

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

## NOTE

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

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



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

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

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