------|
| 30:81         | 350/400        | 350/400                    | 13 t                            | 38 t                            |
|               | S.COMP. 620    | S.COMP. 1430/1543/1643     | 14 t                            | 40 t                            |
|               | 620 SX S.COMP. | 15:33 15:33                | 15 t                            | 42 t                            |
|               | 1st gear       | 15:24 16:24                | 16 t                            | 43 t                            |
|               | 2nd gear       | 18:21 18:21                | 15 t                            | 45 t                            |
|               | 3rd gear       | 20:19 20:19                | 16 t                            | 48 t                            |
|               | 4th gear       | 27:21 27:21                |                                 | 50 t                            |
|               | 5th gear       |                            |                                 | 52 t                            |

### TOLERANCE, ASSEMBLY CLEARANCE

|                        |                                     |              |
|------------------------|-------------------------------------|--------------|
| Crank shaft            | axial play                          | 0,1 - 0,2 mm |
|                        | run out of crank stud               | max. 0,04 mm |
| Connecting rod bearing | radial play                         | max. 0,05 mm |
|                        | axial play                          | max. 1,00 mm |
| Piston                 | assembly clearance 350/400/620      | max. 0,12 mm |
| Piston rings and gap   | compression rings                   | max. 0,60 mm |
|                        | oil scraper ring                    | max. 0,80 mm |
| Valves                 | seat sealing intake                 | max. 1,50 mm |
|                        | seat sealing exhaust                | max. 2,00 mm |
|                        | run out of valve heads              | max. 0,03 mm |
|                        | valve guides diameter               | max. 7,05 mm |
| Oil pump               | clearance outer rotor - housing     | max. 0,20 mm |
|                        | clearance outer rotor - inner rotor | max. 0,20 mm |
| Bypass valve           | minimum spring length               | 25 mm        |
| Clutch discs           | wear limit organic                  | 2,8 mm       |
| Transmission shafts    | axial play                          | 0,1 - 0,3 mm |

### TIGHTENING TORQUES - ENGINE

|                                          |                 |                 |
|------------------------------------------|-----------------|-----------------|
| Hexagon nut of primary gear              | M20x1,5         | Lochte + 170 Nm |
| Collar nut flywheel                      | M12x1 LH thread | 60 Nm           |
| Hexagon nut for inner clutch hub         | M18x1,5         | 80 Nm           |
| Kickstarter stop screw                   | M12x1,5         | 70 Nm           |
| Allen head screws oil pump               | M6              | 8 Nm            |
| Hexagon screw camshaft gear              | M10             | 50 Nm           |
| Allen head screw cylinder head top sect. | M6x25           | 8 Nm            |
| Allen head screw cylinder head top sect. | M6x40/M6x65     | 16 Nm           |
| Cylinder head screws                     | M10             | 50 Nm           |
| Collar nuts at cylinder base             | M10             | 40 Nm           |
| Hexagon nut chain sprocket               | M20x1,5         | 70 Nm           |
| Oil drain plug                           | M22x1,5         | 50 Nm           |
| Magnetic plug                            | M12x1,5         | 20 Nm           |
| Plug bypass valve                        | M12x1,5         | 20 Nm           |
| Hollow screws oil lines                  | M8              | 10 Nm           |
| Hollow screws oil lines                  | M12             | 20 Nm           |
| Jet screw clutch cover                   | M8              | 10 Nm           |
| Screw plug timing-chain tensioner        | M12x1,5         | 20 Nm           |
| Counternuts valve adjusting screws       | M7x0,75         | 20 Nm           |



\*

| API: SF, SG, SH |                 |
|-----------------|-----------------|
| TEMPERATUR      |                 |
| ← -             | 0°C<br>32°F → + |
| 10W 40          | 15W 40          |
| 10W 50          | 15W 50          |
| 10W 60          | 15W 60          |

#### Motoröl

Verwenden Sie nur Markenöle, welche die Qualitätsanforderungen der API-Klassen SF, SG oder SH (Angaben auf dem Behälter) erfüllen oder übertreffen. Es können sowohl Mineralöle als auch Synthetöle mit den hier angegebenen Spezifikationen verwendet werden.

#### VORSICHT

Zu wenig Motoröl oder qualitativ minderwertiges Öl führt zu vorzeitigem Verschleiß des Motors.

\*

| API: SF, SG, SH |             |        |
|-----------------|-------------|--------|
| TEMPERATUR      |             |        |
| ← -             | 0°C<br>32°F | + →    |
| 10W 40          |             | 15W 40 |
| 10W 50          |             | 15W 50 |
| 10W 60          |             | 15W 60 |

#### Motoröl

Verwenden Sie nur Markenöle, welche die Qualitätsanforderungen der API-Klassen SF, SG oder SH (Angaben auf dem Behälter) erfüllen oder übertreffen. Es können sowohl Mineralöle als auch Syntheticole mit den hier angegebenen Spezifikationen verwendet werden.

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