

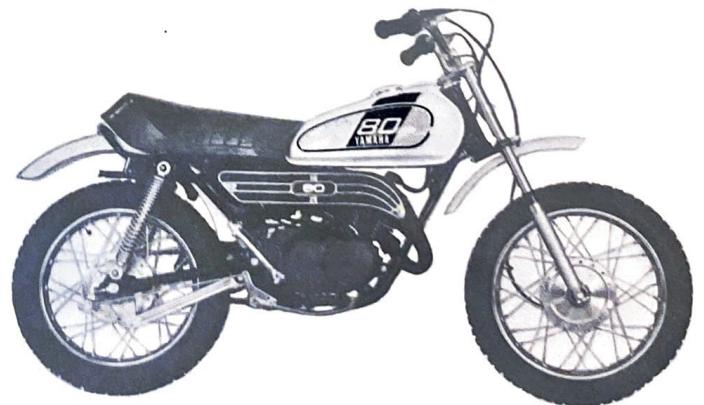


YAMAHA

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GT80C GTMXC

ASSEMBLY MANUAL



90894-07509

FOREWORD

This Assembly Manual contains the information required for the unpacking and assembly of Yamaha motorcycles so that the Yamaha serviceman can assemble the machine in the correct manner. To perform machine assembly, a basic knowledge of service and Yamaha machines is required. Therefore, all Yamaha dealers are urged to make a full study on the service of Yamaha motorcycles using the relevant service manuals.

NOTICE

The service specifications given in this Assembly Manual are based on the model as manufactured when this model may require improvements, the service specifications may be subject to change in the future. If any change is introduced into the specifications or service procedures, Yamaha dealers will be notified through technical service information to be published by Yamaha. The assembly procedure is described in the order that the mechanic should follow, and the correct service tools should be used in the correct manner. Failure to do this may result in poor performance and danger to the rider.

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YAMAHA GT80C, GTMXC
ASSEMBLY MANUAL
1st EDITION, MARCH, 1975
SERVICE DEPT
OVERSEAS ENGINEERING DIVISION
YAMAHA MOTOR. CO., LTD.
IWATA, JAPAN
LIT-11666-00-08

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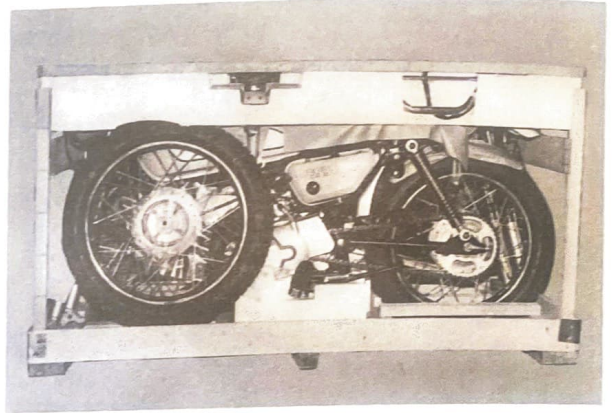
UNPACKING

Note on transportation

Use care not to butt the machine packed in the crate against a hard object or give it a heavy shock during transportation or in the service shop.

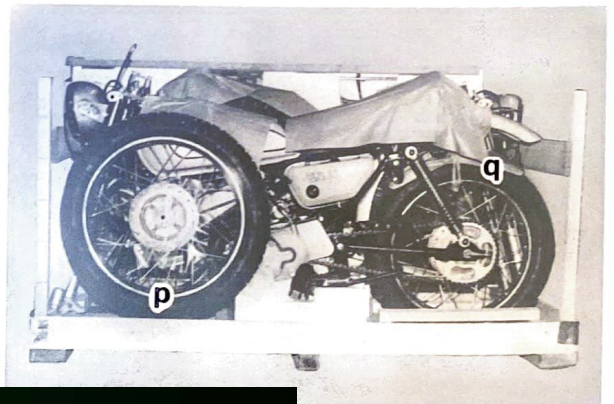
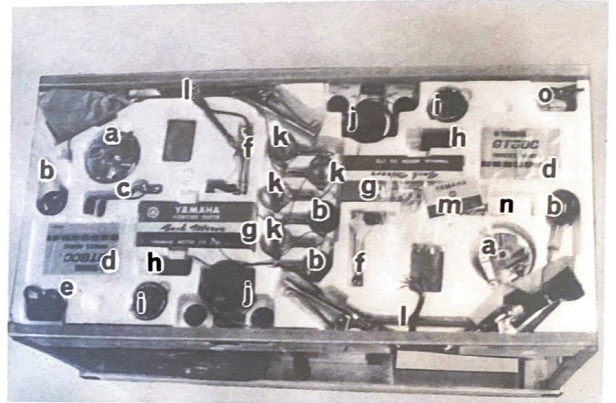
Procedure for unpacking

To remove the machine and parts packed in the cardboard crate, cut the vinyl bands around the box using a cutter or scissors. Next, remove the exterior carton by lifting it straight up.



PARTS CHECK LIST

The following parts are contained in the foam tray and the vinyl bag in the package. Check the quantity of parts against the list. Also check for damage.








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(per unit)

Set position	Parts name	Q'ty
a	Front brake shoe plate assembly	1
b	Rear flasher light (GT80C)Red	2
c	Change pedal	1
d	Owner's Manual (with transmission oil level dip stick)	1
e	Main switch assembly (with ignition key) (GT80C)	1
f	Kick crak	1
g	Rear view mirror (GT80C)	1
h	Foot rest (Right side)	1
i	Speedometer assembly (GT80C)	1
j	Taillight assembly (GT80C)	1
k	Front flasher light(GT80C)Orange	2
l	Handle bar assembly	1
m	Owner's warranty guide book (GT80C)	1
n	Vinyl bag	2 set
o	Vinyl bag (GT80C)	2 set
p	Front wheel assembly	1
q	Front fender	1




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Details of parts in the vinyl bag "n"

No.	Photo	Parts Name	Q'ty	Remarks
n-1		Cotter pin	2 set	for front wheel axle
n-2		Clevis pin	2 set	for right side foot rest
n-3		Cotter pin	2 set	
n-4		Bolt (6 mm)	2 set	for kick crank
n-5		Bolt (6 mm)	2 set	for change pedal

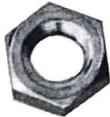





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Details of parts in the vinyl bag "o" (GT80C only)

