

JEFFREY'S 0274 457451

Specifications

(RL250 SPECIFICATIONS SHOWN IN BRACKETS WHERE DIFFERENT FROM RL325)

DIMENSIONS AND WEIGHT

OVERALL LENGTH	2030mm = 80"
OVERALL WIDTH	838mm = 33"
OVERALL HEIGHT	1120mm = 44"
SEAT HEIGHT	775mm = 30.5"
WHEELBASE	132mm = 52"
GROUND CLEARANCE	330mm = 13"
FRONT WHEEL	2.75" x 21"
REAR WHEEL	4.00 x 18"
DRY WEIGHT	91.3kg = 201lbs

ENGINE

TYPE	AIR COOLED, SINGLE CYLINDER, 2 STROKE
CYLINDER TYPE	SLEEVED ALUMINIUM
BORE & STROKE	80mm x 64mm (70mm x 64mm)
CAPACITY	322cc (246cc)
COMPRESSION RATIO (corrected)	7.5 : 1 (6.7 : 1)
INDUCTION SYSTEM	CARBURETTOR : REED VALVE - PISTON PORT.
POWER OUTPUT	23B.H.P. @ 6500 r.p.m. (19B.H.P. @ 6000 r.p.m.)

FUEL SYSTEM

CARBURETTOR	28mm MIKUNI VM28 SH?
	Needle No. - 5CN6
	Slide No. - 1.5
	Main Jet - 120
	Needle Jet - 0.4
	Pilot Jet - 20 (27.5)

LUBRICATION

AIR CLEANER	OILED FOAM
ENGINE	4 star PETROL/OIL PREMIX 20:1
GEARBOX/CLUTCH	20-50 MULTIGRADE (800cc approx. level plug)

IGNITION SYSTEM

SPARK PLUG	NIPPONDENSO W22ES or NGK B7ES
GENERATOR	FLYWHEEL MAGNETO TRANSISTORISED C.D.I.
IGNITION TIMING	(SEE TEXT)

TRANSMISSION

PRIMARY DRIVE	GEAR
CLUTCH	WET MULTI-PLATE
GEARBOX	5 SPEED CONSTANT MESH
GEARCHANGE	LEFT FOOT OPERATED GEAR LEVER
FINAL DRIVE	5/8 x 1/4 or 520 HEAVY DUTY ROLLER CHAIN
	3.25 3.72 3.30
	12T (11T & 13T AVAILABLE)
	39T, 41T, 43T

SUSPENSION

FRONT	TELESCOPIC:- 7 inches movement
	*AIR ASSISTED:- 15p.s.i.
	*OIL DAMPED:- 195cc SAE 10/15/20
REAR	SWING ARM WITH 5 WAY ADJUSTABLE OIL DAMPED SUSPENSION UNITS. GIVING 4.5 inches rear wheel movement

FRAME

BRONZE WELDED REYNOLDS 531 TUBING. HARD CHROME FINISH

BRAKES

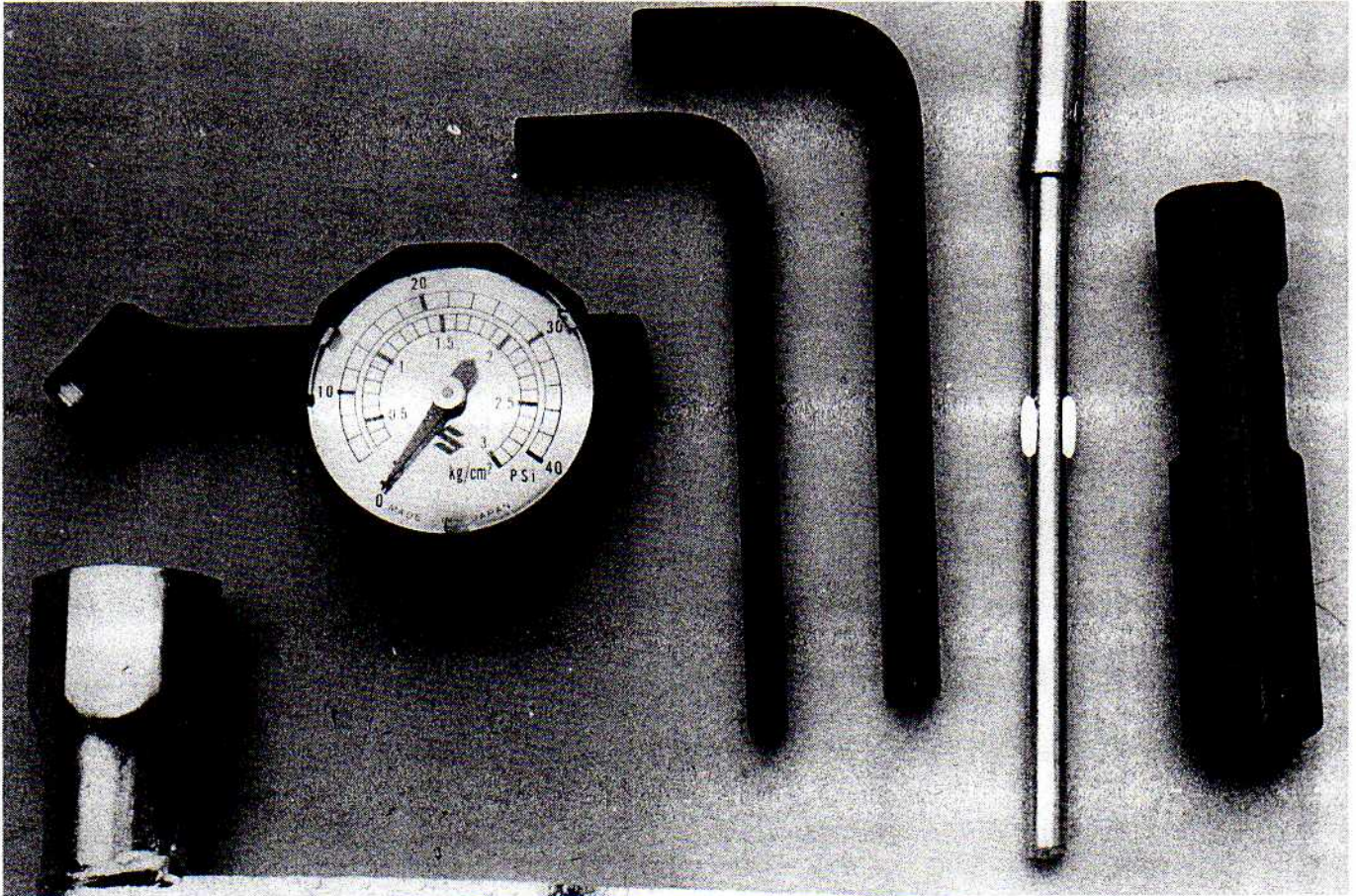
FRONT	RIGHT HAND CABLE OPERATED SINGLE LEADING SHOE
REAR	RIGHT FOOT ROD OPERATED SINGLE LEADING SHOE

LIGHTING

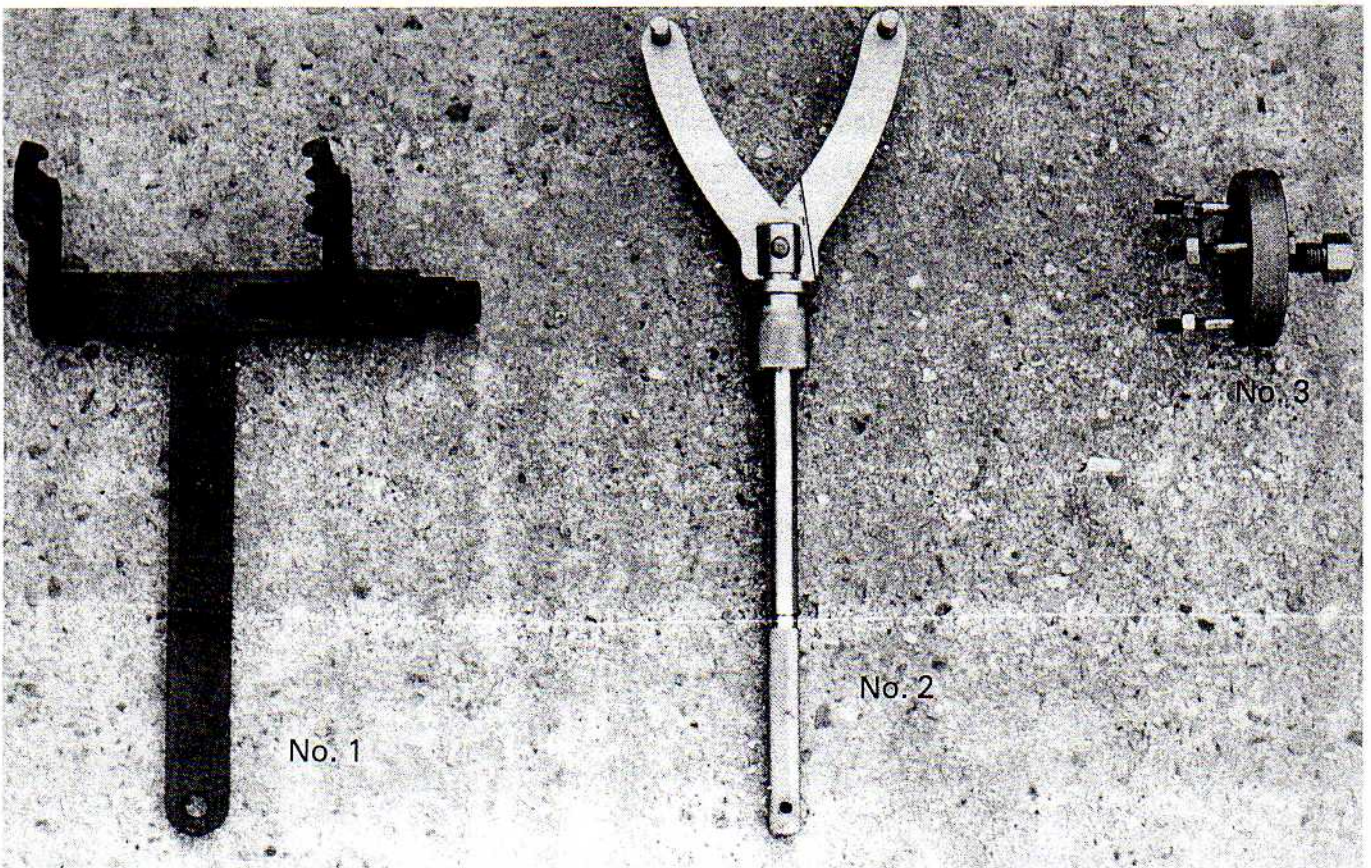
LIGHTING KIT AVAILABLE

BEAMISH MOTORS RESERVE THE RIGHT TO ALTER ANY SPECIFICATION AT ANY TIME

Tool Kit and Special Tools



THE TOOL KIT SUPPLIED WITH THE RL250/325



No. 1

No. 2

No. 3

SPECIAL TOOLS REQUIRED FOR ENGINE STRIPDOWN

Running-in and General Maintenance

**BEAMISH
SUZUKI**

PAGE 3

RUNNING-IN At least 2 hours of easy roadwork before attempting any off-road going will greatly enhance the life and smoothness of the engine. After 100 miles, change the Transmission oil and the front fork oil, check the ignition timing, clean the spark plug and check the gap and check all nuts, bolts and fixings for tightness.

TRANSMISSION OIL Oil change — remove drain plug through hole in sump plate and drain oil into suitable receptacle — Replace drain plug — Remove filler plug and transmission oil level screw from primary drive cover — With bike in upright position slowly pour approximately 800 cc of SAE 20-50 oil down the filler hole until it starts to seep out of the oil level hole — Replace the oil level screw and the filler plug and wipe away any spilt oil.

FRONT FORKS Oil change — **IMPORTANT**, drain and fill one fork leg at a time — Release air from valve in fork top

cap — Drain oil from fork leg by removing drain screw at bottom rear of leg — Replace drain screw — Remove fork top cap and slowly pour 195 cc of selected* weight of oil into fork leg — Replace fork top cap and inflate to 15 p.s.i.** approximately — Repeat for other fork leg.

*The weight of oil used varies, dependent on weight of rider, riding style, type of ground (mud or rocks, etc.), time of year. We suggest that you start at SAE 15 and experiment to suit your personal requirements.

**Air pressure is another variable, requiring personal fine tuning. 15 p.s.i. is the average setting to work from.

CARBURETTOR SETTINGS Standard setting for the Needle on the RL325 is the central notch; on the RL250 the Needle is set on the second notch from the top — Pilot jet screw for both capacity machines is 1 ½-2 ½ turns out and is dependent upon riding style, elevation and ambient temperature. Some jetting changes may be necessary in extreme conditions.

