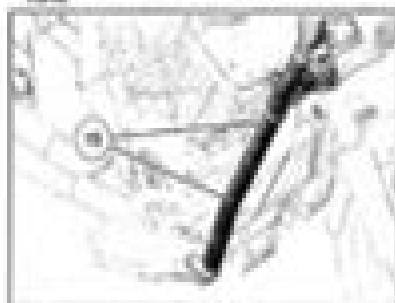


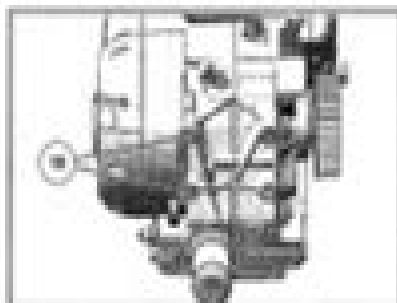
- Rotate engine carefully and remove from right side of frame.

**NOTE**

Push right side of frame (2) while removing engine.

NOTE

Mount engine securely to an engine stand to prevent damage and for ease of disassembly. Use spacers as needed for the stand you are using. Fuel lines will be required, and the fuel will continue to run.

**IMPORTANT**

Before fuel can be collected in and around engine cavity, a fuel filter is required. Clean cavity and surrounding area with compressed air before removing system. If removed, engine must be rotated properly to the fuel rail (aligned to ensure proper spray pattern). See Fuel Rail Installation, page 5.27.

PREPARATION

Refer to Engine Mounting, page 5.2 (Suspension Mount Plate (Spider Bracket) - Rear Frame, page 5.4 for torque values and assembly views.

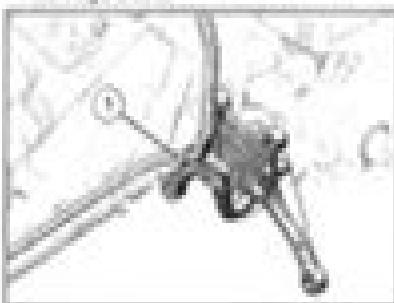
CAUTION

Average for customers when installing engine. The engine must be held securely to prevent damage to engine, frame, wiring, or hoses. The engine is very heavy and could cause severe personal injury if not handled properly. Be sure engine is properly supported before proceeding.

IMPORTANT

Be sure alignment down pins are in place on frame, frame rails and suspension bracket.

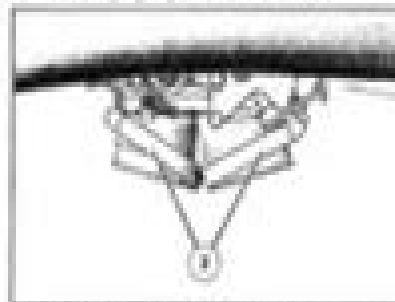
1. Clean mating surfaces of frame, suspension bracket, and engine crankcase. Remove down pins.
2. Be sure rearward frame (2) is raised below frame and steering knuckle.



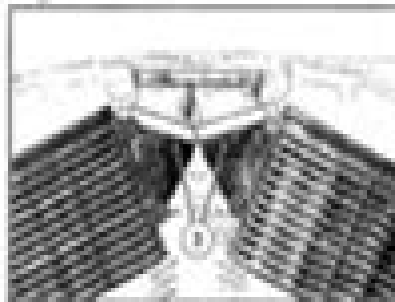
3. Push rear wheel 1 frame off the bench to increase clearance of engine to frame tubes and bracket.

ENGINE REMOVAL / INSTALLATION

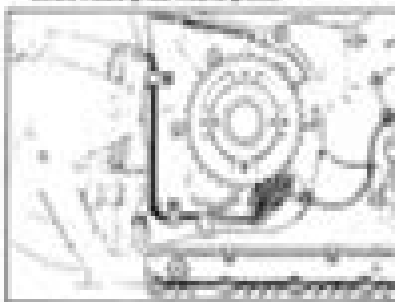
4. Place clamps (2) in position on frame rails.



5. Slide and rotate engine into frame and position engine to center of frame. Adjust height of engine as needed to align rear mounts and down pins.
6. Raise engine and start intake hose on intake ports (3).

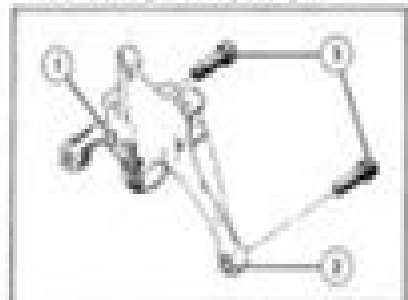


7. Slide engine back into down pins and adjust engine height as needed to align the pins and fully seat the intake hose on intake ports.
8. Be sure all wiring and hoses are properly routed before installing rear mounting bolts.



9. Loosely install all suspension rear engine mounting bolts in frame (2 left side) and upper bracket (down off and right).

10. Carefully and slowly slide engine back into down pins using the left side rear frame bolts (1 & 2) and the lower bolts (3) on the suspension plate.



11. Tighten bolts (2) evenly with engine in down pin against frame and suspension plate bracket. Do not torque fully at this time.

CAUTION

Be sure engine is aligned at the proper height and angle with the down pins. DO NOT force engine alignment using the mounting bolts, or the suspension bracket and down pins may be damaged. Adjust engine height and angle continuously as required while sliding up the bolts.

12. Loosely install all bolts in the suspension down on Engine Mounting, page 5.2 (removing and replacing the down pins to access the right side bolts as in removal process (refer to Chapter 13 for rear suspension feature layout).

13. Install starter motor (if customer has disconnected the starter motor should be torqued to the crankcase during engine assembly).

14. Long bolt is installed in bottom hole (6x10) and shorter bolt (6x10) in top hole.

TORQUE

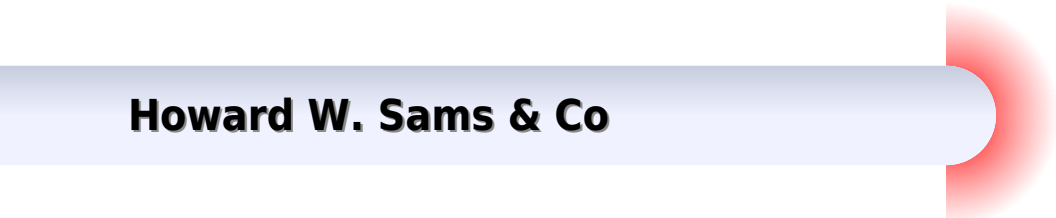
Torque frame to 15 ft-lbs down to 22 ft-lbs

15. Install fuel rail supports Assembly view - Fuelings, Lower (Engine, Harrow, Jackpot, High-Rail), page 5.5.

16. Be sure steel bolts are seated properly to tighten fuel intake ports. Torque clamps to spec.

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Howard W. Sams & Co



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