No.	Photo	Parts Name	Q'ty	Remarks
o-1		Vinyl bag	1	for tail light
o-2		Battery breather pipe	2 set	for battery
o-3		Flasher collar (R)	2 set	for right side rear flasher light

No.	Photo	Parts Name	Q'ty	Remarks
o-4		Flasher collar (L)	2 set	for left side rear flasher light
o-5		Nut (8 mm)	2 x 2 set	for rear flasher light
o-6		Spring washer (8 mm)	2 x 2 set	for rear flasher light

Details of parts in the vinyl bag "o-1" (GT80C only)

No.	Photo	Parts Name	Q'ty	Remarks
o-1-1		Nut (8 mm)	2 x 2 set	for front flasher lights
o-1-2		Spring washer (8 mm)	2 x 2 set	
o-1-3		Grommet	2 x 2 set	for tail light
o-1-4		Bolt (6 mm)	2 x 2 set	
o-1-5		Nut (6 mm)	2 x 2 set	
o-1-6		Spring washer (6 mm)	2 x 2 set	

SET-UP PROCEDURES

Install the following as shown

1. Insert the front fender between the front forks and secure the front fender using 6 mm bolts and spring washers.

Tightening torque: 0.8–1.2 m·kg

NOTE

Bolts and spring washers are fitted to the under bracket.

2. Remove the front wheel axle nut, and loosen the pinch bolt securing the axle. Then remove the wheel axle and wheel axle collar.

3. Install the brake shoe plate assembly in the front wheel hub.

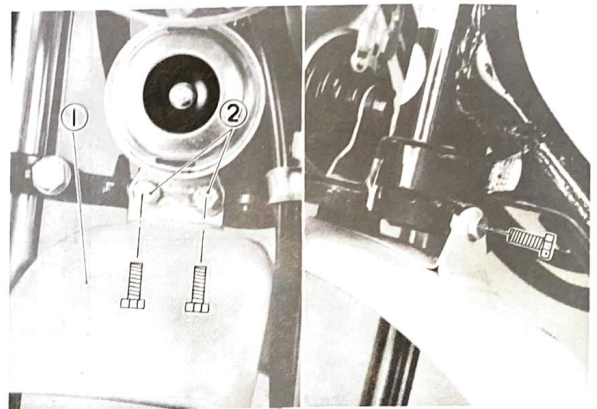
- 1) Apply a light coat of grease to the speedometer drive gear and oil seal.

CAUTION:

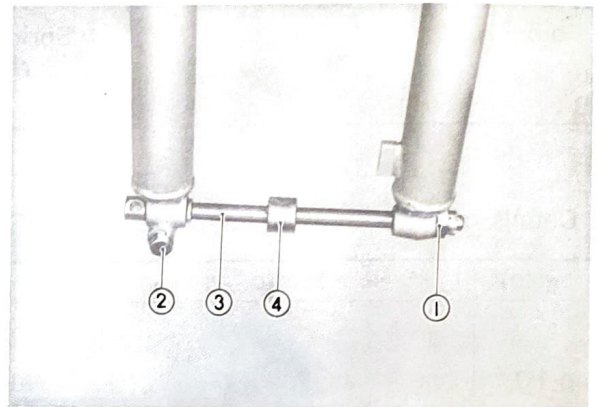
Take care not to put grease on the brake linings or inner surface of the brake drum. If you do so, clean using a rag dampened with solvent.

Foreign material on braking surface can cause impaired braking action.

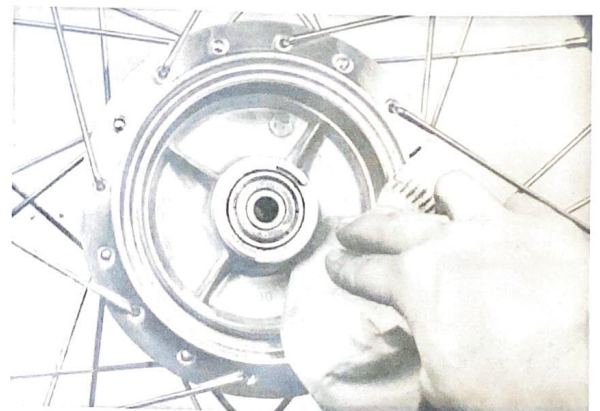
- 2) Clean the inner surface of the front wheel hub with a clean cloth.



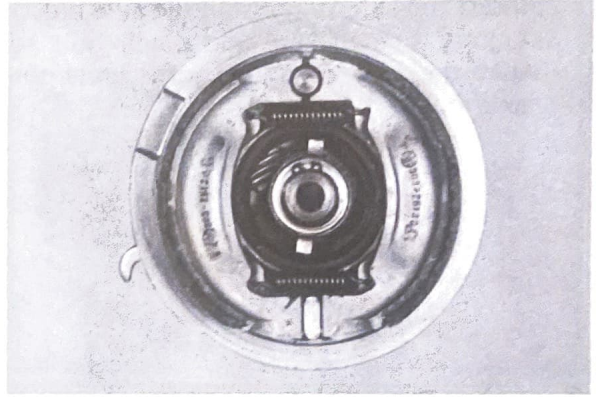
1. Front fender 2. Bolt



1. Wheel axle nut 2. Pinch bolt
3. Wheel axle 4. Wheel axle collar

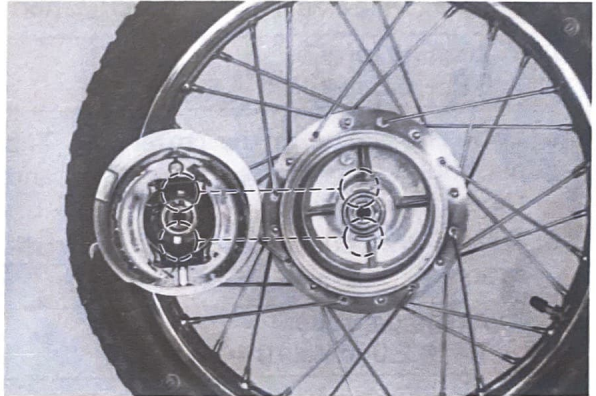


3) Make sure the brake shoes and springs are correctly installed in the shoe plate assembly. If any one of them is out of place, correct per the figure.



