



YAMAHA

YZ 125C

ASSEMBLY MANUAL



90894-07517

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.

YAMAHA YZ125C ASSEMBLY MANUAL

**1st Edition, January 1975
OVERSEAS SERVICE DEPARTMENT
YAMAHA MOTOR CO., LTD.
IWATA, JAPAN**

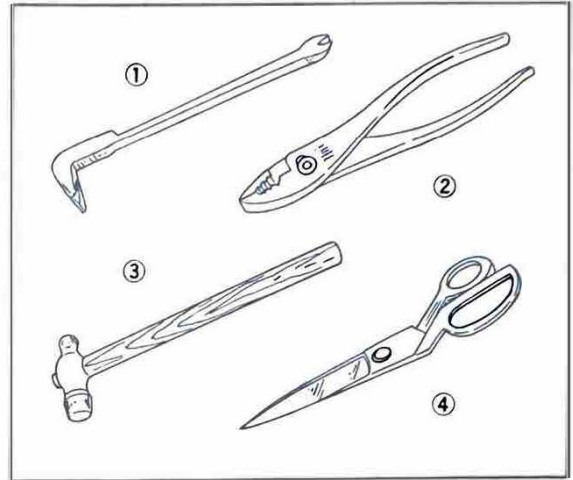
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PREPARATION

To assemble the machine correctly, the following service tools, greases and working space are required.