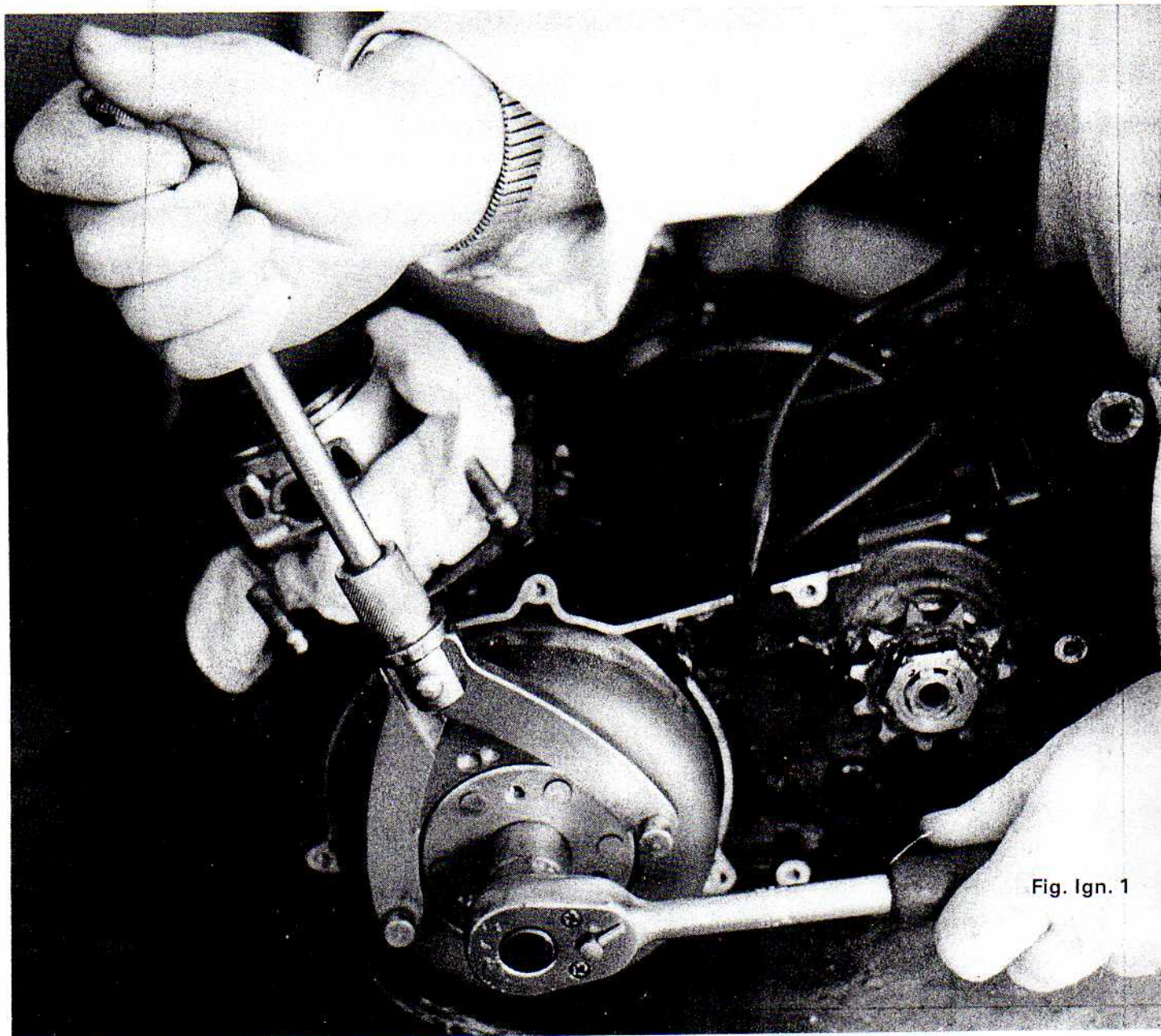


Fig. Ign. 1

AIR CLEANER Remove seat/sidepanel unit by releasing the two DZUS screws on each sidepanel — Remove Air top box — Remove foam air filter element — Clean element in degreasing solvent (Gunk, Jizer, etc.) and wash out with cold water — Leave element to dry naturally, do not wring or place near artificial heat — When dry, soak foam element in SAE 20-50 oil and squeeze, **DO NOT WRING OUT** excess — Replace element, air box top, etc.

IGNITION Remove gear lever, gearbox sprocket cover and magneto cover — Remove flywheel nut (22 mm r-hand thread), holding the flywheel with tool No. 2 as shown in Fig. Ign 1 — Remove lockwasher and washer — Remove flywheel using tool No. 3 as shown in Fig. Ign 2 — The ignition is correctly set when the line on the magneto

stator plate is in line with the mark on the crankcase as shown in Fig. Ign 3 — Reassemble in reverse order (tool No. 3 is not required to fit flywheel. Just ensure correct positioning of flywheel on crankshaft and woodruff key, then fit washer, lockwasher and nut and tighten).

LIGHTING Lighting coils are fitted as standard on the magneto stator plate and lighting equipment fitting instructions are supplied with the lighting kit, which is available through the Beamish Suzuki Dealer Network.

CLUTCH ADJUSTMENT There is no internal clutch adjustment method. The clutch is adjusted simply by the screw adjuster on the clutch cover and for fine adjustment at the handlebar lever.

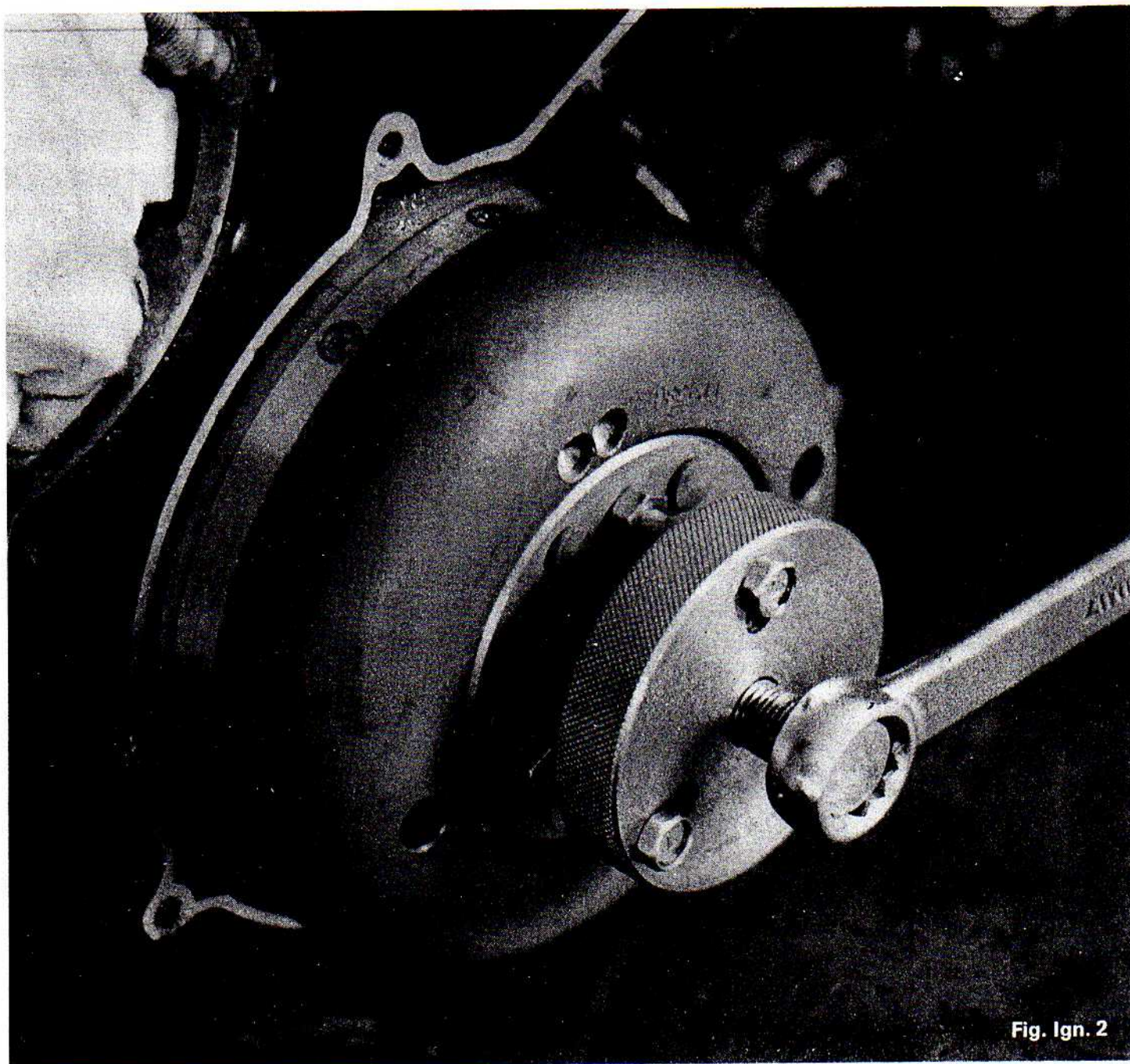


Fig. Ign. 2

TYRE PRESSURES Mud—6-7 p.s.i. front, 3-4 p.s.i.
rear
Rocks—8-9 p.s.i. front, 4-5 p.s.i.
rear

These are average pressures given for guidance purposes.
Personal adjustment is recommended with reference to
these figures.

PERIODIC MAINTENANCE

AFTER EVERY TRIAL Check spark plug gap and
condition — Clean air filter — Check condition of chain,
spokes and tyres — Lubricate chain — Lubricate all lever
pivot points — Tighten all fixings.

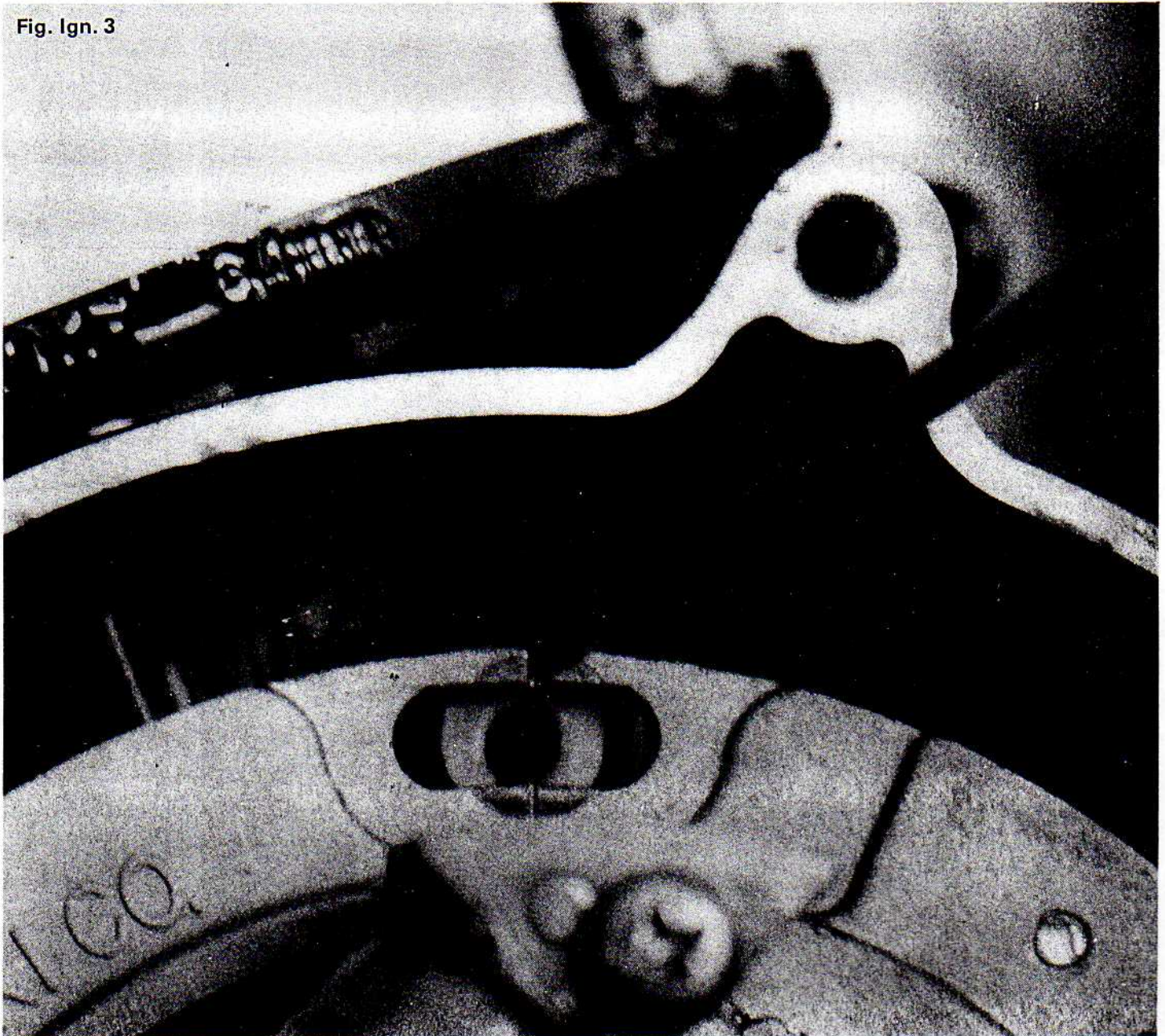
AFTER EVERY 5 TRIALS As above plus — Change
gearbox oil — Change fork oil — Check swing arm silent
bloc bushes for wear — Check chain tensioner rubber for
wear.