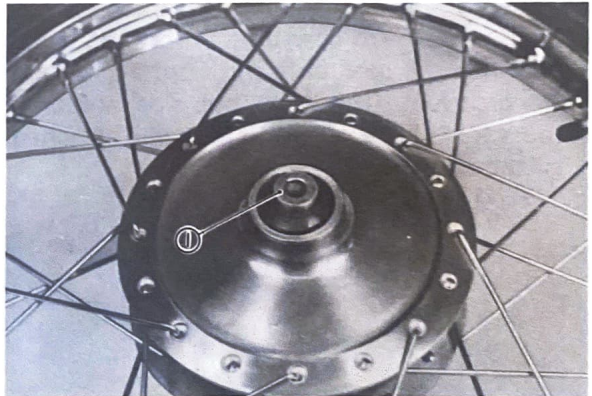
4) Install the brake shoe plate assembly in the wheel hub.

NOTE: _____
Make sure the two legs in the wheel hub align with the two slots in the speedometer clutch assembly.



5) Install the wheel axle collar in the wheel hub on the right side of the front wheel.

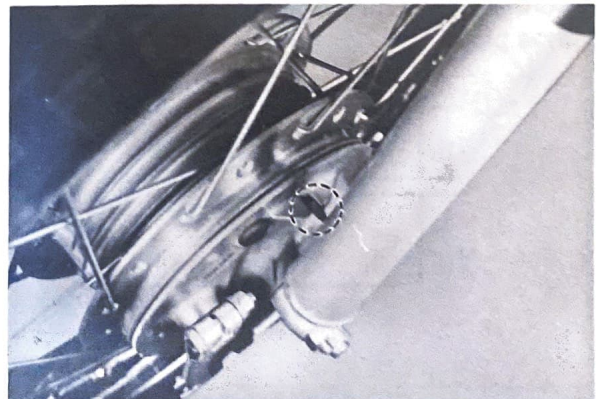
NOTE: _____
To avoid damaging the oil seal lip, apply a light coat of lithium base grease to the oil seal lip and axle collar. If the collar is dirty, clean with a rag.



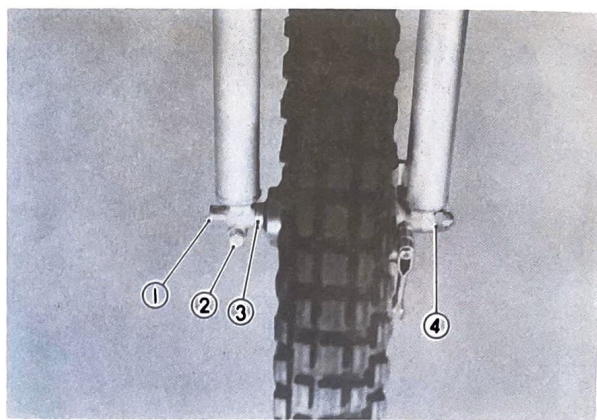
1. Wheel axle collar

4. Install the front wheel on the front forks.

1) Insert the front wheel between the front legs so that the stopper (projection) on the front fork outer tube correctly engages the slot in the brake shoe plate.



- 2) Insert the axle, and install the axle nut.
- 3) Lightly tighten the axle pinch bolt so that the axle does not turn while the axle nut is tightened.



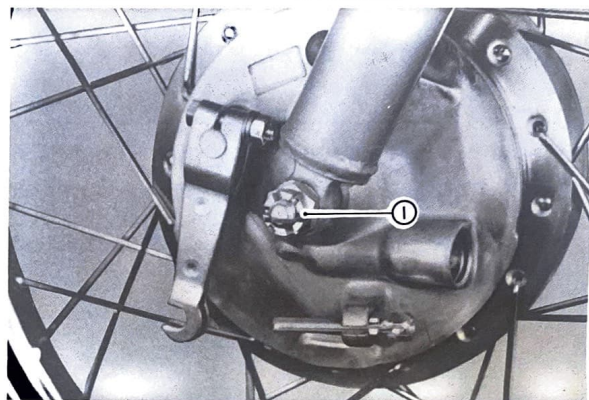
1. Wheel axle 2. Axle pinch bolt
3. Axle collar 4. Axle nut

- 4) Torque the axle nut to specification.

Tightening torque:
5.0 – 6.0 m·kg(36 – 43 ft·lb)

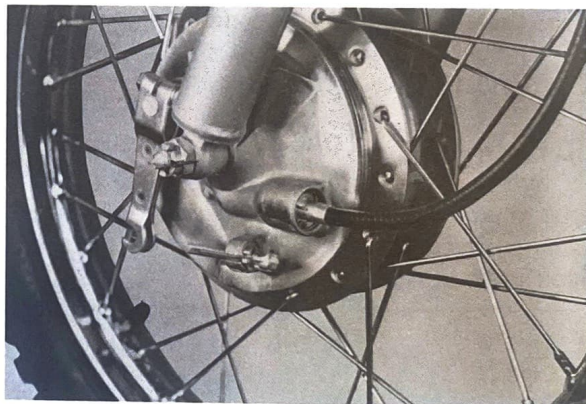
- 5) Lock the nut with the cotter pin. The pin should be inserted downward, and the pin ends should be bent.
- 6) Torque the axle pinch bolt to specification.

Tightening torque:
1.4 – 2.0 m·kg(10 – 14 ft·lb)

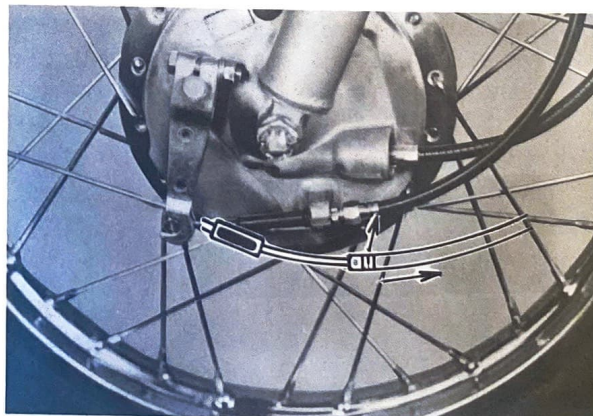


1. Cotter pin

5. Connect the speedometer cable to the front wheel hub gear unit. Insert the cable end into the gear unit and fit the circlip in the groove on the wheel hub side, and lock the cable. (The circlip is already attached to the cable.)