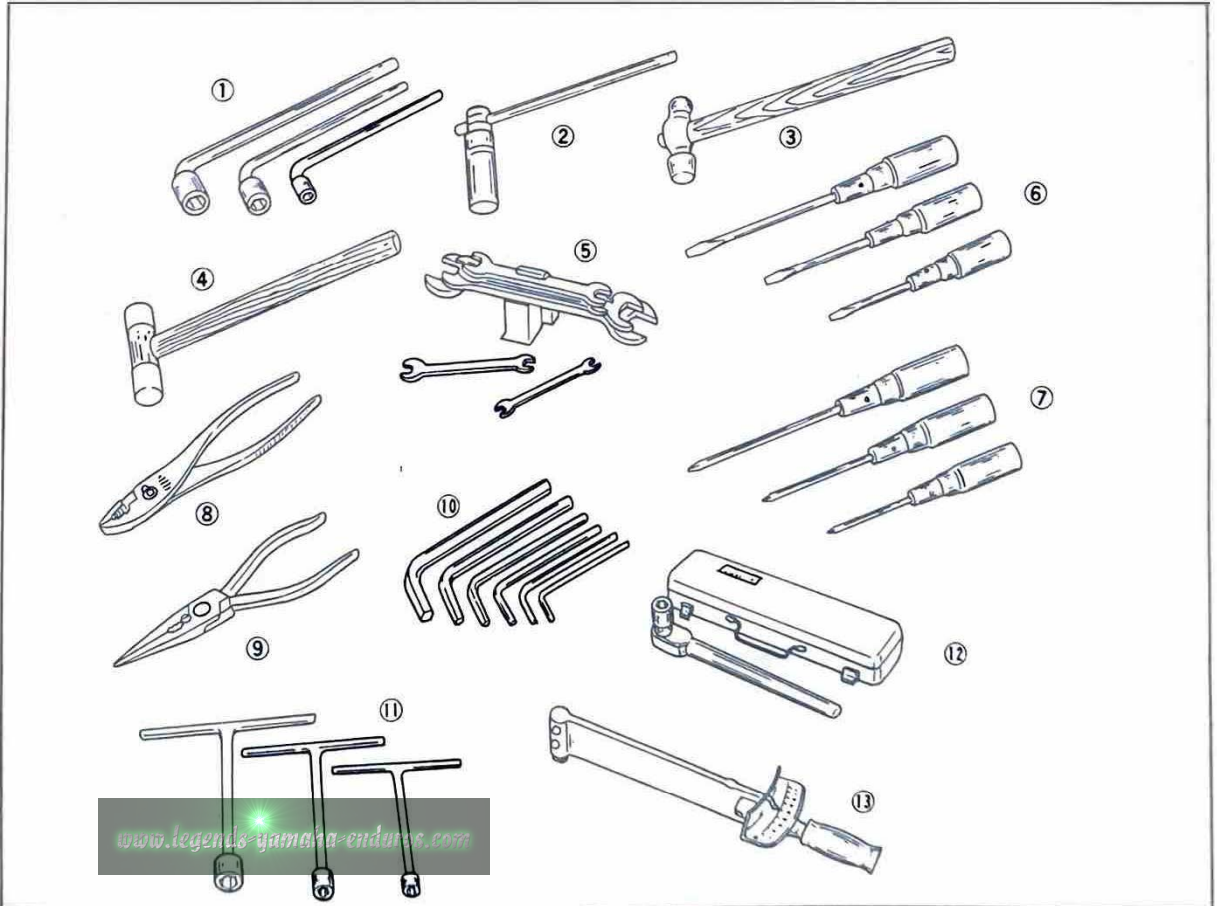
Tools for unpacking

1. Nail puller
2. Pliers
3. Steel hammer
4. Scissors



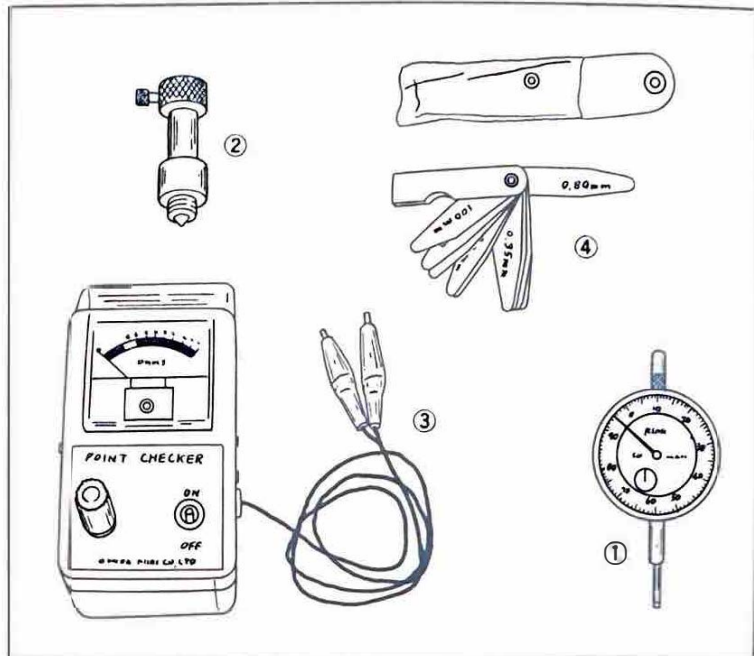
Tools for assembling

1. L-handle socket wrench
2. Spark plug wrench
3. Steel hammer
4. Soft faced hammer
5. Open end wrench set
6. Slotted head screwdrivers (Large, Medium and Small)
7. Phillips head screwdrivers (Large, Medium and Small)
8. Pliers
9. Long nose pliers
10. Allen wrench set
11. T-handle socket wrench
12. Socket wrench set
13. Torque wrench



Special tools

1. Dial gauge
2. Dial gauge holder
3. Point checker
4. Thickness gauge



TORQUE SPECIFICATIONS

The following torque specifications must be adhered to on every machine. Some items with several fasteners should be torqued down in a criss-cross pattern in successive stages until torque specification is reached. The method is similar to installing an automobile wheel and will avoid warping the component.

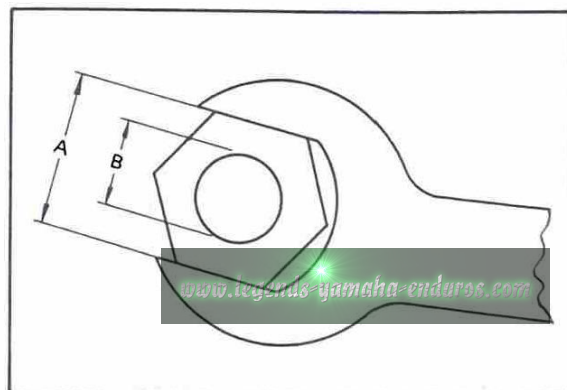
Torque settings are for dry, clean threads. Torquing should always be done to the nut, never to the bolt head.

NOTE:

Certain items with other than standard thread pitches may require differing torque. Consult the model Service Manual or distributor if a question arises.

Torque Specifications

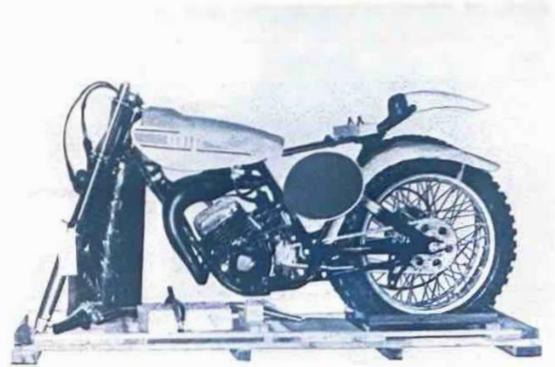
A (Nut)	B (Bolt)	m-kg	ft-lb	in-lb
10 mm	6 mm	1.0	7.2	85
10 mm	7 mm	1.5	11	135
13 mm 14 mm	8 mm	2.0	15	175
17 mm	10 mm	3.5~4.0	20~29	300~350
19 mm	12 mm	4.0~4.5	29~33	350~400
22 mm	14 mm	4.5~5.0	33~36	400~440
26 mm	17 mm	5.8~7.0	42~50	500~600
27 mm	18 mm	5.8~7.0	42~50	500~600
30 mm	20 mm	7.0~8.3	50~60	600~700
SPARK PLUGS		2.5~3.0	18~22	220~260