AFTER EVERY 10 TRIALS As above plus — Decoke
exhaust, cylinder head, piston crown.

ONCE EVERY FULL COMPETITION YEAR Replace
piston rings — Check bore for wear — Replace reed valve
petals.

Obviously items such as spark plugs, control cables, tyres,
drive chains, levers, etc., must be replaced as and when
required.

Fig. Ign. 3



Engine Strip Down

If you have never stripped an engine down before, then we recommend that you gain the assistance of someone who has.

PROCEED WITH CARE AND PATIENCE

- 1 Clean complete machine thoroughly.
- 2 Drain gearbox oil.
- 3 Remove petrol tank, seat/sidepanel unit.
- 4 Select neutral and remove rear chain.
- 5 Lift machine onto stand or box so that rear wheel is not in contact with ground.
- 6 Remove rear wheel, rear mudguard and rear silencer box.
- 7 Remove airbox by moving rearwards through frame.
- 8 Remove exhaust system — Release spring at exhaust manifold — Undo pinchbolt joining first and second sections — Undo exhaust mounting on top tube — Remove top rear engine bolt — Tap front pipe down and forwards to remove — Remove main exhaust by moving backwards and turning out through rear of frame.
- 9 Remove gearlever, engine sprocket cover and magneto flywheel cover.

TOP END

- 10 Remove cylinder head (6 x 14 mm) and gasket — Turn magneto flywheel so that piston is at T.D.C. and carefully scrape the carbon from the piston crown with blunted scraper — Remove carbon from head in similar fashion.
- 11 Remove carburettor and Reed valve assembly (4 x 10 mm).
- 12 Remove cylinder base nuts (4 x 14 mm) — Move piston to B.D.C. — Carefully lift cylinder off of the base studs and if top end overhaul only is anticipated, the crankcase mouth should be padded with clean rag to prevent any broken piston rings or other undesirable debris from falling into the crankcase — Carefully remove cylinder from piston and inspect both for wear/high spots, etc. — Remove piston rings, inspect and replace if worn.
- 13 Remove gudgeon pin circlips and discard, NEVER RE-USE THESE CIRCLIPS — The gudgeon pin can now

be pushed out, or if tight, support the connecting rod securely and use a drift to tap out the pin carefully — Remove piston and small end bearing.

REMOVAL OF ENGINE

- 14 Disconnect electrics at snap connector at forward end of top tube.
- 15 Disconnect clutch cable from clutch cover.
- 16 Remove front engine bolt and engine plates — Remove engine bolt underneath engine — To remove bottom rear engine mounting stud, remove allen screw and washer from either side of frame and carefully drift out the stud (8 ½ in. long).
- 17 Remove engine from frame.

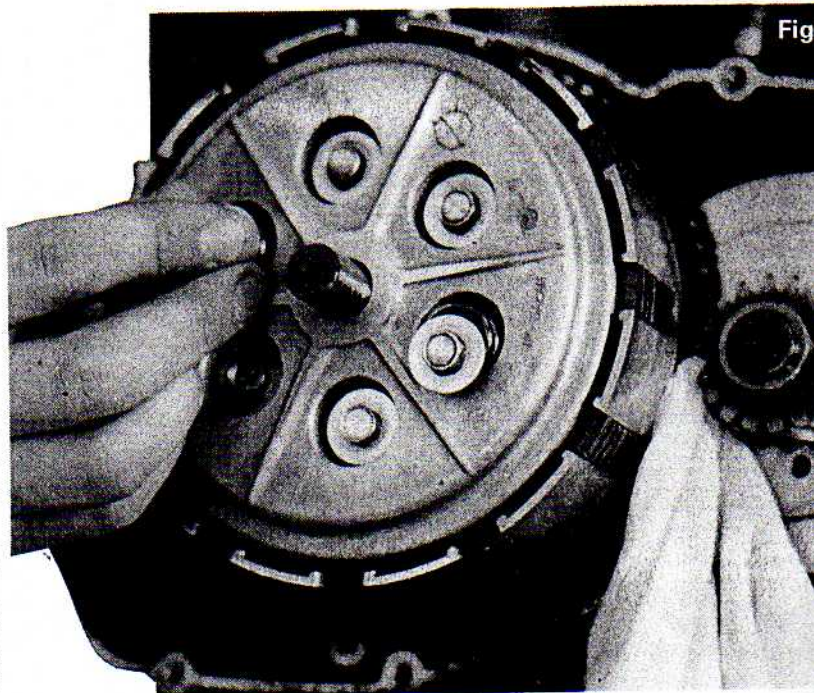


Fig.

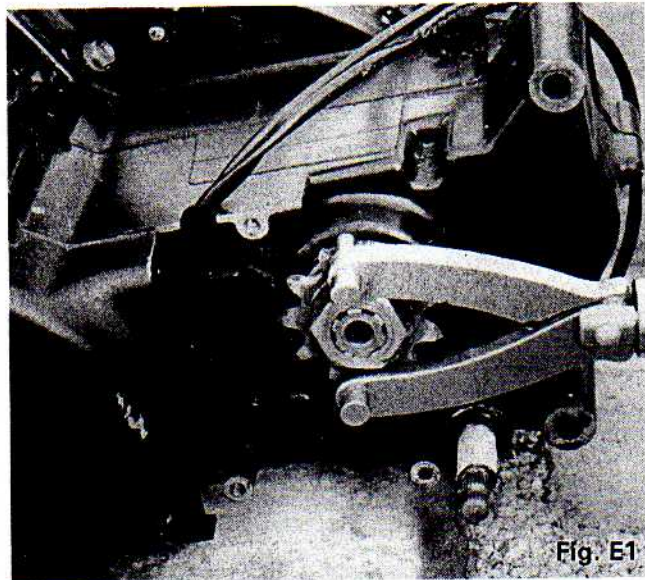


Fig. E1

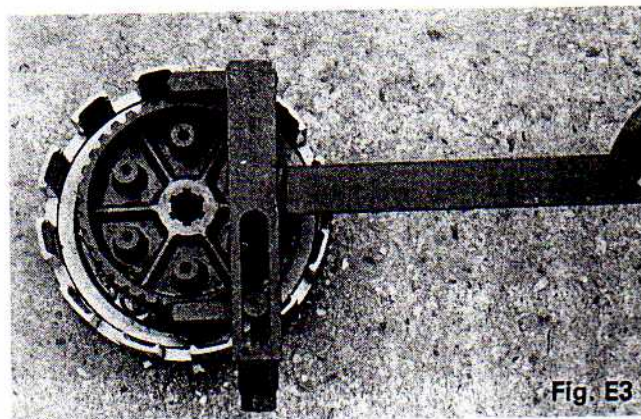
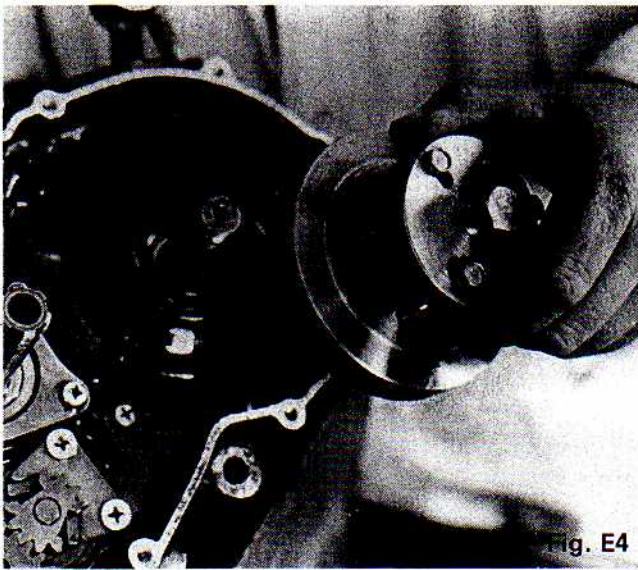


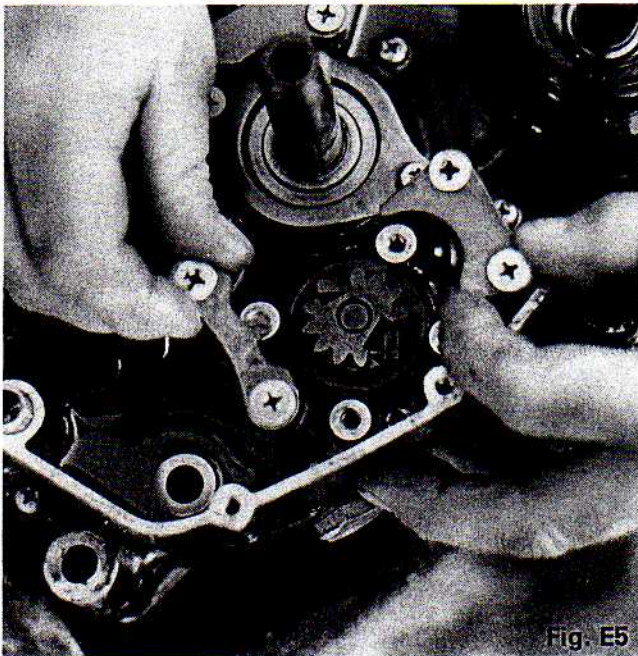
Fig. E3

SPLITTING CRANKCASES

- 18 Using a blunt cold chisel bend back the gearbox sprocket locking washer — Using tool No. 2 as shown in Fig. E1 to hold the sprocket, remove the gearbox sprocket nut (32 mm right-hand thread) — Remove lock washer, sprocket, spacer and rubber "O" ring.
- 19 Remove the ignition flywheel as shown on page 4 for checking ignition timing — Remove magneto stator plate (3 screws) and woodruff key.
- 20 Remove kickstart lever, ten clutch cover screws, clutch cover and gasket.

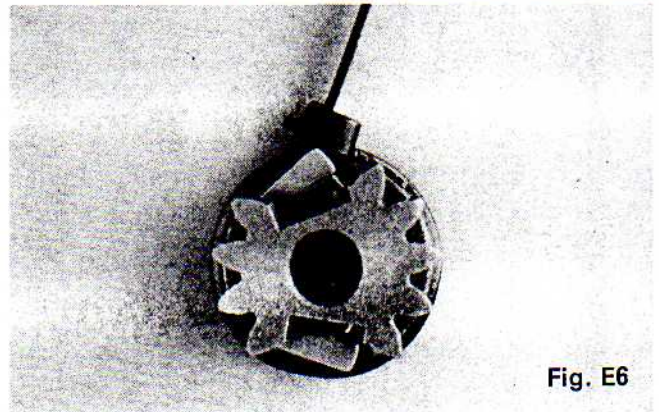


- 21 Remove clutch spring retaining bolts and clutch springs. To lock clutch insert a piece of clean strong rag between the crankshaft gear teeth and the clutch housing teeth as shown in Fig. E2 — Remove crankshaft gear nut (24 mm right-hand thread) — Remove clutch pressure disc, release rack assembly



and clutch plates — Using a blunt cold chisel, bend back and flatten the clutch hub locking washer — Using tool No. 1 as indicated in Fig. E3 lock the clutch hub and remove the clutch hub nut (27 mm right-hand thread) — The complete clutch hub and housing can now be removed — Pay special attention to the position of all washers and bearings.

- 22 Remove primary gear and woodruff key — Using tool No. 3 as shown in Fig. E4 remove the crankshaft auxiliary flywheel — Remove woodruff key.
- 23 Remove kickstart shaft return spring, spring guide and spring holder from the kickstart shaft.
- 24 Remove gearchange shaft by simply withdrawing.
- 25 Remove gearchange cam barrel drive gear assembly retaining plates as shown in Fig. E5 — Now carefully remove the gearchange barrel drive gear assembly, holding in the spring loaded pawls and wiring the



assembly as shown in Fig. E6 — This will avoid losing the component parts of this assembly.

- 26 Remove neutral location plunger/spring/holder from bottom of engine.
- 27 Remove the crankcase screws as indicated in Fig. E7.
- 28 The crankcases can now be split by hitting the crankshaft, gearbox countershaft and the kickstart shaft with a heavy fibre or leather mallet — Be careful not to lose the crankcase locating dowels.



The Beamish Suzuki Production Line in Portslade.