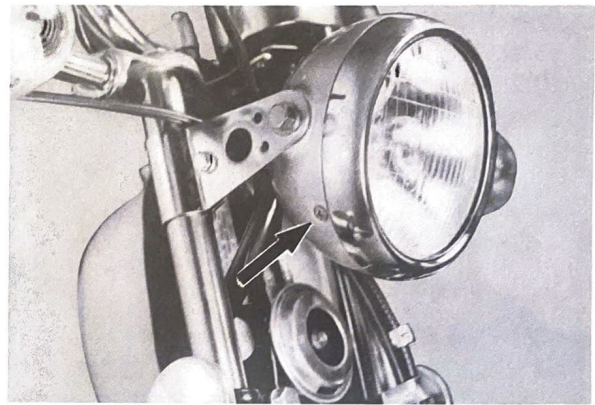
6. Connect the front brake cable to the brake shoe plate.



7. Remove the phillips head screw from the right side of the headlight body. Insert a slotted head screw driver between the headlight body and the headlight rim, pry out the lens assembly.

NOTE:

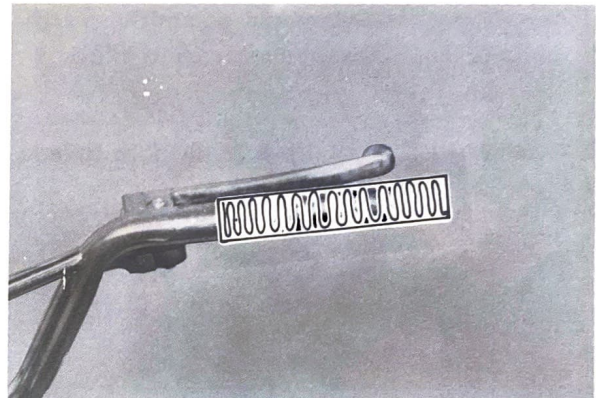
During the operation, care should be taken not to scratch the headlight body and lens rim. Also take care so that the anchor screw is not lost.



8. Remove the throttle grip from front fork. Then grease the right end of the handlebar and the throttle grip housing, and install the throttle grip.

CAUTION:

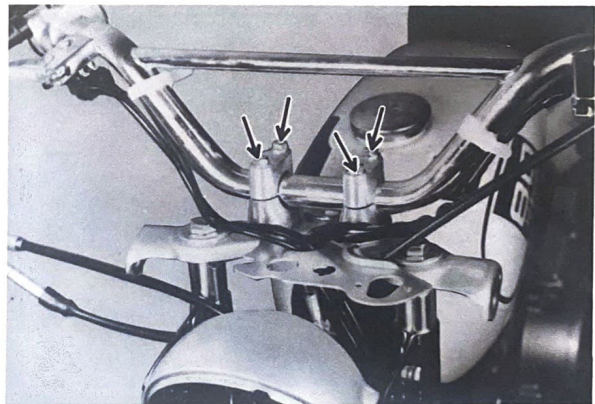
Make certain throttle grip rotates on the handlebar freely, without binding. If not, normal throttle return will be impaired.



9. Install the handlebar using the holder and four hexagon bolts and spring washers.

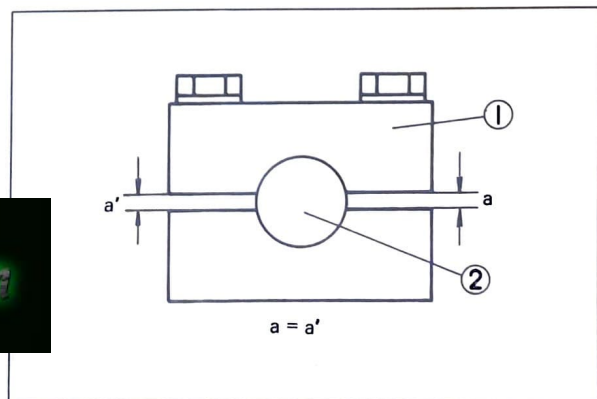
Tightening torque:

0.6 – 1.0 m·kg (4.3 – 7.2 ft·lb)



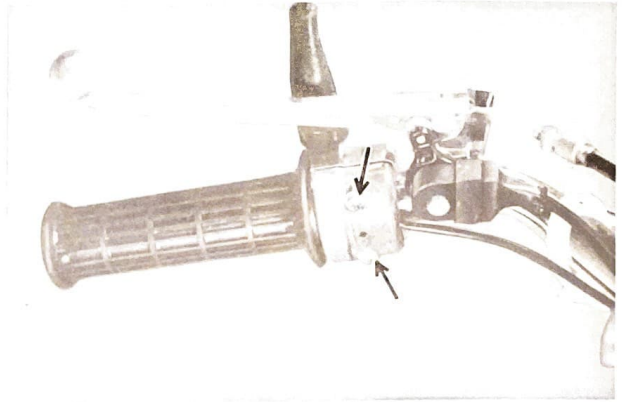
CAUTION:

Tighten bolts in stages and maintain an equal gap on each side of holder.



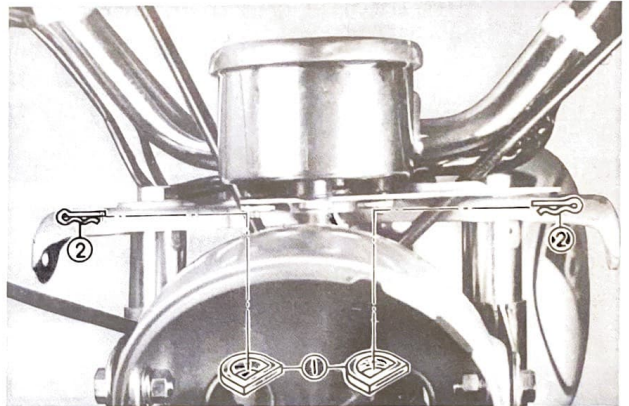
1. Holder 2. Handle bar

10. Slip the throttle grip over the handlebar to the limit and slide it back about 5mm (0.2 in) and assemble the throttle housing using the screws provided.



11. Install the speedometer assembly on the bracket using special washers and clip.

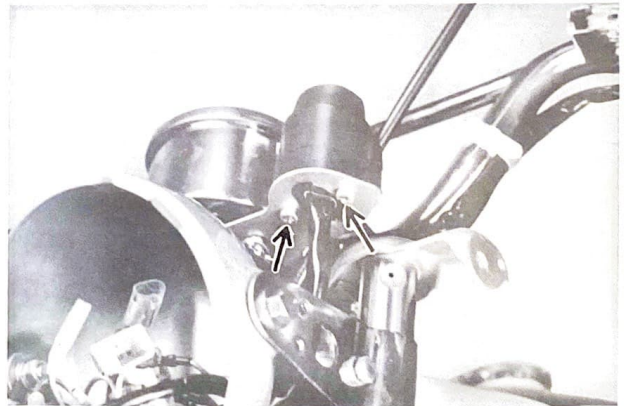
NOTE: _____
Special washers and clip are fitted to speedometer.