UNPACKING

Procedure for unpacking

To remove the machine and parts packed in the wooden crosspieces, cut the wire bands around the box using a cutter or scissors. Next, remove the exterior wooden crosspieces.

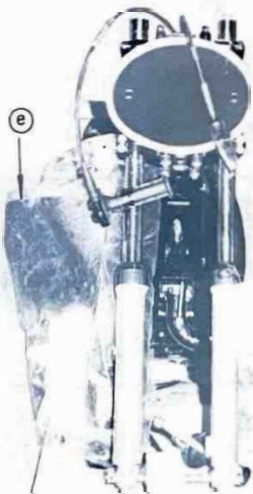
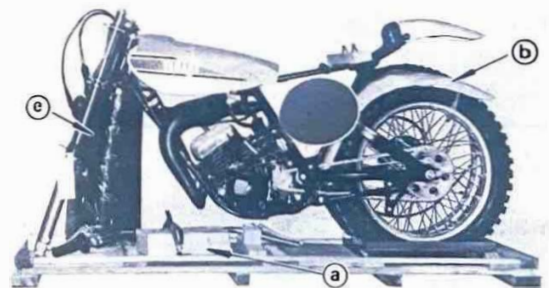
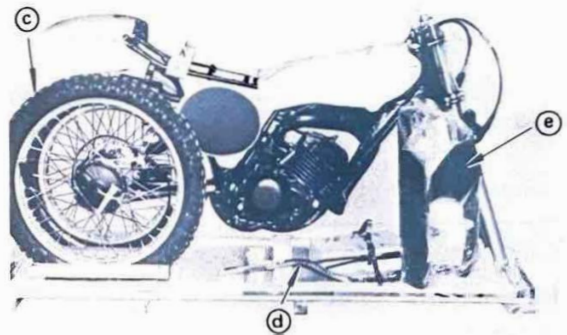


PARTS CHECK LIST




Before starting the assembly, check for damaged or missing. Also check the machine for damage, scratches and other defects.

Check list





Set position	Parts name	Q'ty
a	Carton box	1
b	Front fender	1
c	Front wheel	1
d	Handlebar assembly	1
e	Semi double seat	1



Details of Parts in the carton box 'a'

No.	Photo	Parts name	Q'ty	Remarks
a-1		Owner's manual	1	
a-2		Tool set	1	
a-3		Vinyl bag	1	

Details of Parts in the Vinyl bag 'a-3'

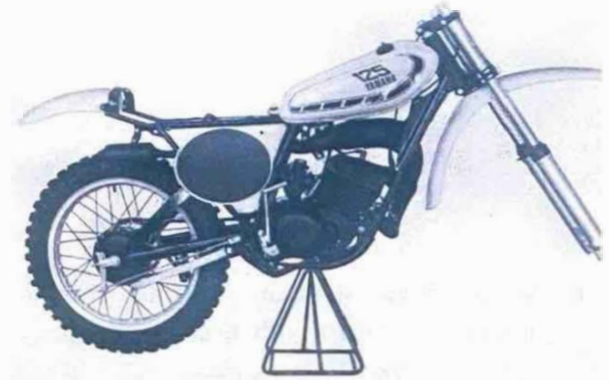
No.	Photo	Parts name	Q'ty	Remarks
a-3-1		Cotter pin	1	For front wheel axle nut
a-3-2		Bolt (M8)	1	For left side footrest
a-3-3		Bolt (M6) with plain. spring washer	2 sets	For semi double seat
a-3-4		Footrest	1	For left side

