



MCCULLOCH

ENGINE MOUNTING - R-1 KART

The following instructions cover the installation of McCulloch kart engines on the R-1 Kart.

1. Mount the engine bracket on the shock mount assembly with four 5/16-24 special screws (P/N 102549), four 0.31-inch plain washers (P/N 13550), twelve 15/16-inch (O.D.) plain washers (P/N 13551), four 5/16-24 jam nuts (P/N 101096), and four 5/16-24 hex nuts (P/N 100682). See Figure 1 below.

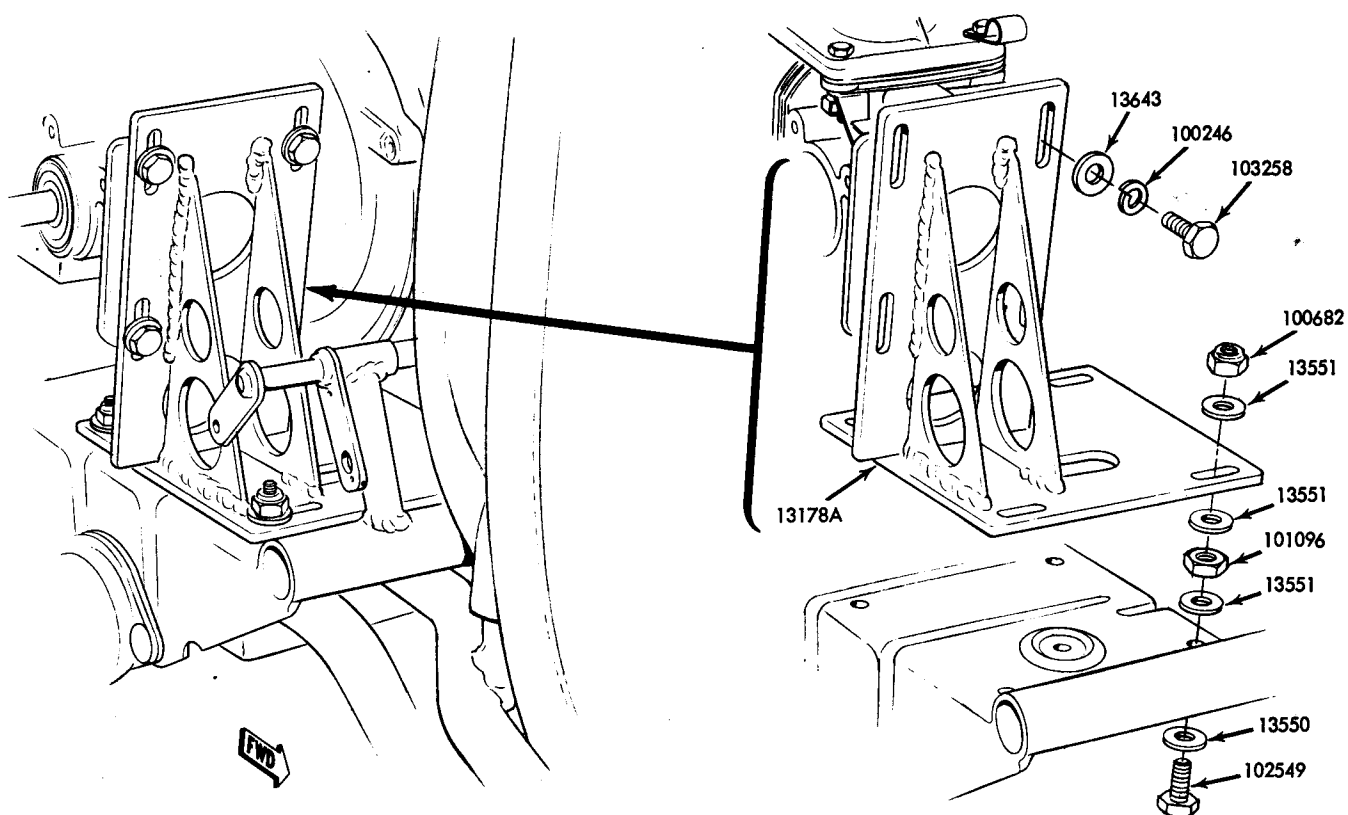
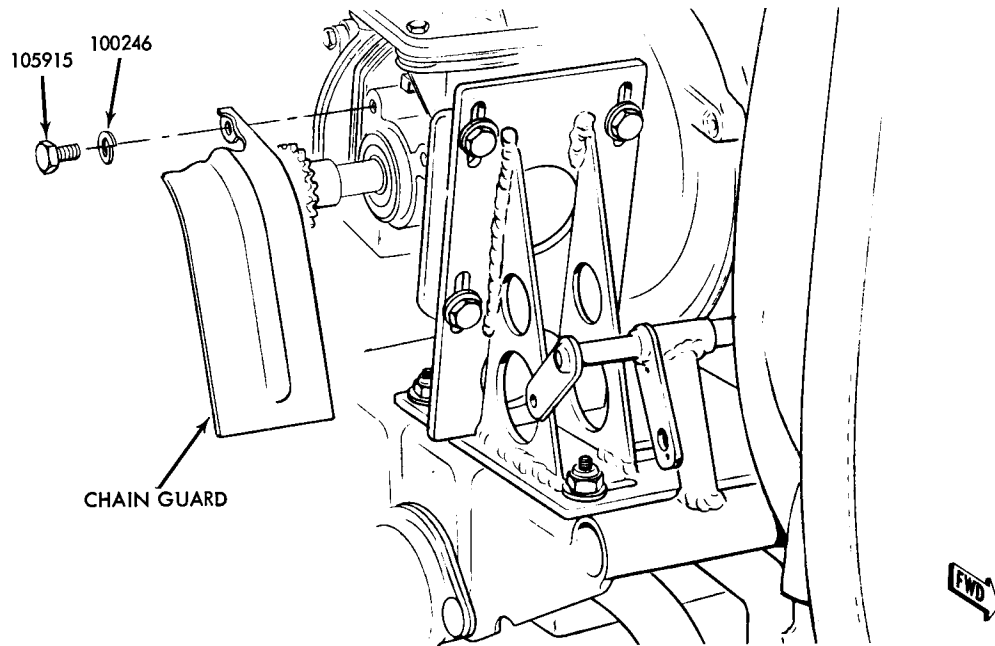