1. Special washer

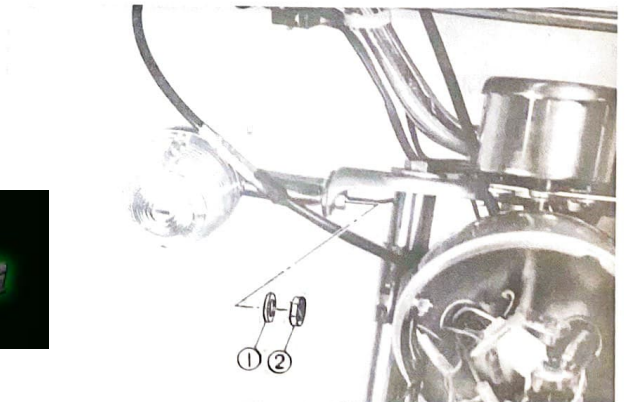
2. Clip

12. Install the main switch on the bracket using two screws.



13. Front flasher light installation.

1) Install the flasher light bracket with 8mm nuts and spring washers.

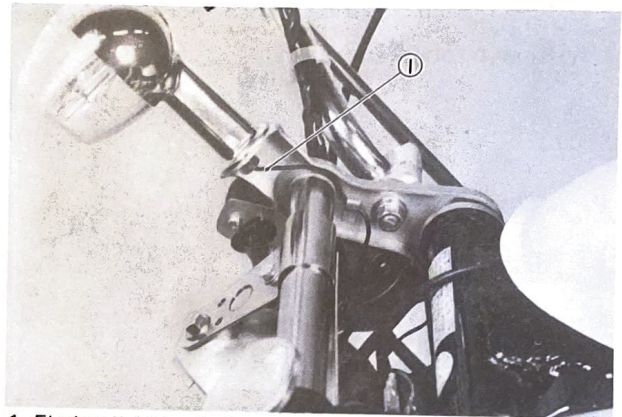


1. Spring washer (o-1-2)

2. Nut (o-1-1)

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2) Bring the flasher light lead wire into the headlight body through the clamp (behind the front fork).

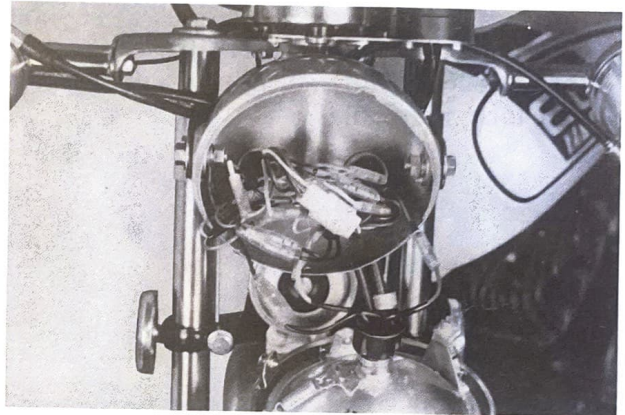


1. Flasher light lead wire

14. Connect all lead wires inside the headlight body. The wires of identical colors should be connected.

NOTE: _____

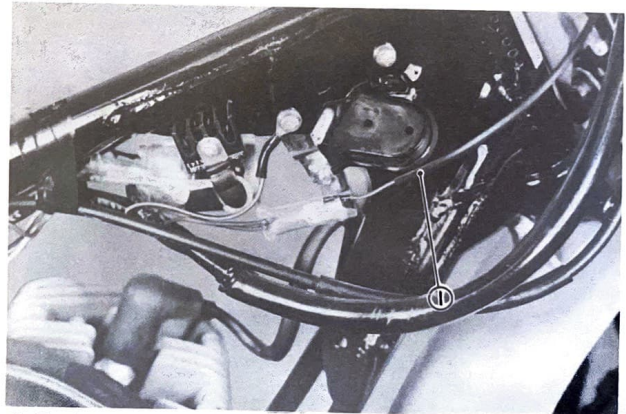
Right flasher light lead wire → Dark green
Left flasher light lead wire → Dark brown



15. Connect the engine stop switch lead wire (coming from the engine stop switch) to the lead wire (black/white) coming from the magneto in the connector.

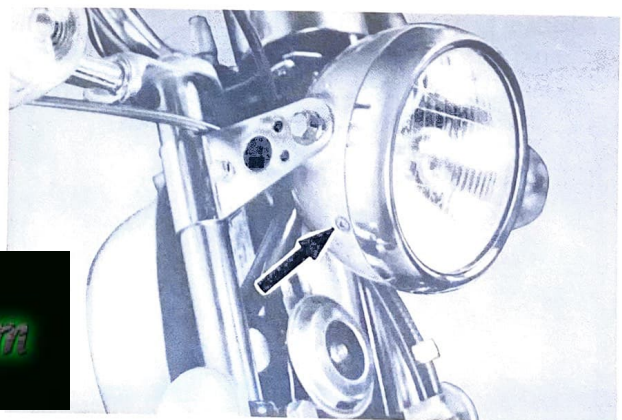
NOTE: _____

Before connecting the engine stop switch cord wire, fuel tank should be removed.