SET-UP PROCEDURES

1. Remove the front fender held between the rear tire and the rear fender. Next, remove the front wheel.

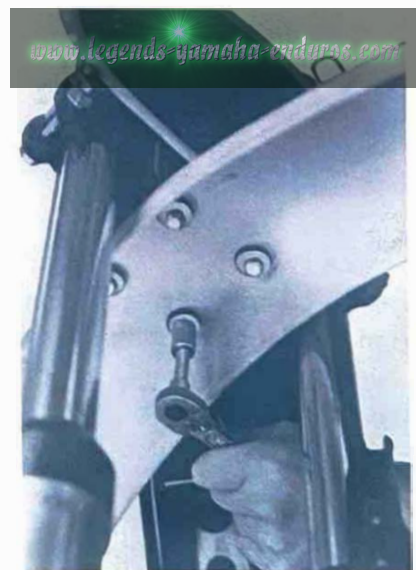


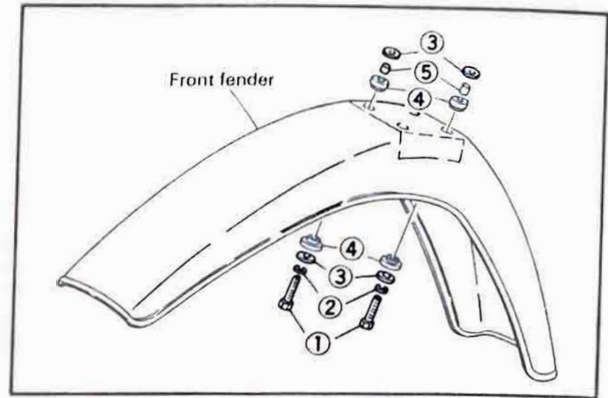
2. Lift up the motorcycle. Then take out the rear wheel from the lower wooden case.
3. Place a suitable support under the engine. This will keep the front of the machine elevated while the front fender and front wheel are installed.



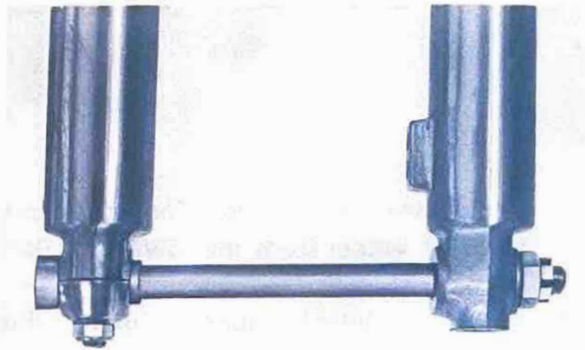
4. Insert the front fender between the front forks, and secure the front fender using bolts (1), spring washer (2), plain washer (3), fender damper (4) and fender collar (5) which are fitted to the under bracket.

Tightening torque:
0.35 ~ 0.55 m·kg
(30 ~ 48 in·lb)

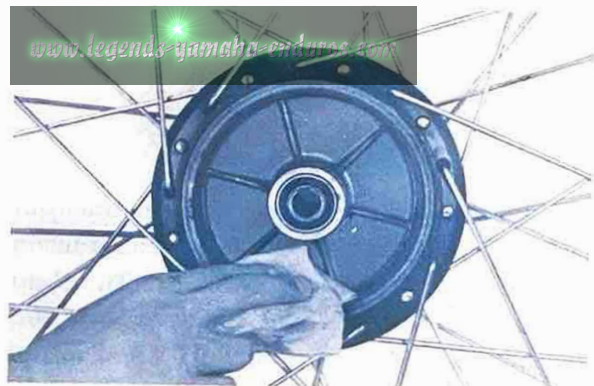




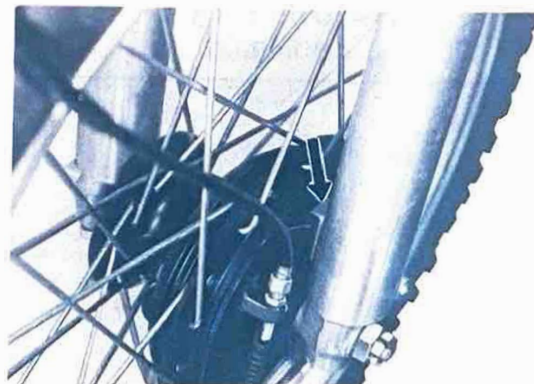
5. Pull out the wheel axle from the front forks.



6. Wipe off any dust on the brake shoe linings and drum with a clean cloth. Then fit the brake shoe plate assembly to the drum.

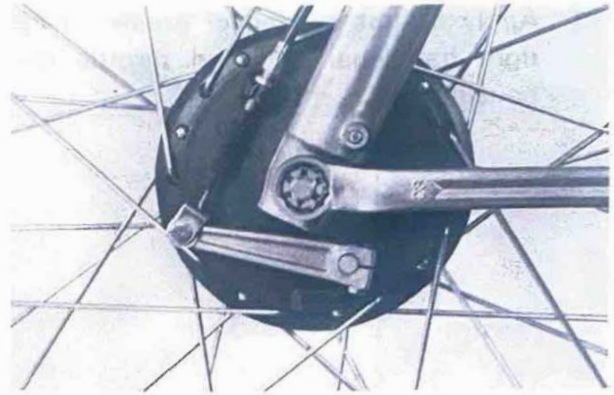


7. Align the stopper (located in the bottom part of the front fork) with the shoe plate groove, and place the front wheel between the front forks. Insert the wheel axle.



