



CUSTOM GEARING AND MACHINING
WORLD'S LARGEST MANUFACTURER OF ATVs

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#40-31 SPECIAL INSERT KIT TAURUS TRANSMISSION

PARTS INCLUDED

Qty.	Part No.	Description
1	40-28	Special Insert
6	473-13	1/4-20x5/8" Socket Head Cap Screw

TOOLS REQUIRED

#7 or 13/64 dia. Drill Bit
Drill
1/4-20 Tap
3/16" Allan Wrench
Scriber

Silicone Sealant (or similar
oil resistant sealant)
Centre Punch
Hammer

INSTRUCTIONS

1. Remove transmission from vehicle.
2. Remove the old #40-27 insert from the transmission. If it doesn't come out easily, screw the pivot bolt into it and pull.
3. Place new Special Insert #40-28 into insert location hole in the transmission.
4. Mark bolt holes with scriber.
5. Remove insert, centre punch and drill 6 holes .60 inches deep into transmission housing.

CAUTION ! Holes must be drilled straight and accurately. Do not drill deeper than specified otherwise damage to an inner bearing will occur.

6. Tap the 6 holes 1/4-20.
 7. Remove all metal particles.
 8. Apply silicone around insert hole.
 9. Install insert, 6 screws and tighten to 70 in./lbs. torque.
 10. Reinstall transmission.
 11. Reinstall main pivot bearing bolt and tighten to 140 ft/lbs torque
- NOTE: Tighten main pivot bearing bolt when vehicle is resting on its wheels.