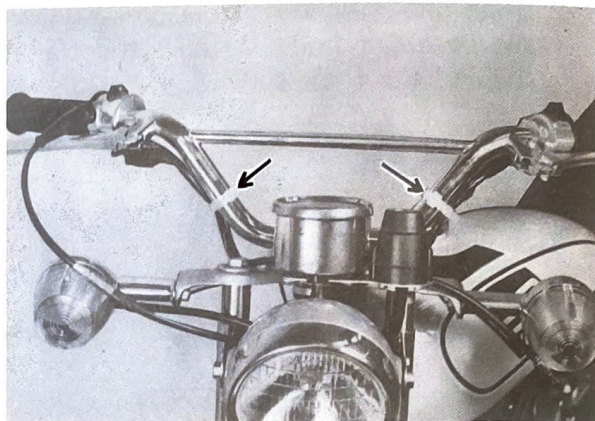


1. Engine stop switch lead wire

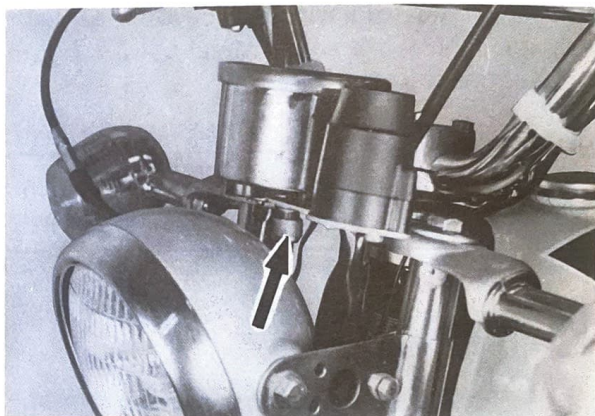
16. When installing the headlight lens assembly, care should be used so that wires are not pinched. Secure the headlight assembly in place with the phillips head screw.



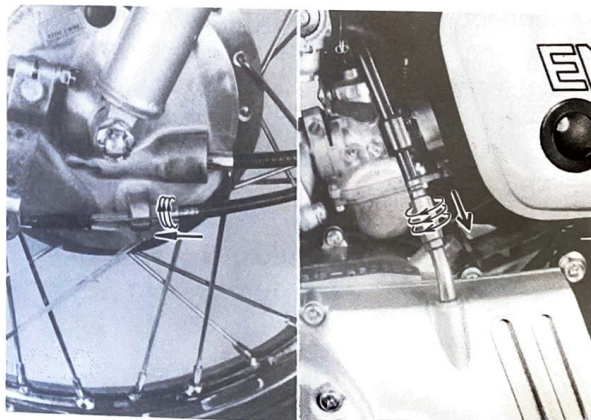
17. Hold the all lead wire to the handlebars with a rubber band.



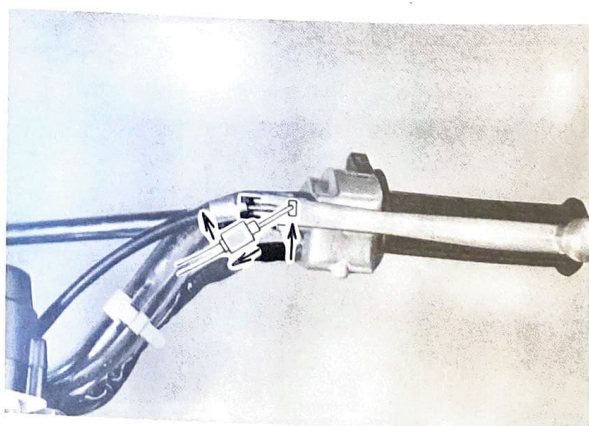
18. Connect the speedometer cable to the speedometer joint. Insert the cable end into the gear unit, turn the holding nut, and lock the cable.



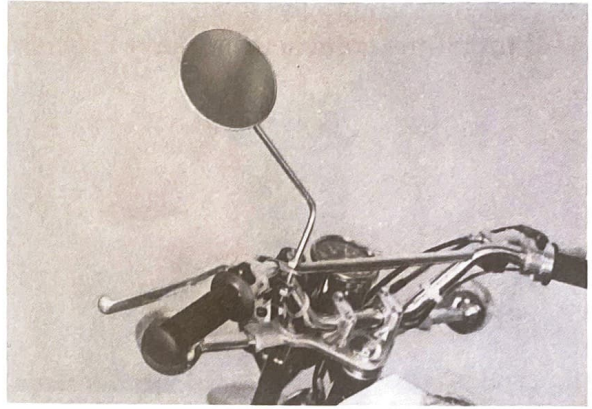
19. Brake wire and clutch wire installation.
1) Full loosen the adjuster lock nut, and screw in the adjuster until tight.



2) Insert the wire end into the lever hole, and hook the outer cable end onto lever holder.

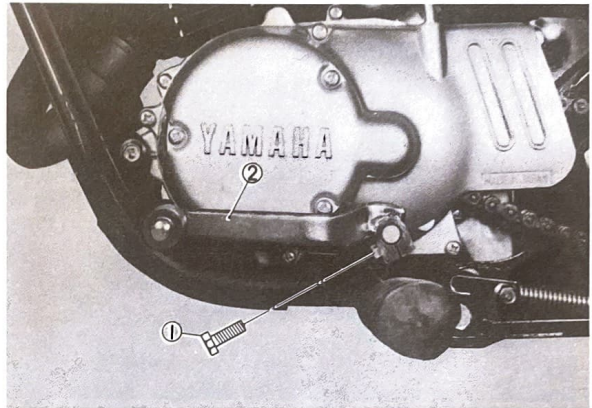


20. Install the rear view mirror on the handle-bar, and tighten the lock nut.



21. Install the change pedal to the change axle and secure the change pedal using 6 mm bolt.

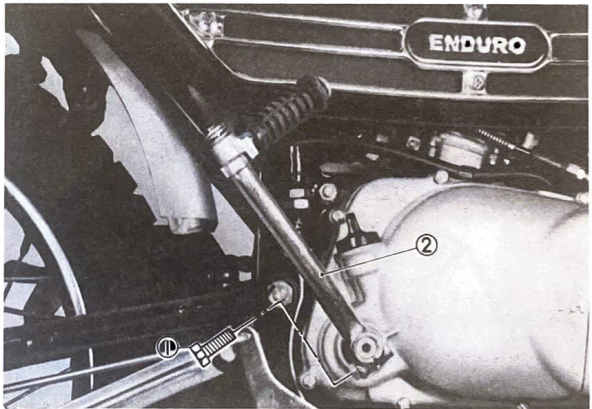
Tightening torque:
0.6 – 1.0 m·kg(4.3 – 7.2 ft·lb)



1. Bolt (n-5) 2. Change pedal (c)

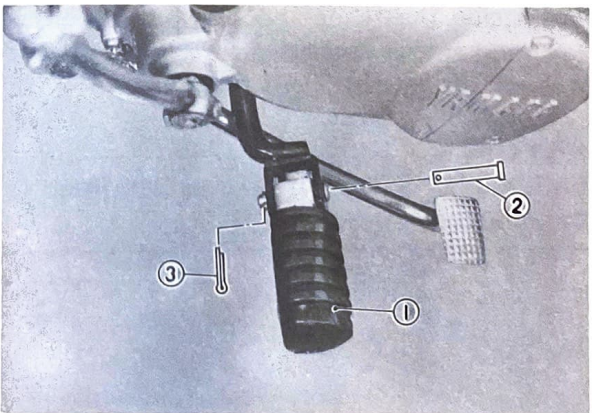
22. Install the kick crank to the kick axle and secure the kick crank using 6 mm bolt.