GEARBOX AND CRANK REMOVAL

With the crankcases split and all components resting in the left-hand crankcase, proceed as follows:

- 29 Remove crank by hitting with a fibre or leather mallet.
- 30 Remove selector fork pivot pins — Remove two drive selector forks (left of cam barrel) — Move countershaft selector fork away from cam barrel — Remove cam barrel by levering the cam barrel retaining arm away from the barrel and withdrawing the cam barrel and shim — The countershaft selector fork can now be removed as can both the countershaft and drive shaft assemblies — Carefully note the position of all gears, circlips and spacers when removing them from their shafts.

NB The kickstart shaft assembly can be removed as soon as the cases are split.

- 3 Assemble the gearbox in neutral. The gearbox is in neutral when the indentation on the cam barrel lines up with the gearchange cam barrel neutral location plunger hole in the right-hand crankcase. (See Fig. E8).
- 4 When fitting the crankcases together ensure that the crankshaft, countershaft, kickstart shaft and gearchange cam barrel all line up in their correct positions in the right-hand crankcase before easing together with a leather mallet.

REASSEMBLY

Reassembly of the engine is basically a straight reversal of the dismantling procedure. However, watch out for the following:

- 1 Remove all traces of old gaskets with a blunt scraper — Always use new gaskets.
- 2 Line up the marks on the kickstart shaft and the ratchet and lay the assembly in position.

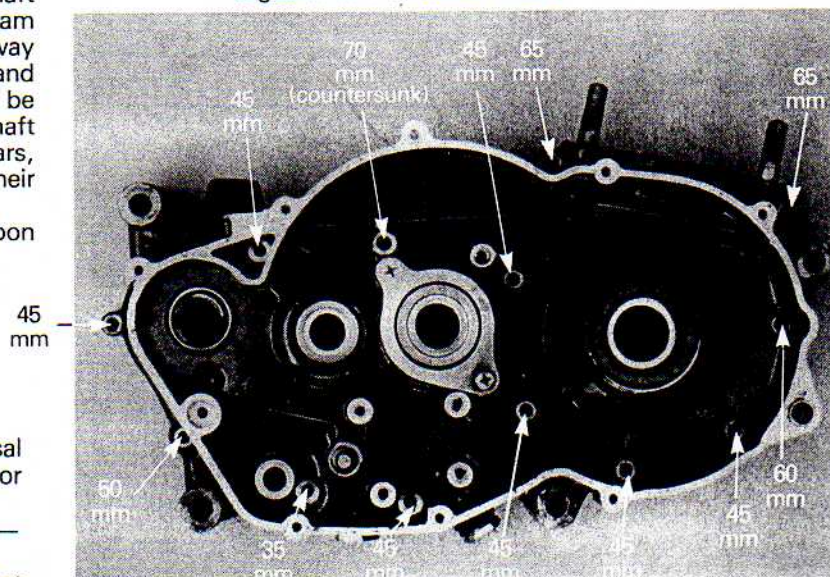


Fig. E7. Showing position of crankcase screws and their lengths.

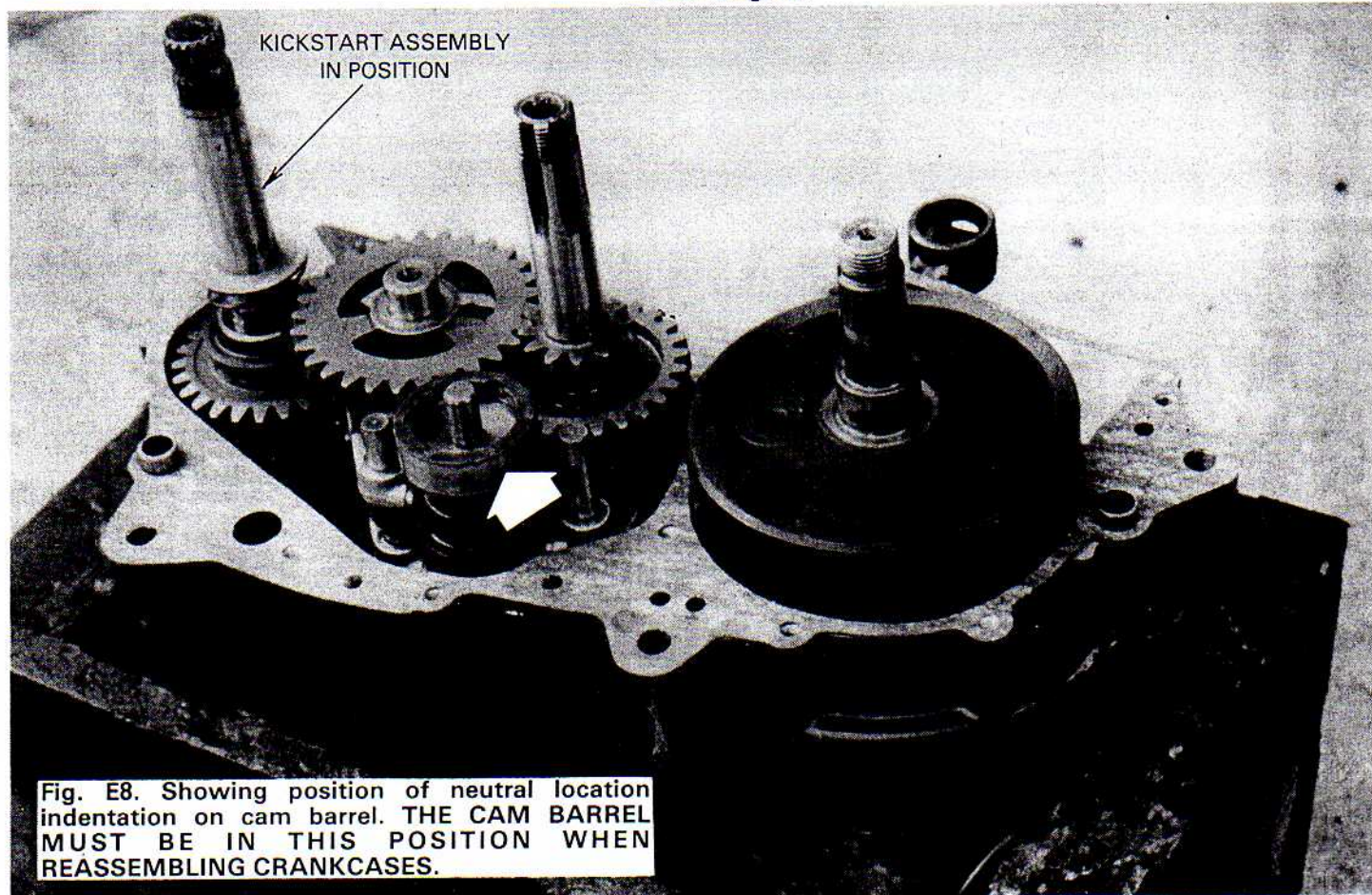
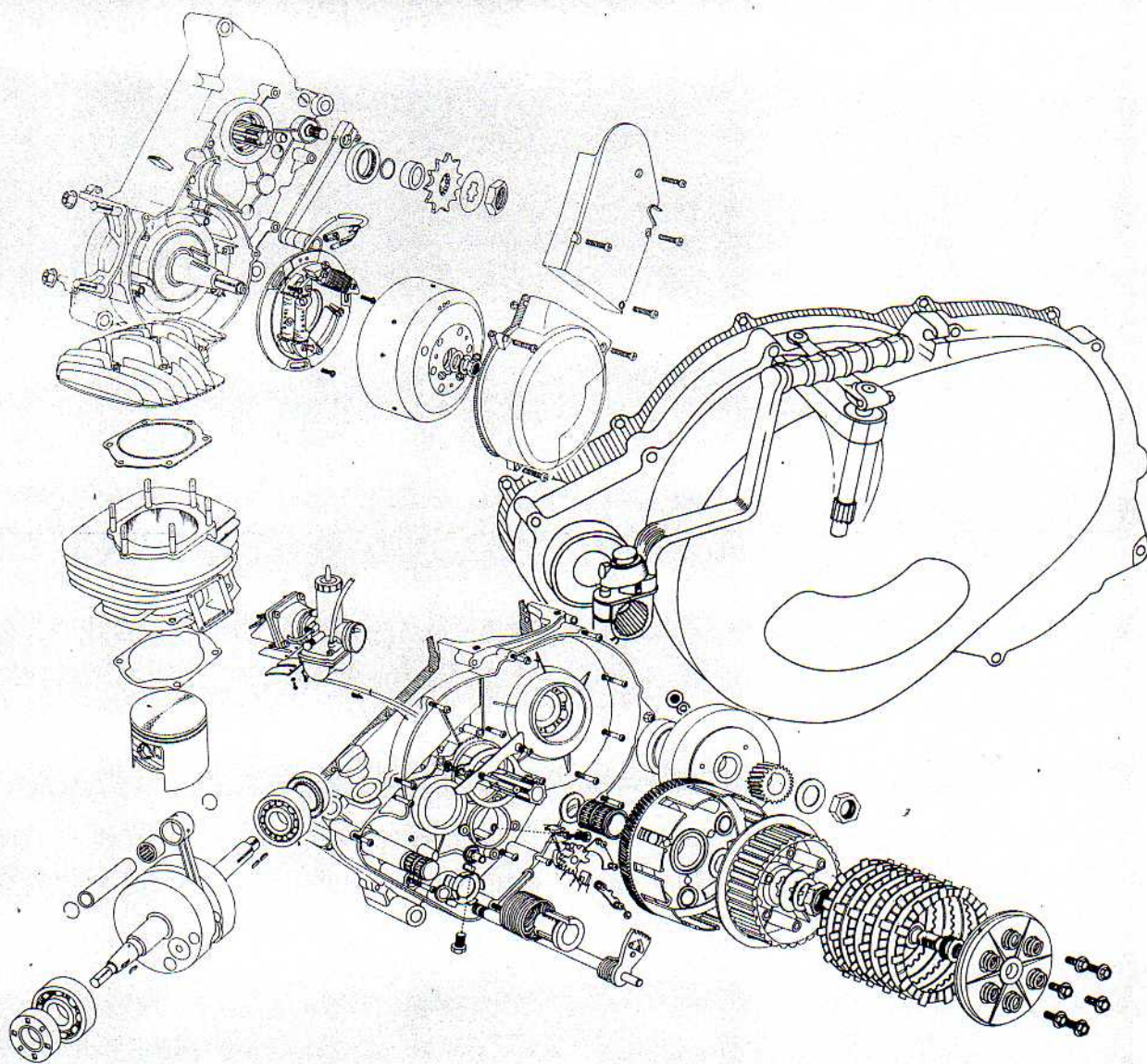


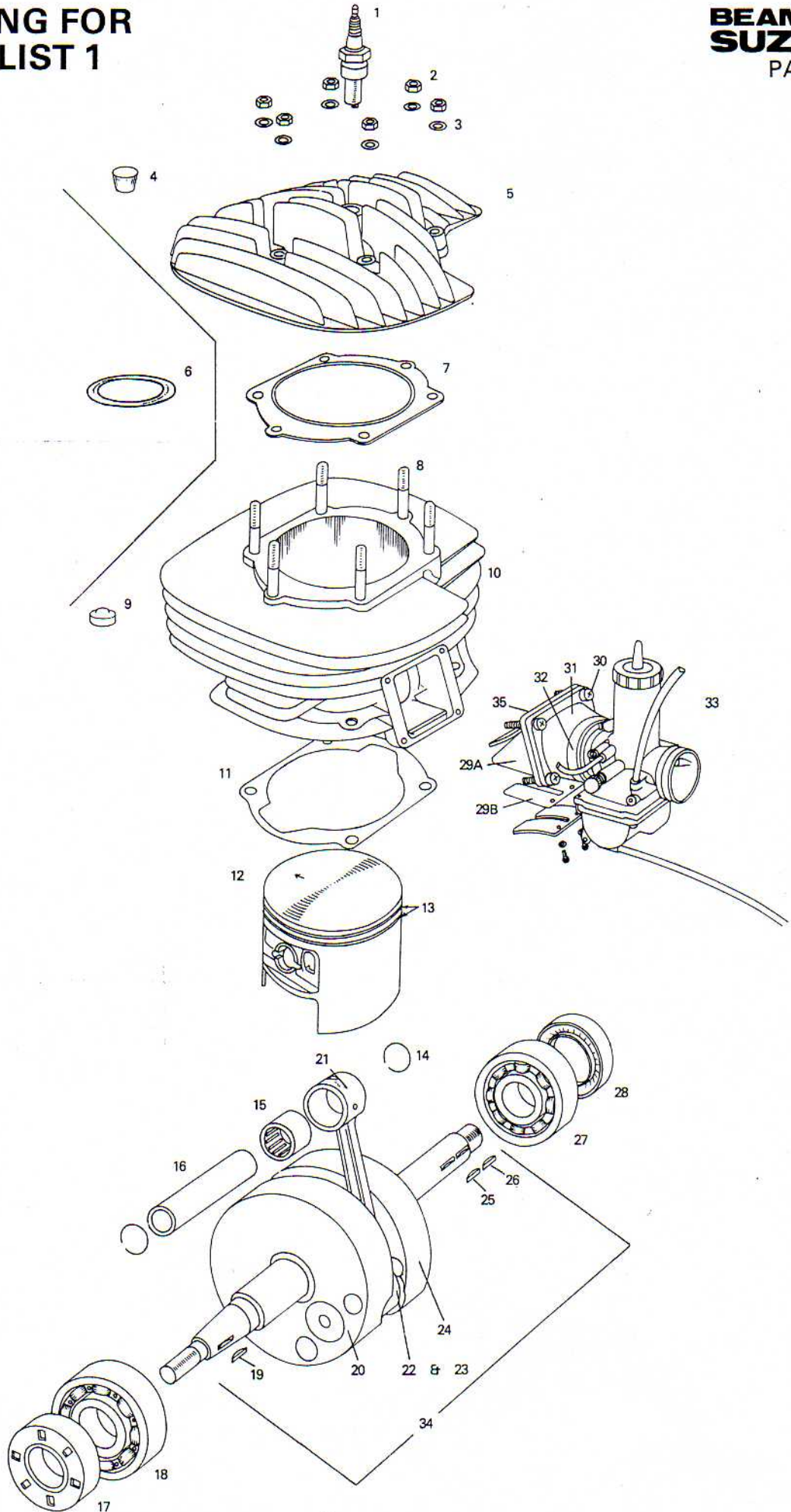
Fig. E8. Showing position of neutral location indentation on cam barrel. THE CAM BARREL MUST BE IN THIS POSITION WHEN REASSEMBLING CRANKCASES.

