

Technical Bulletin

MOTORCYCLE SAE 2483 no. M83-005

SR/TT/XT250

Crankshaft oil-Gallery Modification

The action of the crankshaft on some affected models may act as a centrifugal pump, drawing too much oil; this means there is less oil available for delivery to the top end. Installation of a special roll pin in the crankshaft will correct this. The crankshaft oil gallery will be partially restricted; reducing the drawing action of the crankshaft so more oil will be available for delivery to the top end. **This modification will not adversely affect the lubrication of the crankshaft; the crankshaft will be adequately lubricated.**

Dealers are required to install the roll pin in oil action affected models in their inventories. When customer owned machines come in for service, install a roll pin in them. Warranty will cover this procedure in oil affected models.

Affected Models

SR250G ALL	TT250J All
SR250H All	XT250G ALL
SR250TH ALL	XT250H ALL
SR250U All	XT250J ALL
TT250G ALL	XT250R ALL
TT250H ALL	

Procedure

1. Inspect the engine serial number to ensure that this modification has yet to be performed. A punch mark over the serial number dash indicated that the procedure has already been done.

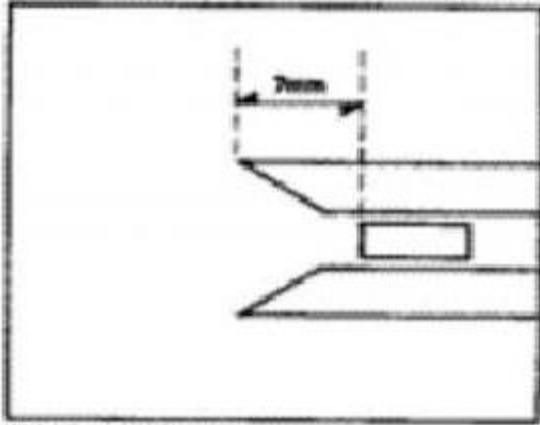


ILLUSTRATION 1

2. Drain the oil from the motorcycle, remove the kick starter and remove the right-hand side cover.
3. With a properly sized punch, drive the roll pin into the crankshaft oil gallery as shown in illustration 1. The pin should be 7mm from the end of the crankshaft.
4. Inspect the crankshaft oil seal in the right-hand crankcase cover: see illustration 2. If the seal is work, damaged, or cooked in its place, replace or reposition it. **This oil seal much be inspected.** The engine will be severely damaged if the seal is worn, damaged or improperly positioned.

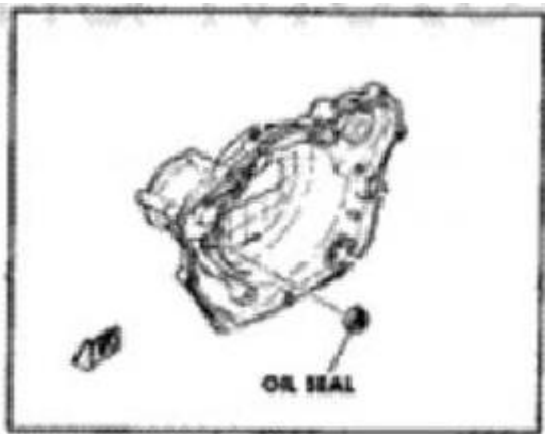


ILLUSTRATION 2

5. reinstalled the crankcase cover and kick starter. Use a new crank case cover gasket.
6. Add 1300cc of oil. Start the machine and check the oil level, add oil as necessary.
7. Make a punch mark above the dash in the serial number to indicate that this modification has been performed on the unit. See illustration 3.

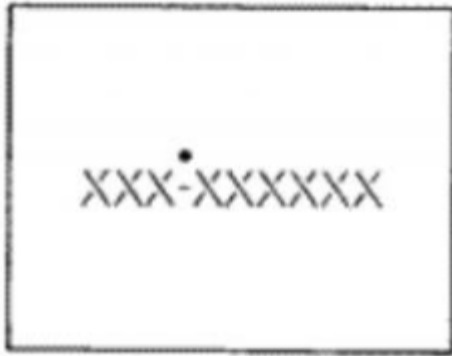


ILLUSTRATION 3

8. Remove the screw and inspect the oil gallery shown in illustration 4. Make sure there are no particles blocking the gallery.