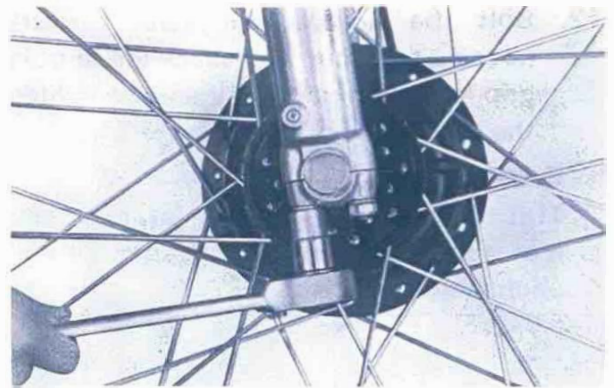
8. Tighten the wheel axle nut with specified torque.

Tightening torque:
7.0 ~ 10.0 m·kg (50 ~ 72 ft·lb)

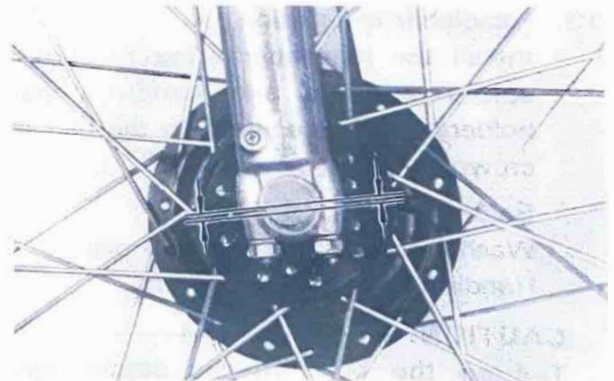


9. Tighten the axle holder nuts with specified torque.

Tightening torque:
0.8 ~ 1.25 m·kg
(70 ~ 110 in·lb)



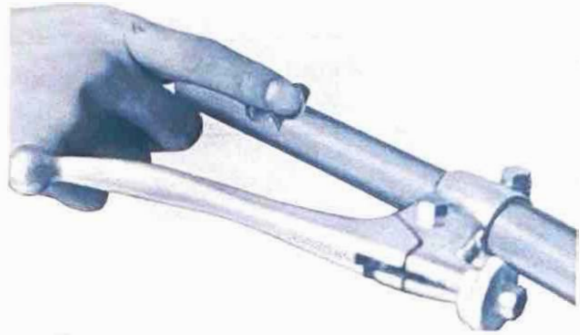
CAUTION: _____
Tighten axle holder nuts in stage and maintain an equal gap each side.



10. Lock the nut with cotter pin. The pin should be inserted downward, and the pin ends should be bent.

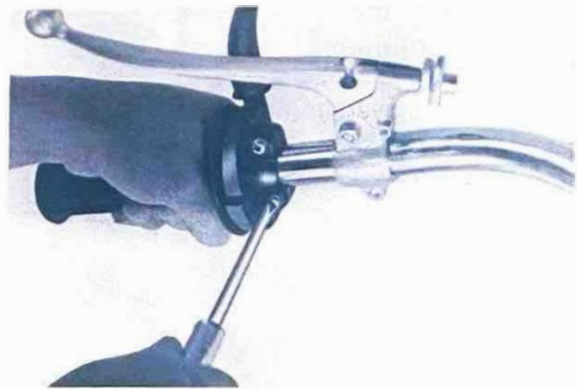


11. Apply a light coating of grease to the right handlebar end and throttle grip housing.



12. Bolt the upper and lower throttle housing together, and check the throttle grip for smooth action, then fully tighten the throttle housing securing screws.

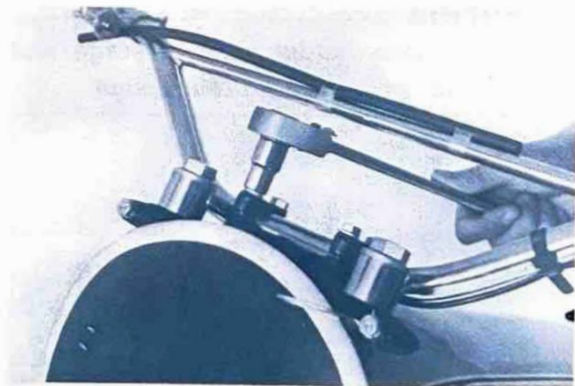
CAUTION: _____
Tighten screws in the stages and maintain an equal gap on each side of each holder.