Exploded Drawings and Spare Parts List

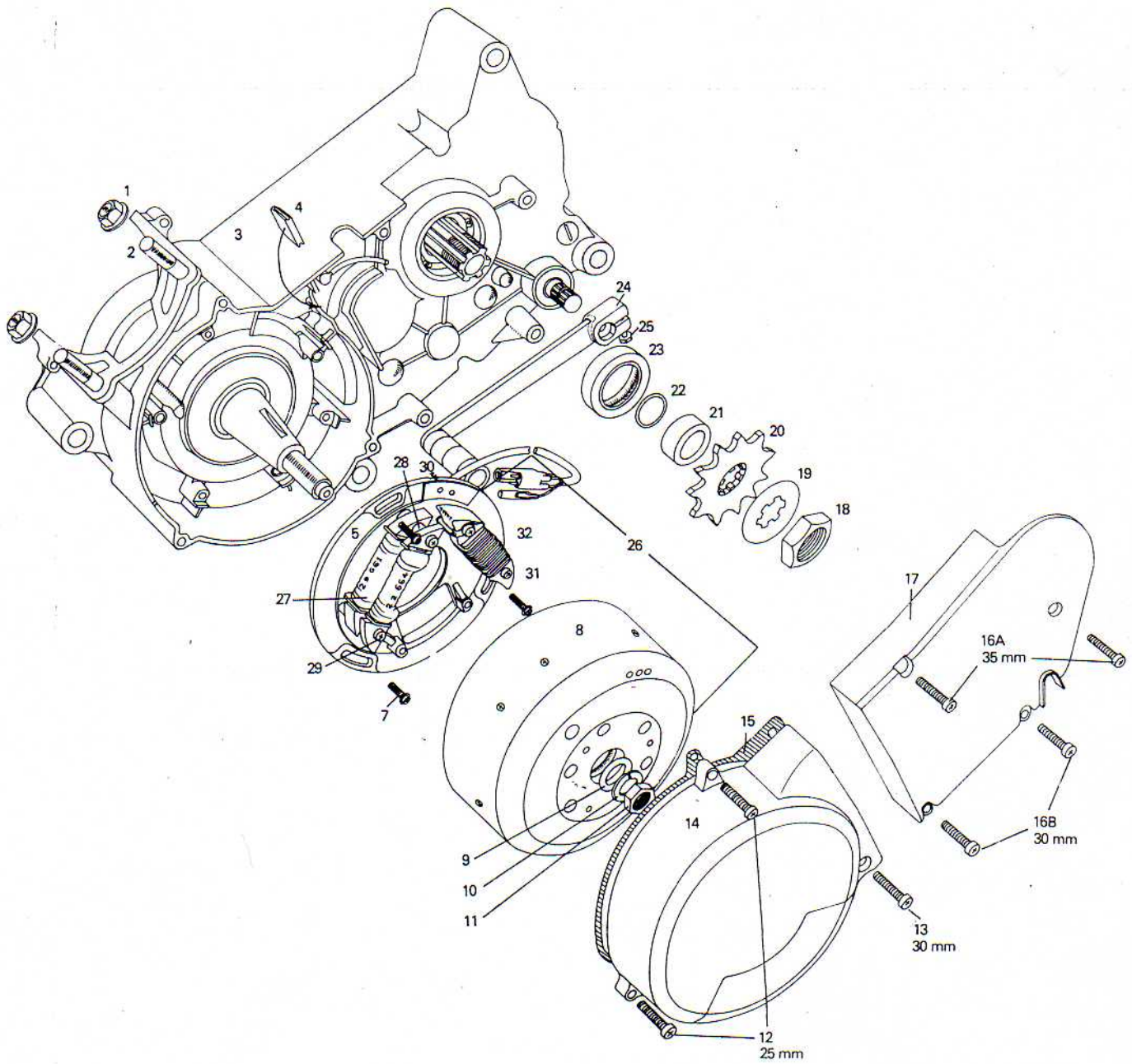
The exploded drawings are numbered 1-8.
The corresponding parts lists are numbered
accordingly and start on page 18.
There are no drawings for Parts List 9.



