ENGINE ASSEMBLY

REMOVAL OF ENGINE - GEARBOX REAR AXLE UNIT

- Disconnect the air-cleaner hose from *he carburetor.
- Disconnect the throttle choke and startermotor cables.
- Disconnect the flexible brake hoses from the rear three-way union.
- Remove the bolts of the rear shockabsorbers.
- Disconnect the speedometer cable, fuel hose and spark-plug cables.
- Remove the rear cover.
- Remove the muffler.
- Disconnect the brake and clutch controlrables.
- Disconnect the gearshift, 10,550 P from the cearshift 10,549 P.
- Disconnect the ignition and startermotor wires.
- Unscrew the bolts assembling the gearbox/ engine to the carrier.

REMOVAL OF GEARBOX/ENGINE ASSEMBLY

- Disconnect the air cleaner hose, throttle choke - startermotor - and sparkplug cables, ignition wires and muffler.
- Remove the cover 12387 P from the gearboxcarrier.
- Remove the rearcover.
- Lift up the engine assembly by its hangingpoint.
- Unscrew the bolts and the two stud nuts assembling the engine to the gearbox.
- Take care during the engine removal, that the engine is not leaning upon the gearbox mainshaft 12.379.

ENGINE DISASSEMBLY

- Place the engine on the support (Tool N° 1102 fig. 5).
- Remove the spark-plugs.
- Remove the ignition system cover and sparking distribution carrier.
- Remove the belt.
- Remove the centrifugal advance.
- Remove the carburetor.
- Remove the crankshaft-pulley by means of tool N° 1138.
- Remove the generator.
- Unscrew the nuts securing the fan-housing to the cylinder-assembly, remove the plate assembling fan-housing and exhaust manifold.
- Remove the fan-housing.
- Remove the clutch and the flywheel by means of tool N* 1118 - Fig. 6.
- Remove the cylinder-heads.
- Remove the cylinders and mark them.
- Remove the piston pin retainers Z. 7361.
- Remove the piston pin by means of tall 1115.
- The pistons are to be marked as they are to be re-installed in the same cylinder.
- Remove the upper-part of the crankcase by means of tool N° 1111.
- Remove the crankshaft.
- DURING ALL THESE OPERATIONS CARE MUST BE TAKEN THAT THE JOINING SUR-FACES BETWEEN UPPER CRANKCASE/CY-LINDERS AND BETWEEN THE TWO CRANK-CASE PARTS ARE NOT INJURED.

ENGINE ASSEMBLY

For assembling execute the reverse of the disassembly operations.

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M Tight

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Table of Contents Vespa 400 Workshop Service Repair Manual

- 1. Understanding the eBook Vespa 400 Workshop Service Repair Manual
 - The Rise of Digital Reading Vespa 400 Workshop Service Repair Manual
 - o Advantages of eBooks Over Traditional Books
- 2. Identifying Vespa 400 Workshop Service Repair Manual
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
- 3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - $\circ\,$ Features to Look for in an Vespa 400 Workshop Service Repair Manual
 - User-Friendly Interface
- 4. Exploring eBook Recommendations from Vespa 400 Workshop Service Repair Manual
 - Personalized Recommendations
 - $\circ\,$ Vespa 400 Workshop Service Repair Manual User Reviews and Ratings
 - Vespa 400 Workshop Service Repair Manual and Bestseller Lists
- 5. Accessing Vespa 400 Workshop Service Repair Manual Free and Paid eBooks
 - Vespa 400 Workshop Service Repair Manual Public Domain eBooks
 - Vespa 400 Workshop Service Repair Manual eBook Subscription Services

- Vespa 400 Workshop Service Repair Manual Budget-Friendly Options
- 6. Navigating Vespa 400 Workshop Service Repair Manual eBook Formats
 - o ePub, PDF, MOBI, and More
 - Vespa 400 Workshop Service Repair Manual Compatibility with Devices
 - ∘ Vespa 400 Workshop Service Repair Manual Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Vespa 400 Workshop Service Repair Manual
 - Highlighting and Note-Taking Vespa 400 Workshop Service Repair Manual
 - Interactive Elements Vespa 400 Workshop Service Repair Manual
- 8. Staying Engaged with Vespa 400 Workshop Service Repair Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Vespa 400 Workshop Service Repair Manual
- 9. Balancing eBooks and Physical Books Vespa 400 Workshop Service Repair Manual
 - Benefits of a Digital Library
 - o Creating a Diverse Reading Collection Vespa 400 Workshop Service Repair Manual
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Vespa 400 Workshop Service Repair Manual
 - Setting Reading Goals Vespa 400 Workshop Service Repair Manual
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Vespa 400 Workshop Service Repair Manual
 - Fact-Checking eBook Content of Vespa 400 Workshop Service Repair Manual
 - Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
- 14. Embracing eBook Trends

- Integration of Multimedia Elements
- Interactive and Gamified eBooks

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