13. Handlebar installation
Install the handlebar using the bolts, spring washers and handle upper holders which are fitted to the handle crown.

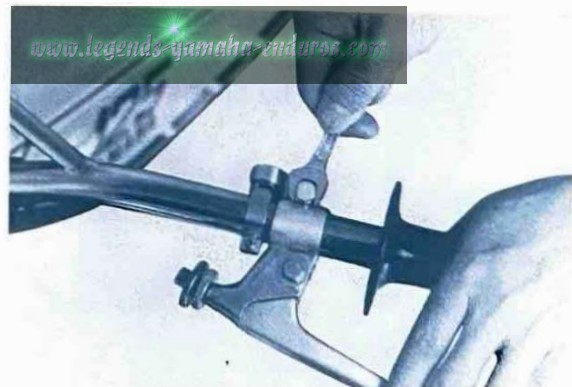
Bolts: (8 mm) × 4 pcs
Washer springs: (8 mm) × 4 pcs
Handle upper holders: 2 pcs

CAUTION: _____
Tighten the bolts in the stages and maintain an equal gap on each side of each holder.



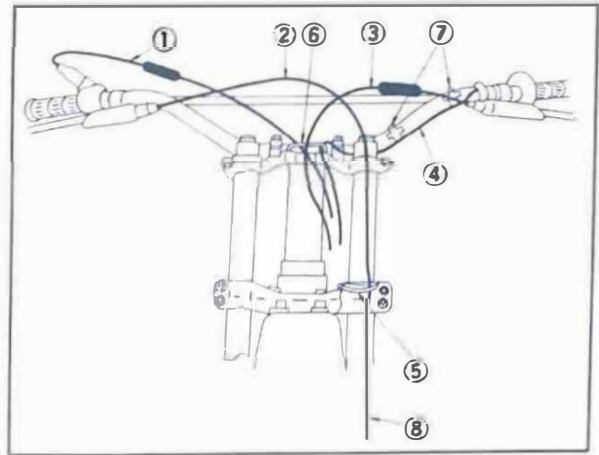
Tightening torque:
1.1 ~ 1.8 m·kg (95 ~ 170 in·lb)

14. Tighten the brake and clutch lever holder 6 mm bolts.



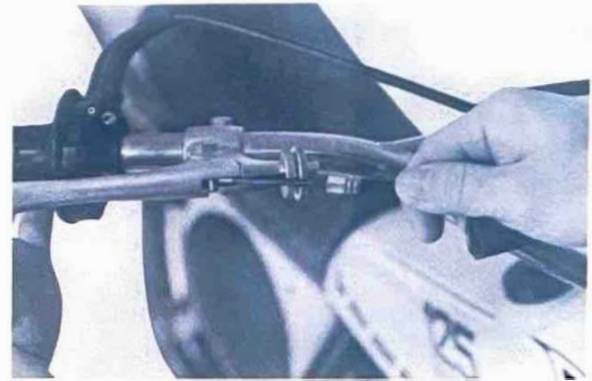
15. For detailed front brake, clutch cable and engine stop switch cord routing refer to illustration.

1. Throttle cable
2. Front brake cable
3. Clutch cable
4. Engine stop switch cord
5. Cable holder (for front brake cable)
6. Wire holder (for throttle cable, clutch cable and switch cord)
7. Switch cord band (for switch cord)
8. From front brake camshaft lever



16. Connect the brake and clutch cable to each lever.

- a. Fully loosen the lever lock nut, and screw in the adjusting bolt until it becomes tight so that the lever lock nut slot is aligned with the adjusting bolt slot. Next, connect the cable end to the lever, and hook up the outer cable to the lock nut. Then, fully pull in the lever, and release it abruptly. At the same time, pull the outer cable quickly. This makes easy the connection of the outer cable to the adjusting bolt.



For detailed cable routing, refer to "CABLE ROUTING DIAGRAMS".

- b. Adjust cable length according to the specification in the model YZ125C Owner's Service Manual.
- c. Cover the holder covers on the brake and clutch lever holders.

17. Connect the engine stop switch cord wire (coming from the engine stop switch) to the lead wire (black/white) coming from the C.D.I. unit assembly in the connector.