FIGURE 1

2. Remove the four crankcase bottom cover screws from your engine. Do not remove the cover.
3. Place the engine on the mounting bracket and install four 1/4-20 x 1-1/8-inch long screws, four plain washers, and four lockwashers (see Figure 1). The lockwashers go between the plain washers and the heads of the screws.
4. Mount the chain guard on the engine crankcase and install two 1/4-20 x 1/2-inch long screws (P/N 105915) and two lockwashers (P/N 100246). See Figure 2.

FIGURE 2



5. Remove the locknut from the engine crankshaft and install the 10-tooth Sprocket (P/N 48637) on the crankshaft. Make sure that the 100199 Woodruff key is in place in the crankshaft keyway before installing the Sprocket. Reinstall the locknut.
6. Align the engine Sprocket with the 80-tooth axle Sprocket (see Figure 3). It may be necessary to loosen the four nuts securing the mounting bracket and to move the bracket to the right or left (whichever direction is necessary) until the Sprockets lie in the same plane.

Place the Drive Chain over the Sprocket teeth and secure the chain with the Master Link (P/N 13325).

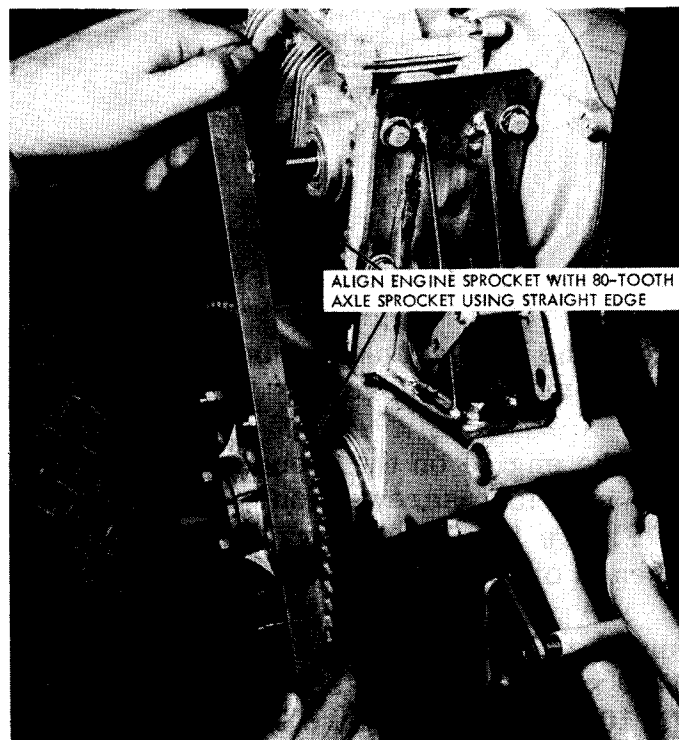


FIGURE 3