

# ENGINE ASSEMBLY

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## REMOVAL OF ENGINE - GEARBOX REAR AXLE UNIT

- Disconnect the air-cleaner hose from the 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 control-cables.
- Disconnect the gearshift, 10.550 P from the gearshift 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 rearcovers.
- Lift up the engine assembly by its hanging-point.
- 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 main-shaft 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 toll 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 SURFACES BETWEEN UPPER CRANKCASE/CYLINDERS AND BETWEEN THE TWO CRANKCASE PARTS ARE NOT INJURED.

## ENGINE ASSEMBLY

For assembling execute the reverse of the disassembly operations.

# Vespa 400 Workshop Service Repair Manual

**N Noddings**



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