NOTE: _____

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



18. Install the footrest assembly.

NOTE:

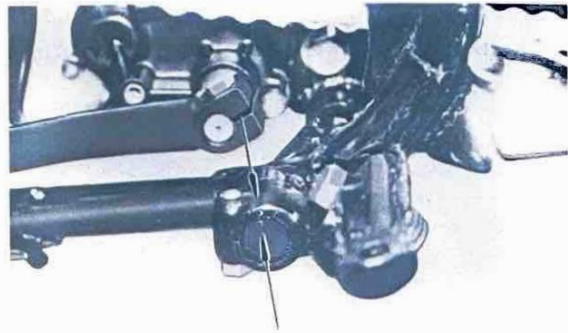
Match the punch mark of the footrest assembly to that of the footrest shaft.

Tighten the securing bolt (a-3-2).

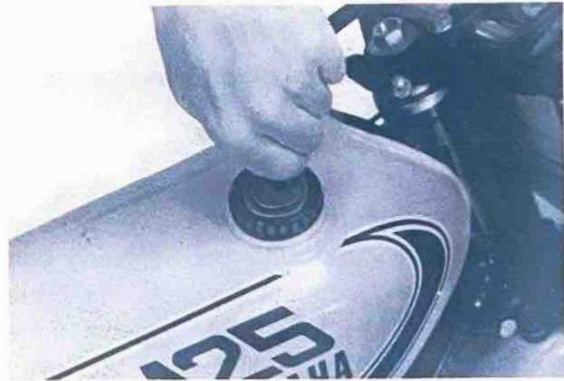
Tightening torque:

1.5 ~ 2.0 m·kg

(135 ~ 175 in·lb)



19. Connect the air breather pipe to the fuel tank cap.



20. Installing the semi double seat
Tighten the securing bolt (a-3-3) after inserting a rear flap to inside the both seat rail.

Tightening torque:

0.35 ~ 0.55 m·kg

(30 ~ 48 in·lb)



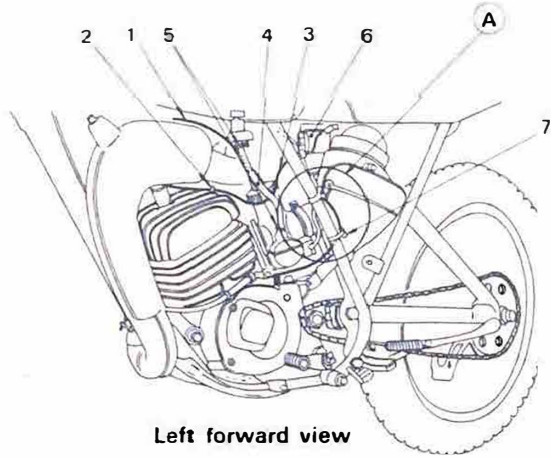
Starting at the front of the unit, inspect the following fittings, mounts, and fasteners for correct installation and fastener torque:

1. Front wheel spoke tightness
2. Front wheel rim deflection and runout
3. Front wheel tire pressure
4. Front wheel axle holder securing nuts
5. Front fork securing bolts
6. Steering head lock nuts
7. Handlebar holder securing bolts
8. Handle lever, and throttle assembly mounts
9. Engine mounting bolts
10. Cylinder head securing bolts
11. Carburetor mounting flange screws
12. Footrest mounts
13. Change pedal securing bolt
14. Brake pedal mount and actuating mechanism
15. Rear fender mount
16. Rear shock (cushion) mounting bolt
17. Rear swing arm pivot securing nuts
18. Rear axle lock nut
19. Chain adjusting bolts and lock nuts
20. Rear wheel spoke tightness
21. Rear wheel rim deflection and runout
22. Rear wheel tire pressure

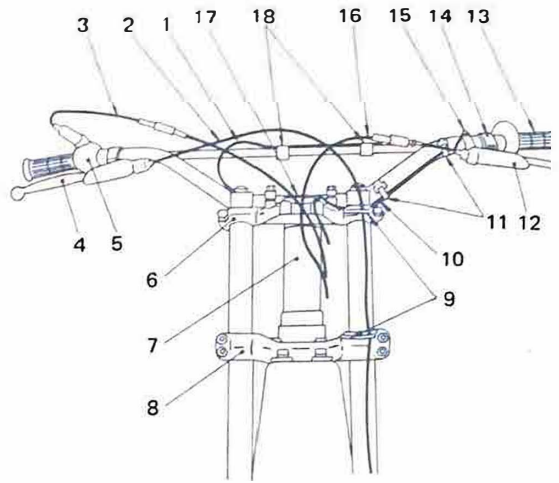
THIS CONCLUDES THE ASSEMBLY PORTION. HOWEVER, THE UNIT MUST STILL BE "SET-UP" FOR DELIVERY TO THE CUSTOMER.