Tightening torque:
0.6 – 1.0 m·kg(4.3 – 7.2 ft·lb)



1. Bolt (n-4) 2. Kick crank (f)

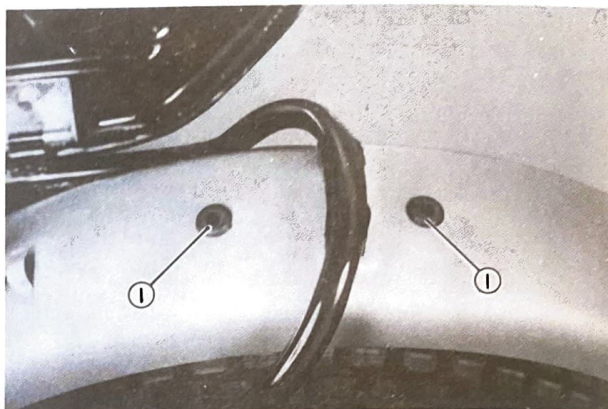
23. Install right side foot rest using clevis pin and cotter pin.



1. Foot rest (h) 2. Clevis pin (n-2)
3. Cotter pin (n-3)

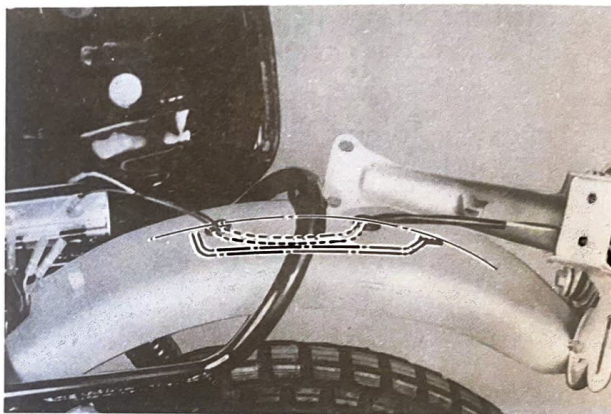
24. Taillight assembly installation

1) Install the grommets on the rear fender.

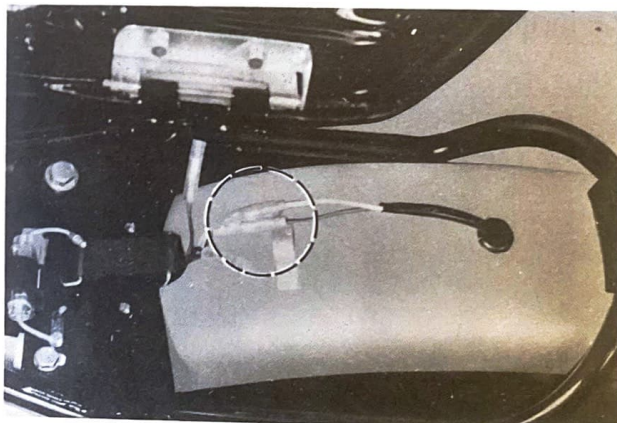


1. Grommet (o-1-3)

2) Thread the wire harness through the fender grommet.



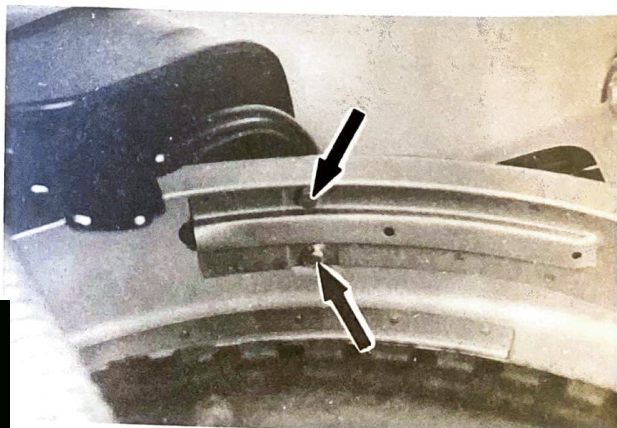
3) Connect the taillight lead wire to the wire harness, and lock it with the hook. (The wires of identical color should be connected.)



4) Using the fender holding bolts, washers and spring washers secure the front part of the tail/stoplight bracket to the rear fender.

NOTE:

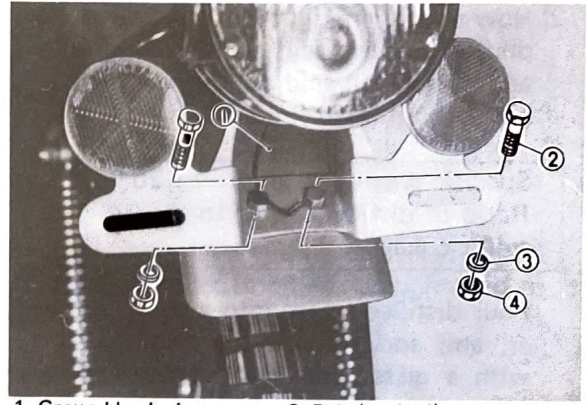
Bolt, washer and spring washer are fitted to the tail/stoplight bracket.



- 5) Using the bolts, spring washers and nuts secure the rear part of the tail/stoplight bracket to the fender.

NOTE: _____

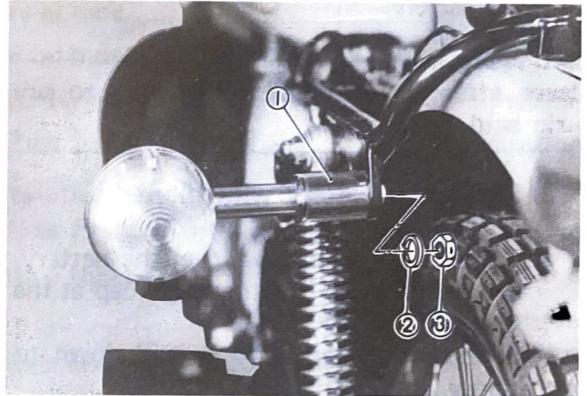
In this time, install the Tail/stoplight ground lead wire together with right side bolt.