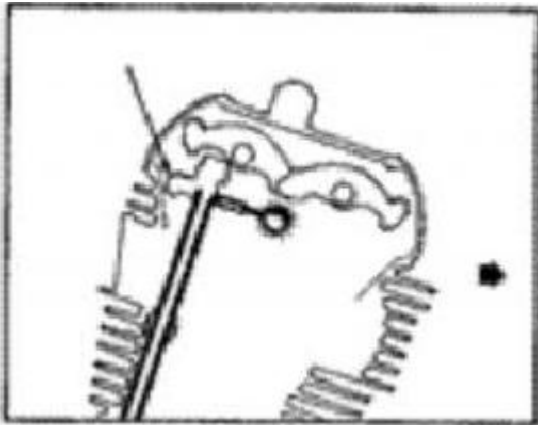


ILLUSTRATION 4

Parts Information:

Roll Pin 91690-40018-00

Oil Seal (S7-14-25-5.5-1-Hs) 93101-14092-00

Gasket, Crcs Cvr 2 3Y1-15461-10-00

TECHNICAL BULLETIN

MOTORCYCLE

DAY 2483

NO. M63-005

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SR/TT/XT250

CRANKSHAFT OIL-GALLERY MODIFICATION

The action of the crankshaft on some affected models may act as a centrifugal pump, drawing too much oil; this means there is less oil available for delivery to the top end. Installation of a special roll pin in the crankshaft will correct this. The crankshaft oil gallery will be partially restricted, reducing the drawing action of the crankshaft so more oil will be available for delivery to the top end. **This modification will not adversely affect the lubrication of the crankshaft; the crankshaft will be adequately lubricated.**

Dealers are requested to install the roll pin in all unused affected models in their inventories. When customer-owned machines come in for service, install a roll pin in them. Warranty will cover this procedure in all affected models.

AFFECTED MODELS

SR250G: All	TT250G: All	XT250G: All
SR250H: All	TT250H: All	XT250H: All
SR250J: All	TT250J: All	XT250J: All
SR250K: All	TT250K: All	XT250K: All

PROCEDURE

1. Inspect the engine serial number to ensure that this modification has yet to be performed; a punch mark over the serial number dash indicates that the procedure has already been done.
2. Drain the oil from the motorcycle, remove the kick starter, and remove the right-hand side cover.
3. With a properly sized punch, drive the roll pin into the crankshaft oil gallery as shown in Illustration 1. The pin should be 7mm from the end of the crankshaft.

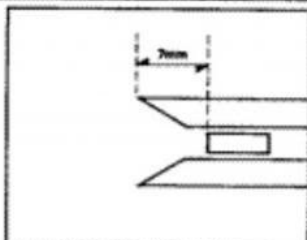


ILLUSTRATION 1

4. Inspect the crankshaft oil seal in the right-hand crankcase cover; see Illustration 2. If the seal is worn, damaged, or cocked in its boss, replace or reposition it. **This oil seal must be inspected; the engine will be severely damaged if it is worn, damaged, or improperly positioned.**

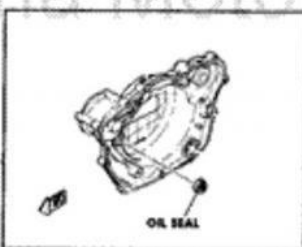


ILLUSTRATION 2

5. Reinstall the crankcase cover and kick starter; use a new crankcase cover gasket.

6. Add 1300cc of oil, start the machine, and check the oil level. Add oil as necessary.

7. Make a punch mark above the dash in the engine serial number to indicate that this modification has been performed on the unit; see Illustration 3.

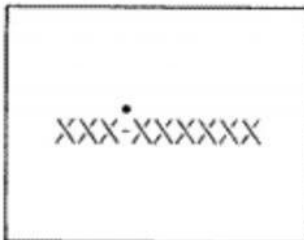


ILLUSTRATION 3

PARTS INFORMATION

PART NUMBER	DESCRIPTION	REMARKS	DEALER COST
91509-60029-00	Roll Pin		
93151-14092-00	Oil Seal		
316-15461-00-00	Crankcase Cover Gasket	Fits SR250	
311-15461-00-00	Crankcase Cover Gasket	Fits TT250 and XT250	

WARRANTY

The warranty labor allowance for this procedure is 0.5 hours. The problem code is 90EH.

To receive credit, follow standard service-per-bulletin procedures.

90EH
90EH refers to problem code listed
 elsewhere in the bulletin.

0.5
HOURS

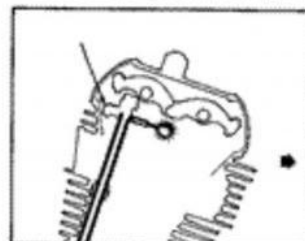


ILLUSTRATION 4