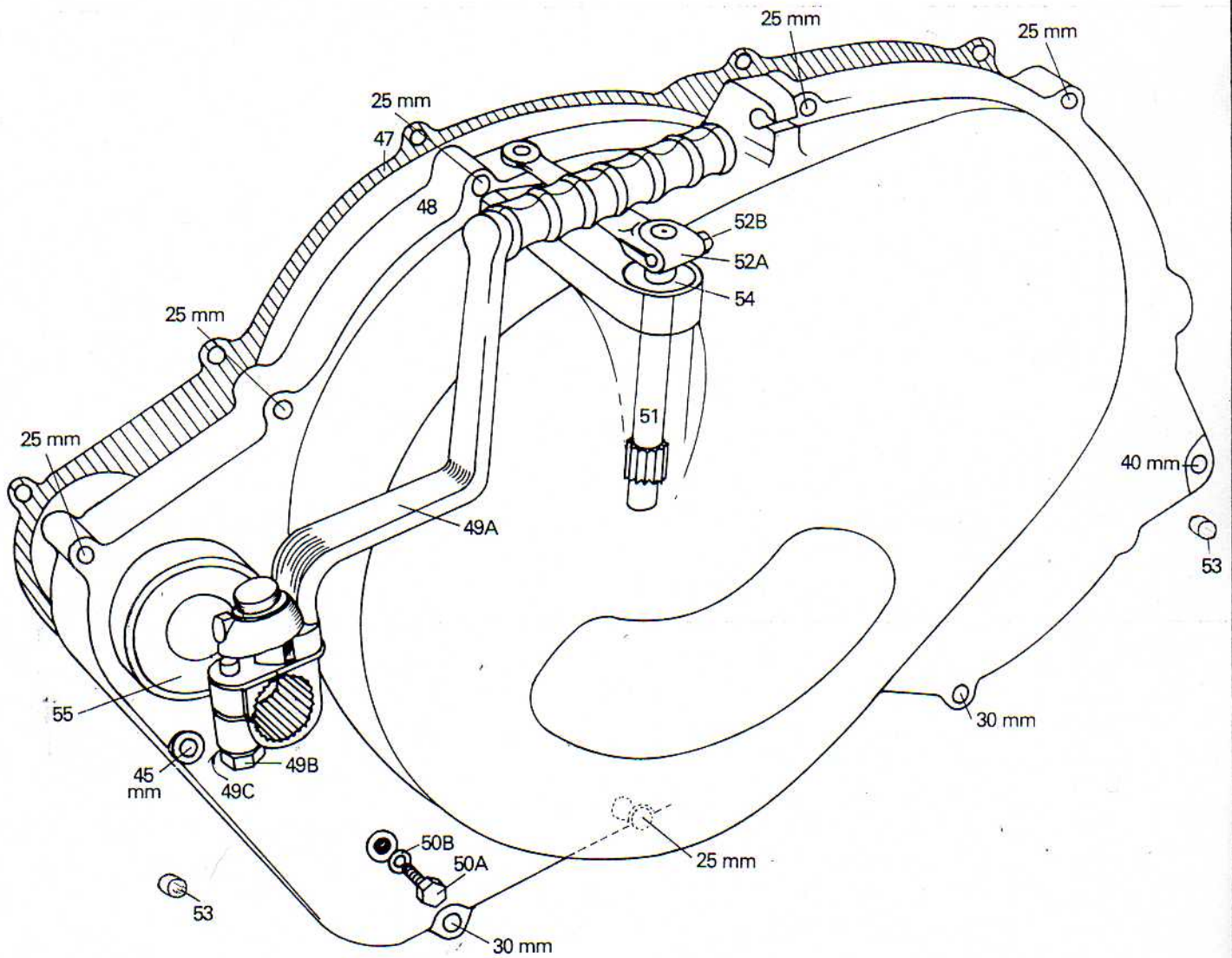
DRAWING FOR PARTS LIST 1



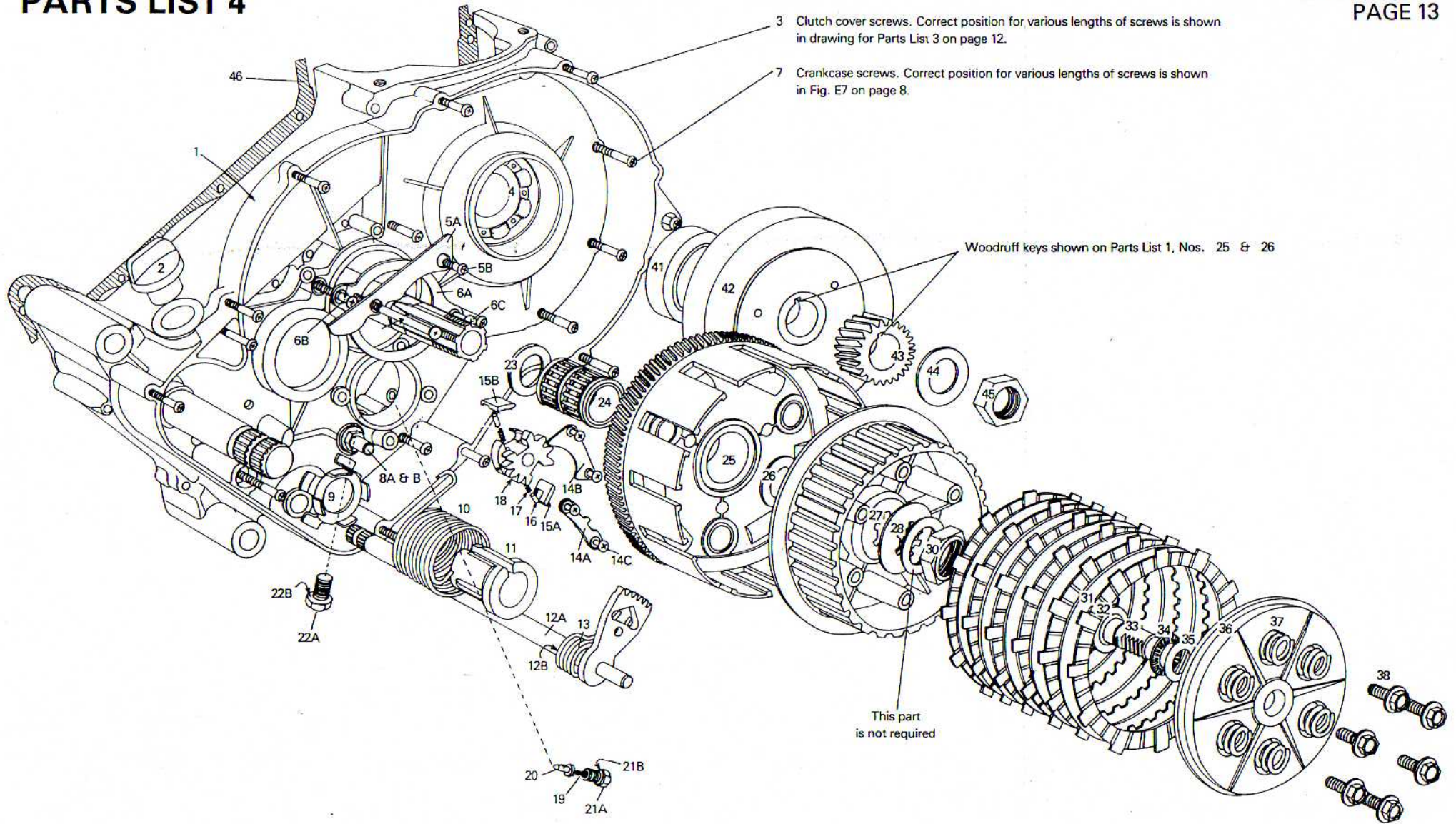
DRAWING FOR PARTS LIST 2



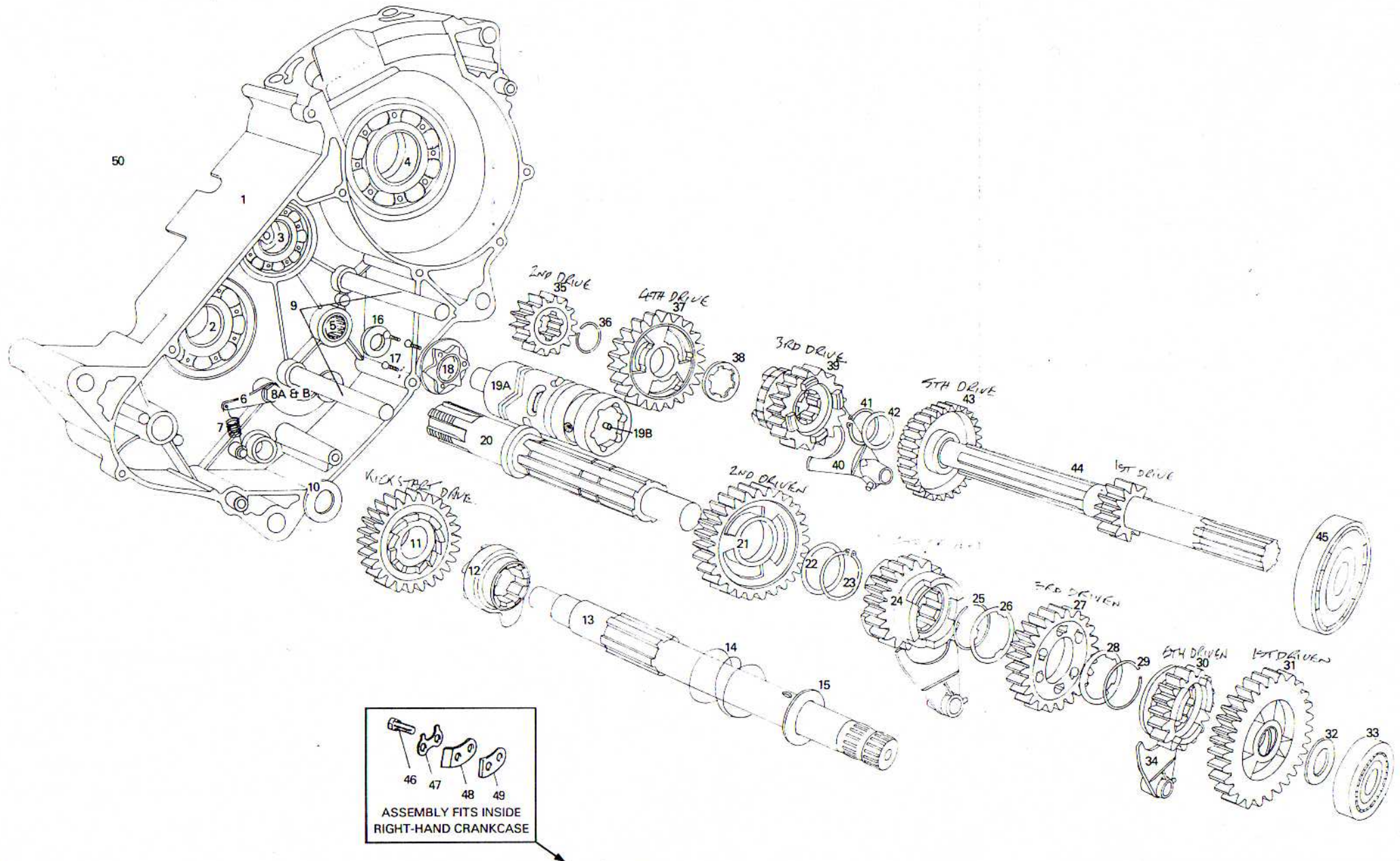
DRAWING FOR PARTS LIST 3



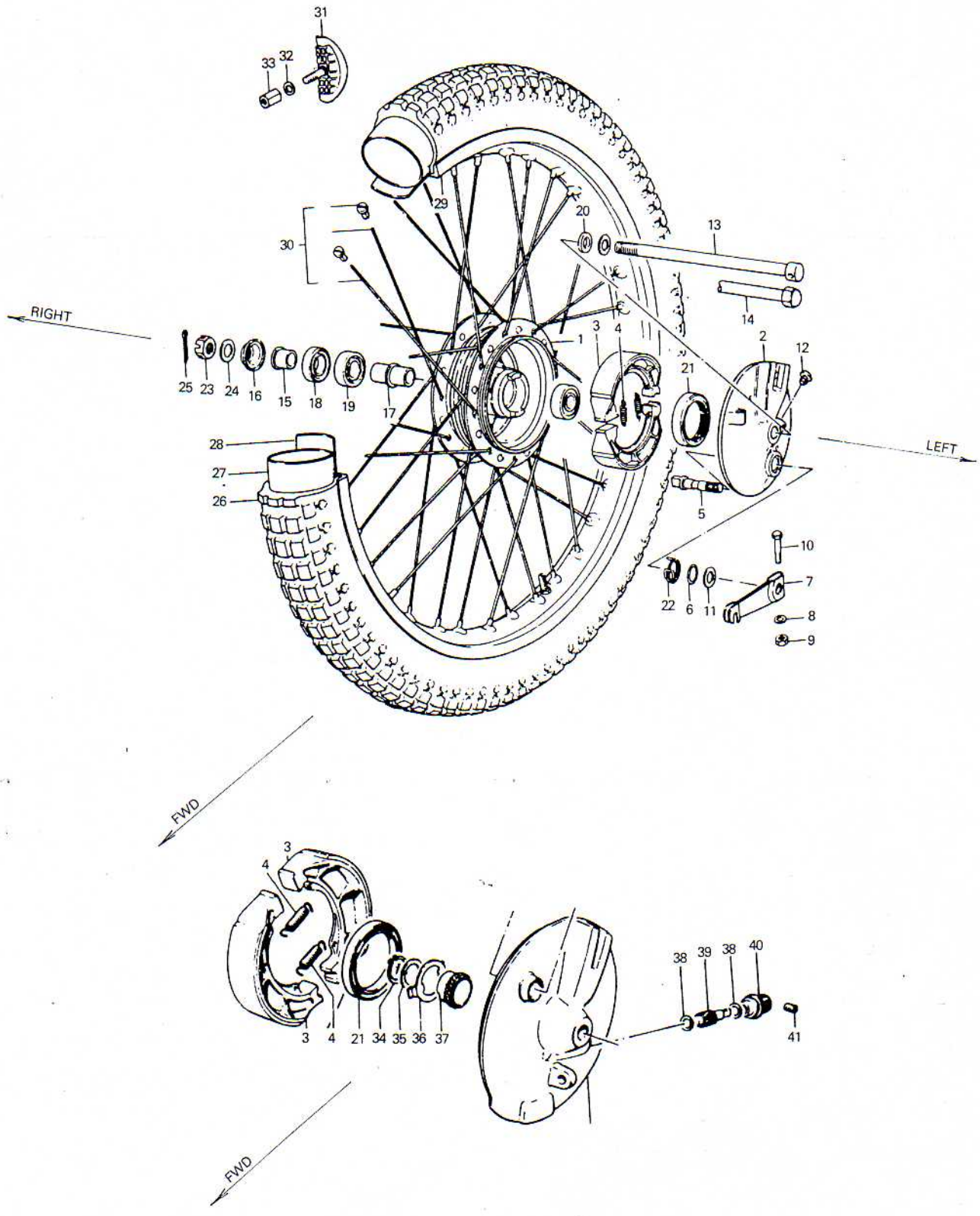
DRAWING FOR PARTS LIST 4



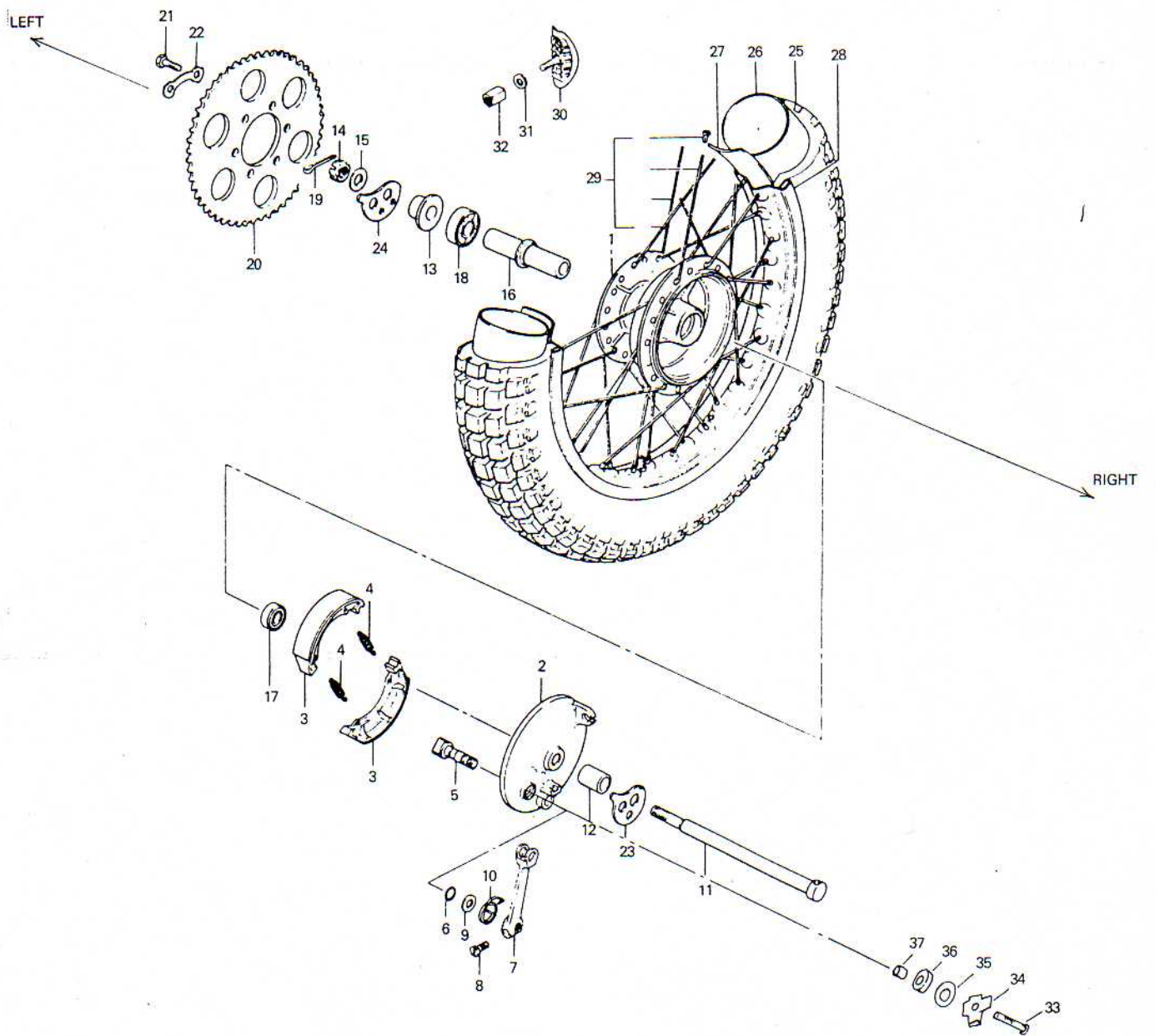
DRAWING FOR PARTS LIST 5



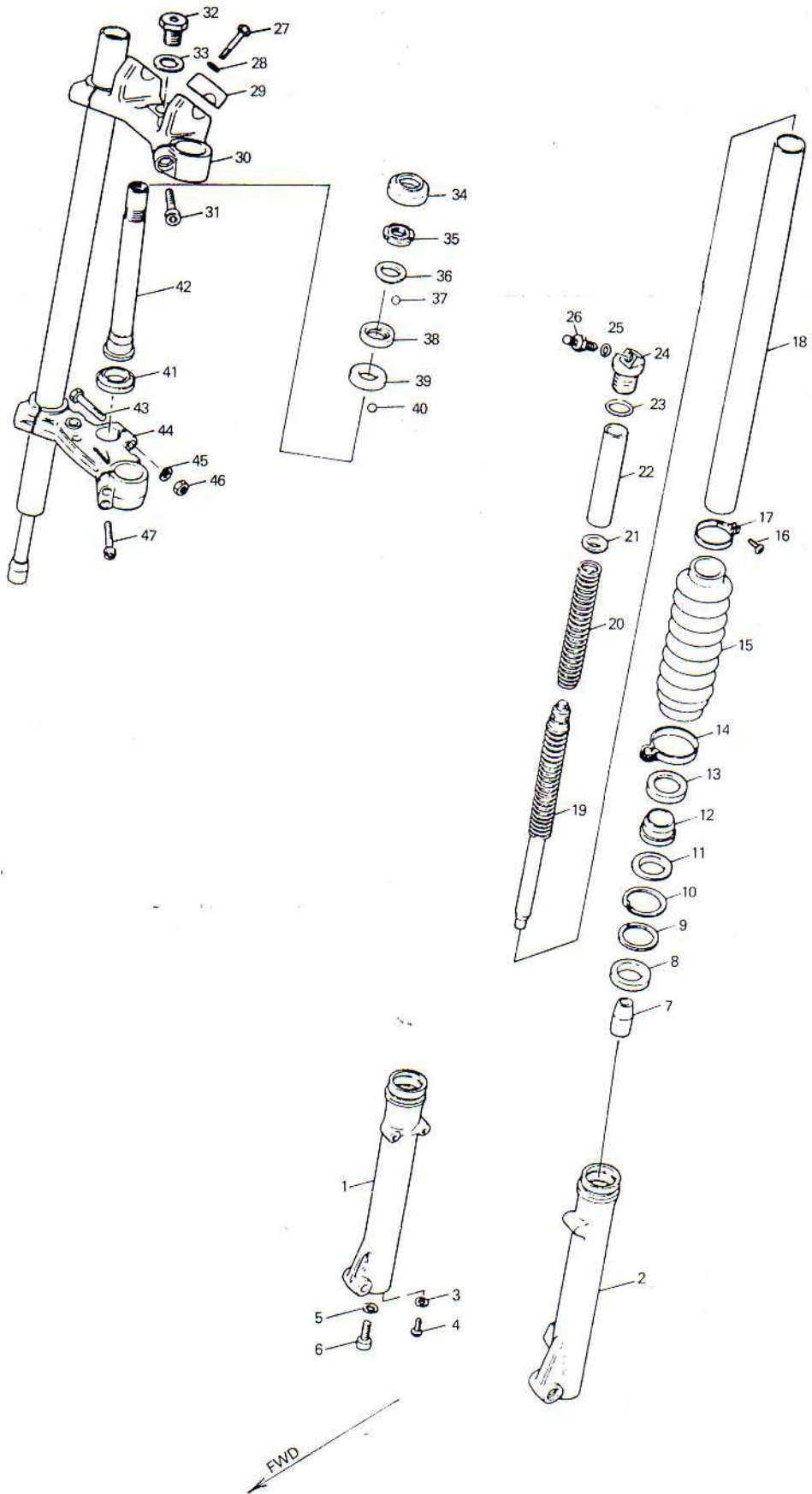
DRAWING FOR PARTS LIST 6



DRAWING FOR PARTS LIST 7



DRAWING FOR PARTS LIST 8



Parts Lists

PARTS LIST 1

Fig. No.	Part No.	Description	Quantity
1	09482-0089	Spark plug	1
2	09140-08005	Cylinder head nut	6
3	08322-21088	Cylinder head washer	6
4	11151-25000	Cylinder head fin rubber pad	8
5-a	11111-38100	Cylinder head 325	1
5-b	11111-38250	Cylinder head 250	1
6	11141-16250	Cylinder head gasket 250	1
7	11141-38100	Cylinder head gasket 325	1
8	09108-08018	Cylinder head barrel stud bolt	6
9	11252-38001	Cylinder fin rubber pad	16
10-a	11210-38100	Cylinder 325	1
10-b	11210-38250	Cylinder 250	1
11	11241-38100	Cylinder base gasket	1
12-a	12110-38100	Piston complete 325	1
12-b	12110-30000	Piston complete 250	1
13-a	12140-95211	Piston ring set 325	1
13-b	12140-30010	Piston ring set 250	1
14	09381-18002	Gudgen pin circlip	2
15-a	09263-18011	Small end bearing 325	1
15-b	09263-18005	Small end bearing 250	1
16-a	12151-15002	Gudgen pin 325	1
16-b	12151-15000	Gudgen pin 250	1
17	09283-30011	Left hand crank shaft oil seal	1
18	08113-63060	Left hand crank shaft main bearing	1
19	08341-31049	Magneto woodruff key	1
20	12261-38100	Left hand crank shaft	1
21	12161-31001	Connecting rod	1
22	09263-24007	Big end bearing	1
23	12211-41101	Big end bearing crank pin	1
24	12221-38100	Right hand crank shaft	1
25	08341-31059	Crank shaft auxiliary flywheel woodruff key	1
26	08341-31059	Primary drive gear woodruff key	1
27	08113-63050	Right hand crank shaft main bearing	1
28	09283-35009	Right hand crank shaft oil seal	1
29-a	13150-38100	Reed valve assembly	1
29-b		Reed petal set	
30	01114-06258	Reed unit connecting bolt	4
31	13110-38100	Rubber intake manifold	1
32	09402-44306	Rubber intake manifold clamp	1
33	13200-38100	Carburettor complete	1
34	12200-38100	Crank shaft assembly complete	1
35	13156-38100	Reed valve assembly gasket	1

Optional Parts

RL 325

12110-38100-025	Piston over size 0.25	1
12110-38100-050	Piston over size 0.50	1
12140-95211-025	Piston ring set over size 0.25	1
12140-95211-050	Piston ring set over size 0.50	1

RL 250

12110-30710	Piston over size 0.50	1
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12110-30720	Piston over size 1.00	1
12140-30710	Piston ring set over size 0.50	1
12140-30720	Piston ring set over size 1.00	1

PARTS LIST 2

Fig. No.	Part No.	Description	Quantity
1	09159-10022	Crank case/cylinder nut	4
2	01421-10308	Crank case/cylinder stud	4
3	11320-38100	Left hand crank case	1
4	09259-04001	Magneto rubber grommit	1
5	32101-38120	Magneto stator plate assembly	1
6	Not required		
7	09139-05011	Magneto stator plate screw	3
8	32102-38120	Magneto flywheel	1
9	09160-14015	Magneto flywheel washer	1
10	08321-21148	Magneto flywheel lockwasher	1
11	09140-14011	Magneto flywheel nut	1
12	02112-06258	Magneto cover screw 25mm	2
13	02112-06308	Magneto cover screw 30mm	1
14	11351-38100	Magneto cover	1
15	11483-38100	Magneto cover gasket	1
16-a	02112-06358	Gear box sprocket cover screw 35mm	2
16-b	02112-06308	Gear box sprocket cover screw 30mm	2
17	11361-38100	Gear box sprocket cover	1
18	09140-22003	Gear box sprocket nut	1
19	09167-22004	Gear box sprocket washer	1
20	27511-41100	Gear box sprocket 12T	1
	27511-41110	Gear box sprocket 13T	1
	27511-41111	Gear box sprocket 11T	1
21	09180-22016	Gear box sprocket spacer	1
22	09280-22003	Gear box sprocket spacer, rubber "O" ring	1
23	09283-32003	Gear box drive shaft oil seal	1
24	25600-38100	Gear lever	1
25	01107-06208	Gear lever bolt	1
26	32100-38121	Magneto assembly complete	1