1. Ground lead wire 2. Bolt (o-1-4)
3. Spring washer (o-1-6) 4. Nut (o-1-5)

25. Rear flasher light installation

- 1) Install both flasher light assembly and collar by aligning with the locating pin.

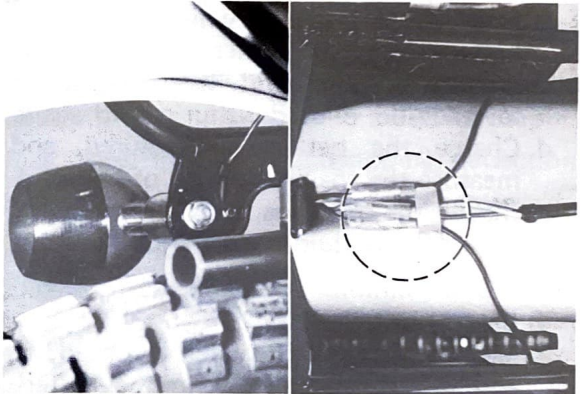


1. Flasher collar (L) (o-4) 2. Spring washer (o-6)
3. Nut (o-5)

- 2) Thread the flasher lead wire through the clamp, then connect the flasher lead wires to the wire harness on the rear

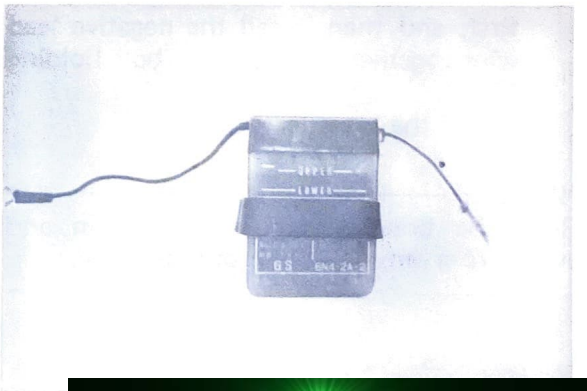
NOTE: _____

Right flasher light lead wire
→ Dark green
Left flasher light lead wire
→ Dark brown



26. Battery

- 1) When filled with diluted sulfuric acid (electrolyte), this battery can be put into use immediately. That is, it is a dry-charged battery. It is advisable, however, that the battery be charged as much as possible before using for the first time for maximum performance. This initial charge will prolong the life of the battery.



charging current	0.2A
charging hours	10 hours.

- 2) How to prepare diluted sulfuric acid. The diluted sulfuric acid can be prepared by adding sulfuric acid to distilled water at a specific mixing ratio.

Specific gravity at 20°C – 1.26
Ratio of distilled water to
sulfuric acid – 3.2

Pour distilled water into a glass container, and add sulfuric acid while stirring with a glass stick. Adding the acid will generate heat, and therefore, care should be taken so that heat does not rise excessively.

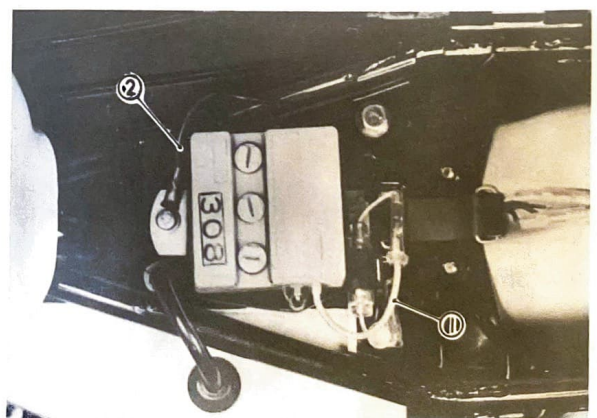
CAUTION: _____
Never attempt to add distilled water to sulfuric acid.

- 3) Filling the battery with diluted sulfuric acid
- Remove all filler caps from the battery, and remove the breather pipe cap at the same time.
 - Cool the diluted sulfuric acid down to below 30°C (86°F)
 - Pour diluted sulfuric acid into each cell little by little up to the upper level line, and leave it for a while. When the battery fluid permeates the plates and separators, the fluid level begins to lower. Add diluted sulfuric acid again.
 - Charge the battery as required, and measure the specific gravity of the fluid.
 - Install the filler caps, and thoroughly wipe off the fluid around the filler caps.

4) Battery installation

- Make sure the main switch is turned off, and install the battery in the battery box. (Secure the battery with a band.) Connect the positive lead wire (Red) first, and then install the negative lead wire together with battery box holding screw.
- Install the breather pipe.

NOTE: _____
Rout the breather pipe outlet down and away from any part of the machine.



1. Positive lead wire (Red) 2. Negative lead wire (Black)

INSPECTIONS

Inspections

After all packed parts are installed, check to see that all these parts and other parts (mounted or installed at the Yamaha factory) are correctly mounted or installed, or tightened to specification. This check-up should be started with the front of the machine.

Item

Front wheel spokes.....Tension	Seat Mounting, clevis pin
Front wheel rimHopping, deflection	Fuel tank Mounting
Front wheel tire Tire pressure	Fuel pipeConnection
Front wheel axle nut	Battery Mounting, fluid level, wiring
..... Cotter pin, tightening torque	Rear fender Mounting
Front wheel axle pinch bolt:	Taillight Mounting, wiring
..... Tightening torque	Rear flasher light Mounting, wiring
Front fork pinch bolts.....Tightening torque	Rear shock absorber
Steering head lock nut Tightening torque Mounting, tightening torque
Handlebar holder Tightening torque	Rear swing arm pivot shaft
Front flasher light Mounting, wiring Tightening torque
Throttle housing	Rear axle nut
..... Position, operation, tightness Cotter pin, tightening torque
Engine mounting bolts Tightening torque	Chain puller Lock nut
Carburetor joint(s) Tightness	Real wheelSpoke tenisin
Footrests Position, tightening torque	Rear wheel rimHopping, deflection
Change pedal	Rear wheel tire Tire pressure
..... Position, looseness, operation	Transmission oil Oil level
Brake pedal	Engine oil Oil level
..... Position, looseness, operation	



This concludes the assembly portion however, the unit must still be "SET-UP" for delivery to the customer.

For specifications regarding ignition timing, carburetor adjustment, tire pressures, engine oil type and quantity, etc....

Refer to appropriate section of GT80B/GTMXB SERVICE MANUAL.

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