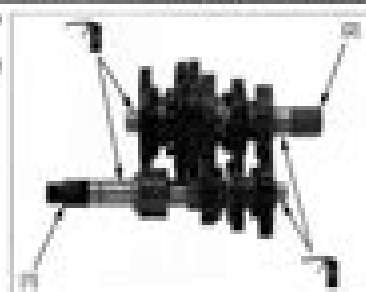


Check the gears for freedom of movement or rotation on the shaft.

Apply engine oil to the journals of the mainshaft (1) and countershaft (2).  
Engage the mainshaft and countershaft gears.



Position the cork weights so that they do not interfere with the mainshaft (1).

Install the mainshaft, countershaft (2) and washer (3) assemblies as a set into the rear crankcase.



Apply engine oil to the sliding surface of the reverse idler gear roller (1).

Install the thrust washer (2), reverse idler gear (3), roller and shaft (4).



Each shift fork has an identification mark, "BR" (1) for the rear fork, "C" (2) for the center fork and "FR" (3) for the front fork.



Apply engine oil to the shift drum grooves for the gate pin and install the shift drum (1).

Install each shift fork (2) into the gear slider grooves and shift drum grooves with their identification marks facing up (front crankcase side).

- rear shift fork into the 1st gear
- center shift fork into the C2 gear
- front shift fork into the C3/reverse gear slider

Apply engine oil to the fork shaft (3).  
Install the fork shaft through the shift forks and into the crankcase.

Assemble the crankcase halves (page 14-18).

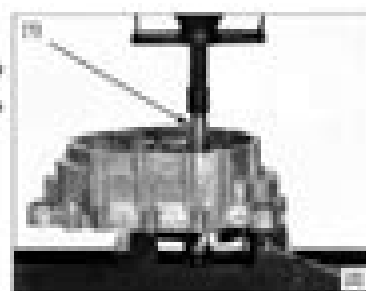


## CRANKSHAFT/BALANCER

### REMOVAL

Separate the crankcase halves (page 14-18).  
Remove the transmission (page 14-7).

**Be careful not to damage the crankcase mating surface and crankshaft assembly.**  
Remove the crankshaft (1) and balancer (2) from the rear crankcase using a hydraulic press.  
**Be sure to hold the crankshaft and balancer while pressing them out of the crankcase.**



Remove the rear crankshaft bearing (1) using the bearing puller (2) with a suitable protector (3) and dislodge the bearing.

**TOOL:**  
Bearing Separator Set

87521-0016000 or equivalent  
commercially  
available in U.S.A.

### NOTES

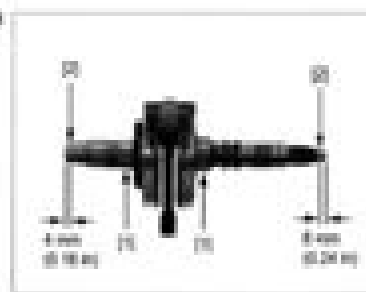
- Always replace the rear crankshaft bearing with a new one when the crankshaft is removed.



### INSPECTION

Set the crankshaft in a stand or vise (1) and measure the runout using a dial indicator (2).

**SERVICE LIMIT: 0.15 mm (0.006 in)**



# 2015 Pioneer Manual

**Shasha Hu**



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