27	32140-32020	Primary coil assembly	1
28	32160-32020	Coil spacer	1
29	02111-05358	Screw primary coil	2
30	02111-24258	Screw, magneto lead wire	1
31	02111-05303	Screw lighting coil	2
32	32120-29420	Lighting coil	1

PARTS LIST 3

Fig. No.	Part No.	Description	Quantity
47	11482-38100	Clutch cover gasket	1
48	11341-38100	Clutch cover	1
49-a	26300-38100	Kick starter assembly	1
49-b	09135-10002	Kick starter bolt	1
49-c	08321-21108	Kick starter bolt washer	1

50-a	09128-06004	Transmission oil level screw	1	20	25351-30010	Gear shift cam barrel neutral location	1
50-b	09168-06001	Transmission oil level screw washer	1			plunger	
51	23261-16500	Clutch release pinion	1	21-a	25354-30000	Gear shift cam barrel neutral location	1
52-a	23271-40000	Clutch release arm	1			plunger holder	
52-b	01107-06208	Clutch release arm bolt	1	21-b	09168-14002	Washer for above part	1
53	09206-13001	Clutch cover location dowel	2	22-a	09247-14007	Oil drain plug	1
54	09285-12002	Clutch release pinion oil seal	1	22-b	09168-14002	Oil drain plug washer	1
55	09283-20029	Kick starter shaft oil seal	1	23	09164-46002	Clutch housing bearing washer	1
				24-a	09180-20010	Clutch housing bearing sleeve	1
				24-b	09263-25014	Clutch housing bearing	1
				25	21200-38100	Clutch housing	1
				26	08211-20383	Clutch hub bearing retaining washer	1
				27	21411-38100	Clutch hub	1
				28	09167-20001	Clutch locking washer	1
				29		This part not required	
				30	09140-20002	Clutch hub retaining nut	1
				31	21451-45000	Clutch plate, driven	5
				32	21441-45000	Clutch plate, drive	6
				33	23165-16501	Clutch release rack	1
				34	09263-15003	Clutch release thrust bearing	1
				35	09160-15015	Clutch release thrust washer	1
				36	21462-16500	Clutch pressure disc	1
				37	09440-19003	Clutch spring	6
				38	09116-06016	Clutch spring bolt	6
				41	09283-35009	Right hand crank shaft oil seal	1
				42	12271-38100	Crank shaft auxiliary flywheel	1
				43	21111-38100	Crank shaft primary gear	1
				44	09164-18001	Crank shaft gear lock washer	1
				45	09140-18002	Crank shaft gear nut	1
				46	11481-38100	Crank case gasket	1

PARTS LIST 4

Fig. No.	Part No.	Description	Quantity
1	11310-38100	Right hand crank case	1
2	09259-19001	Transmission oil filler plug	1
3-a	02112-06458	Clutch cover screw 45 mm	1
3-b	02112-06408	Clutch cover screw 40 mm	1
3-c	02112-06308	Clutch cover screw 30 mm	2
3-d	02112-06258	Clutch cover screw 25 mm	6
4	08113-63050	Crank shaft right hand main bearing	1
5-a	24871-38100	Oil reservoir plate	1
5-b	02122-06128	Oil reservoir plate screw	1
6-a	24741-30000	Gear box countershaft bearing retaining plate	1
6-b	02122-06128	Countersunk screw for above part	1
6-c	02112-06128	Roundhead screw for above part	1
7-a	02122-06708	Crank case screw 70 mm	1
7-b	02112-06658	Crank case screw 65 mm	2
7-c	02112-06608	Crank case screw 60 mm	1
7-d	02112-06508	Crank case screw 50 mm	1
7-e	02112-06458	Crank case screw 45 mm	7
7-f	02112-06358	Crank case screw 35 mm	1
8-a	25671-01000	Gear change arm stopper	1
8-b	08321-21088	Gear change arm stopper lock washer	1
9	26222-30000	Kick starter shaft spring holder	1
10	09448-47002	Kick starter shaft return spring	1
11	26221-30000	Kick starter shaft spring guide	1
12-a	25510-38100	Gear change shaft complete	1
12-b	09180-12068	Gear change shaft spacer	1
13	09444-26012	Gear change shaft return spring	1
14-a	25341-11000	Gear change cam barrel drive gear assembly retaining plate, left	1
14-b	25331-30000	Gear change cam barrel drive gear assembly retaining plate, right	1
14-c	02122-06108	Gear change cam barrel drive gear assembly retaining plate, screws	4
15-a	25323-11000	Lower gear shift pawl	1
15-b	25324-11000	Upper gear shift pawl	1
16	09261-05003	Gear shift pawl pin	2
17	09440-04003	Gear shift pawl return spring	2
18	25322-11000	Gear shift cam barrel drive gear	1
19	09440-06014	Gear shift cam barrel neutral location plunger spring	1

Crank case assembly complete (left and right cases) Part No. 11300-38100

PARTS LIST 5

Fig. No.	Part No.	Description	Quantity
1	11320-38100	Left hand crank case	1
2	09262-22006	Drive shaft bearing left	1
3	08113-62030	Counter shaft bearing left	1
4	08113-63060	Crank shaft main bearing left	1
5	09263-12009	Gear change cam barrel bearing	1
6	25350-30001	Gear change cam barrel retaining arm	1
7	09443-1007	Gear change cam barrel retaining arm spring	1
8-a	09111-06003	Bolt for above part	1
8-b	08322-21068	Washer for above part	1
9	25411-30000	Selector fork pivot pin	2
10	08211-17322	Kick start drive gear washer	1
11	26241-38100	Kick start drive ratchet gear	1
12	26231-40000	Kick start shaft ratchet	1
13	26211-38100	Kick start shaft	1
14	09440-35001	Kick start ratchet retaining spring	1
15	08211-20382	Kick start retaining spring plate	1

16	08211-12253	Gear change cam barrel thrust washer	1	10	09100-06050	Front brake cam lever bolt	1
17	02122-04128	Gear change cam barrel stopper plate screw	3	11	09160-12011	Brake cam dust seal washer	1
18	25381-20001	Gear change cam stopper plate	1	12	This item not required on Beamish Suzuki		
19-a	25311-38100	Gear change cam barrel	1	13	This item not required on Beamish Suzuki		
19-b	09261-10002	Gear change cam barrel pin	1	14	54711-16502	Front wheel axle	1
20	24131-38100	Drive shaft	1	15	09180-12057	Right hand spacer	1
21	24321-38100	Second gear driven	1	16	54892-28001	Front hub dust seal	1
22	09160-25003	Second gear driven thrust washer	1	17	09180-12041	Front hub central bearing spacer	1
23	09380-25003	Second gear driven circlip	1	18	09284-18002	Right hand bearing oil seal	1
24	24341-38100	Fourth gear driven	1	19	09262-12002	Front hub bearings	2
25	09380-25006	Third gear driven circlip	1	20	09180-12058	Front spacers	2
26	09167-25012	Third gear driven thrust washer	1	<i>(NB One on inside left hand fork leg, one on outside fork leg)</i>			
27	24331-38000	Third gear driven	1	21	09285-43001	Backing plate oil seal	1
28	09167-25012	Third gear driven thrust washer	1	22	09448-27005	Front brake cam lever return spring	1
29	09380-25006	Third gear driven circlip	1	23	08314-31128	Front axle nut	1
30	24351-38100	Fifth gear driven	1	24	08322-11128	Front axle washer	1
31	24310-38000	First gear driven	1	25	04111-30258	Front axle split pin	1
32	09160-17001	First gear driven thrust washer	1	26	Optional	Tyre	
33	08143-62030	Drive shaft bearing right	1	27	Optional	Tube	
34	25211-30001	Gear change selector fork (drive shaft)	2	28	Optional	Rim tape	
35	24221-38100	Second gear, drive	1	29	55311-29610	Front wheel rim	1
36	09380-22003	Fourth gear, drive circlip	1	30-a	55300-28850	Front spoke set	36
37	24241-38100	Fourth gear, drive	1	30-b	55321-28700	Front wheel inner spokes	18
38	09167-22007	Fourth gear drive thrust washer	1	30-c	55322-28700	Front wheel outer spokes	18
39	24231-38000	Third gear, drive	1	30-d	65325-16520	Front wheel spoke nipples	36
40	25231-30000	Gear change selector fork (counter shaft)	1	31	65270-30001	Security bolt	1
41	08331-31229	Fifth gear, drive circlip	1	32	08322-21088	Washer for above part	1
42	08211-22281	Fifth gear drive thrust washer	1	33	09159-08016	Nut for above part	1
43	24251-38100	Fifth gear, drive	1	34	08331-31189	Speedometer gear circlip	1
44	24121-38100	Countershaft	1	35	09160-18002	Speedometer gear thrust washer	1
45	08143-63040	Countershaft bearing, right	1	36	54661-07000	Speedometer gear driving plate	1
46	01107-06168	Kick start stopper plate bolt	2	37	54611-28401	Speedometer drive gear	1
47	09169-06003	Kick start stopper plate washer	1	38	09160-05001	Speedometer pinion thrust washer	2
48	26232-40000	Kick start stopper plate guide	1	39	54621-28400	Speedometer drive pinion	1
49	26233-40000	Kick start stopper plate	1	40	54632-01001	Speedometer drive pinion retaining bush	1
50	09206-13001	Crank case locating dowels	2	41	09134-03101	Retaining screw for above part	1

PARTS LIST 6

Fig. No.	Part No.	Description	Quantity
1	54110-28301	Front wheel hub	1
2	54210-38000	Front brake backing plate	1
3	54410-01005	Front brake shoes	2
4	09443-07001	Brake shoe spring	2
5	54441-01002	Front brake cam	1
6	09280-12001	Front brake cam dust seal	1
7	54451-38000	Front brake cam lever	1
8	08322-21068	Front brake cam lever washer	1
9	08310-11068	Front cam lever nut	1

PARTS LIST 7

Fig. No.	Part No.	Description	Quantity
1	64110-38001	Rear wheel hub	1
2	64210-38000	Rear brake backing plate	1
3	54410-07002	Rear brake shoe set	2
4	09443-07001	Rear brake shoe springs	2
5	54441-01002	Rear brake cam	1
6	09280-12001	Brake cam dust seal	1
7	64451-25301	Rear brake cam lever	1
8	01104-06208	Rear brake cam lever bolt	1
9	09160-12011	Rear brake cam dust deal washer	1
10	09448-27005	Rear brake cam lever spring	1
11	64711-28001	Rear axle	1

12	09180-15033	Rear axle right hand spacer	1	18	51110-38100	Fork tube	2
13	64750-38000	Rear axle left hand spacer	1	19	51146-38100	Damper rod	2
14	09141-12002	Rear axle nut	1	20	51171-38100	Fork spring	2
15	08322-11128	Rear axle washer	1	21	51172-38010	Front fork spring cover guide	2
16	64730-28001	Rear wheel hub central bearing spacer	1	22	51176-41211	Front fork spring spacer	2
17	09262-15003	Rear right hand hub bearing	1	23	51117-16310	Fork cap rubber 'O' ring	2
18	09262-15004	Rear left hand hub bearing	1	24	51351-38600	Fork cap	2
19	04111-30308	Rear axle split pin	1	25	51117-41211	Air valve rubber 'O' ring	2
20	64511-38001	Rear sprocket (optional)	1	26	51169-41211	Air valve	2
21	09100-08094	Rear sprocket bolt	6	27	01234-08357	Handle bar clamp bolt	4
22	09169-08013	Rear sprocket lock tab	3	28	08321-21088	Lock washer for above part	4
23	61411-38000	Snail cam chain adjuster, right	1	29	56211-27110	Handle bar clamp	2
24	61421-38000	Snail cam chain adjuster, left	1	30	51311-38010	Top yoke	1
25	Optional	Tyre		31	09106-10001	Top yoke pinch bolt	2
26	Optional	Tube		32	51351-28310	Steering stem top bolt	1
27	Optional	Rim tape		33	51356-28310	Washer afor above part	1
28	65311-41020	Rear wheel rim	1	34	51643-25001	Steering stem dust seal	1
29-a	65300-28860	Rear wheel spoke set	36	35	51631-28000	Steering stem lock nut	1
29-b	65321-28321	Rear spokes inner, right	9	36	51621-28000	Upper, outer steering race	1
29-c	65322-28321	Rear spokes outer, right	9	37	06111-06003	Ball bearings 3/16 in.	22
29-d	65323-28321	Rear spokes inner, left	9	38	51611-20002	Upper, inner steering race	1
29-e	65324-28321	Rear spokes outer, left	9	39	51611-33002	Lower, inner steering race	1
29-f	65325-16521	Rear wheel spoke nipples	36	40	06111-08003	Ball bearings ¼ in.	18
30	65270-32101	Security bolt	2	41	51621-33001	Lower, outer steering race	1
31	08322-21088	Washer for above part	2	42	51401-38100	Steering stem	1
32	09159-08016	Nut for above part	2	43	01104-10608	Steering stem pinch bolt	1
33	09119-10012	Backing plate anchor bolt	1	44	51411-38010	Bottom yoke	1
34	09167-10004	Lock washer for above part	1	45	08321-21108	Pinch bolt lock washer	1
35	09160-10028	Washer for above part	1	46	08310-11108	Pinch bolt nut	1
36	09161-14006	Cushion for above part	1	47	51456-28310	Bottom yoke allan screws	4
37	09180-10026	Spacer for above part	1				

PARTS LIST 8

Fig. No.	Part No.	Description	Description
1-a	51103-38100	Right hand fork leg complete	1
1-b	51130-38100	Right hand fork slider	1
2-a	51104-38100	Left hand fork leg complete	1
2-b	51140-38100	Left hand fork slider	1
3	51183-03010	Drain screw gasket	2
4	02111-04087	Drain screw	2
5	51148-41310	Damper rod retaining bolt gasket	2
6	51147-16510	Damper rod retaining bolt	2
7	51195-38010	Damper rod locating bush	2
8	51153-38600	Front fork oil seal	2
9	51158-41211	Fork oil seal washer	2
10	51156-41211	Fork oil seal circlip	2
11	This part not required in trials forks		
12	51173-38600	Dust seal	51643 25001 000 2
13	51149-41211	Dust seal guide	2
14	51573-41410	Fork gaiter clip	2
15	51571-38600	Fork gaiter	2
16/17	Optional	Fork gaiter jubilee clip	2

PARTS LIST 9

N.B. THERE IS NO DRAWING FOR THIS PARTS LIST

Part No.	Description	Quantity
325/1	Frame	1
325/2	Front engine mountings	2
325/3	Bottom engine mountings	2
325/4	Bottom rear engine mounting stud	1
325/5	Socket cap allan screws for above part	2
325/6	Washers for above part	2
325/7/R	Right hand foot rest	1
325/7/L	Left hand foot rest	1
325/8	Foot rest pins	2
325/9	Foot rest pin washers	2
325/10	Foot rest pin, split pins	2
325/11	Foot rest springs	2
325/12	Side panel dzus fasteners	2
325/13	Washers for above part	2
325/14	Petrol tank rubber retaining strap	1
325/15	Foot brake pedal	1
325/16	Brake pedal retaining washer	1
325/17	Split pin for above part	1

325/18	Brake rod	1	31900-38020	C.D.I. unit and loom	1
325/19	Alloy sump plate	1	09443-11002	Exhaust front pipe retaining spring	1
325/20	Button head screws for above plate 8 mm x 20 mm	4	14170-16500	Exhaust pipe flange	1
325/21	Button head screws for above plate 8 mm x 16 mm	4	02112-36208	Exhaust pipe flange screws	3
325/22	Button head screws for above plate 6 mm x 16 mm	3	14181-30080	Exhaust pipe flange gasket	1
325/23	Washers for above screws	3	34100-38700	Speedometer head	1
325/24	Front mudguard stay	1	34910-38700	Speedometer cable	1
325/25	Not required		37820-16512	Ignition cut out switch assembly	1
325/26	Swinging arm	1	09329-10007	Petrol tank front mounting rubbers	2
325/27	Swinging arm pivot bolt	1	44541-30000	Petrol tank central mounting rubber	1
325/28	Pivot bolt nuts	2	44300-05112	Fuel tap	1
325/29	Pivot bolt washers	2	44200-28300	Petrol tank filler cap	1
325/30	Swinging arm bushes	2			
325/31	Swinging arm bush spacer	1			
325/32	Prop stand	1			
325/33	Prop stand pivot bolt	1			
325/34	Nut for above part	1			
325/35	Prop stand internal washer	1			
325/36	Prop stand spring	1			
325/37	Rear brake arm	1			
325/38	Rear brake arm spring	1			
325/39	Chain oiler screw	1			
325/40	Chain oiler screw spring	1			
325/41	Chain oiler cap	1			
325/42	Chain tensioner arm	1			
325/43	Chain tensioner pivot tube	1			
325/44	Chain tensioner pivot bolt	1			
325/45	Nut for above part	1			
325/46	Washer for above part	1			
325/47	Chain tensioner spring	1			
325/48	Chain tensioner pad	1			
325/49	Screws for above part	2			
325/50	Nuts for above part	2			
325/51	Washers for above part	2			
BE/001	Front mudguard	1			
BE/002	Rear mudguard	1			
BE/003/1	Petrol tank	1			
BE/003/2	Petrol tank, large	1			
BE/004	Chain guard	1			
BE/005	Air filter box	1			
BE/006	Air filter element retainer	1			
BE/007	Air filter element	1			
BE/008	Air filter lid	1			
BE/009	Exhaust front pipe	1			
BE/010	Main exhaust	1			
BE/011	Exhaust tail pipe	1			
BE/012	Throttle cable	1			
BE/013	Front brake cable	1			
BE/014	Clutch cable	1			
BE/015	Front number plate	1			
BE/016	Right hand side panel	1			
BE/017	Left hand side panel	1			
BE/018	Seat	1			
33410-30020	Ignition coil	1			
				Rear suspension units—optional Suzuki, Girling, etc.	