For specifications regarding ignition timing, carburetor adjustment, tire pressures, engine oil type and quantity, etc., refer to appropriate sections of YZ125C Owner's Service Manual.

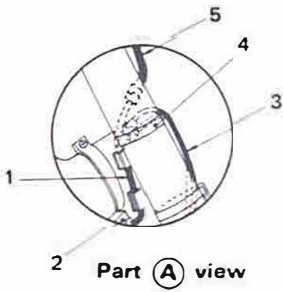
CABLE ROUTING DIAGRAM



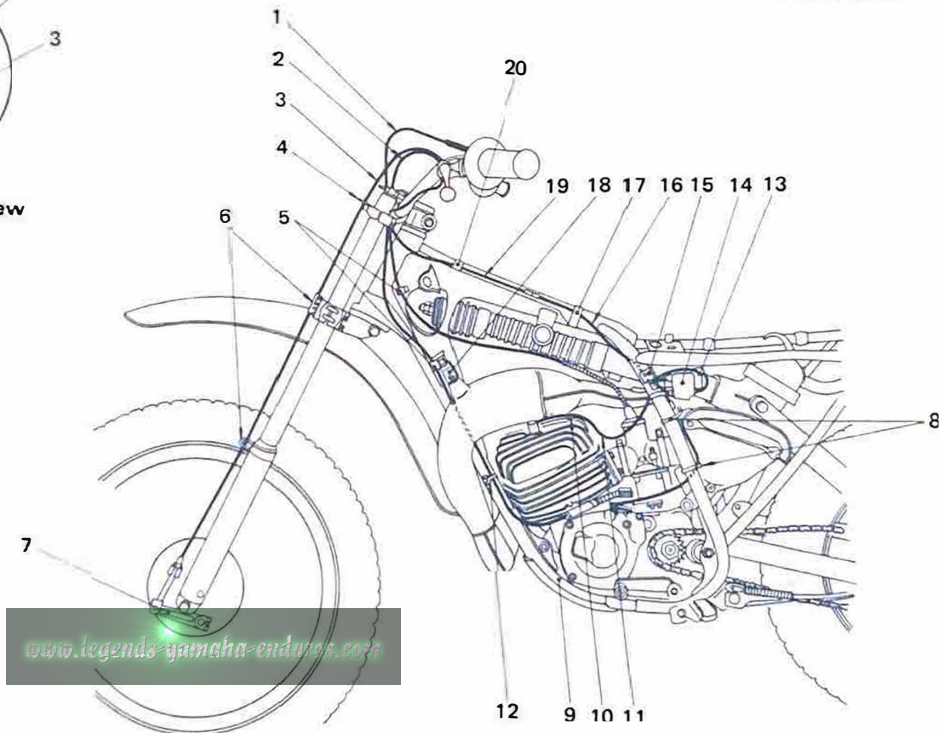
Left forward view



Front view



Part A view



Left side view

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Left forward view

1. Throttle cable assembly
2. Clamp
3. High-tension cord
4. Fuel pipe
5. Clip
6. Ignition coil
7. C.D.I. Unit

Part (A) view

1. C.D.I. Unit wire
2. C.D.I. Unit
3. C.D.I. Magneto wire
4. Band
5. Sub-lead wire

Left side view

1. Throttle cable
2. Clutch cable
3. Front brake cable
4. Cable holder
5. Clamp
6. Cable holder
7. Camshaft lever
8. Band
9. Down tube
10. Absorber
11. High-tension cord
12. Band
13. Clamp
14. Ignition coil
15. Clamp
16. Sub-lead wire
17. Taping
18. Muffler stay
19. Switch cord
20. Clamp

Note:

Clamp the switch cord. some looseness should be allowed on the switch cord even when the steering handle is turned fully to the right.

Front view

1. Breather pipe
2. Front brake cable
3. Throttle cable
4. Lever (R.H.)
5. Grip cap
6. Handle crown
7. Head pipe
8. Under bracket
9. Cable holder
10. Switch cord
11. Band switch cord
12. Lever (L.H.)
13. Grip (L.H.)
14. Lever holder (L.H.)
15. Handle switch
16. Clutch cable
17. Wire holder
18. Taping

1. Throttle cable

Cap grip → Cable holder (above the handle crown) → In front of clutch cable → Left side of head pipe (clamp) → Right side of high-tension cord → Carburetor
(Front view, left side view)

2. Clutch cable

Lever (L.H.) → In front of the front brake cable → Wire holder (above the handle crown) → Left side of head pipe → Muffler stay (clamp) → Under left side of down tube (clamp)
(Front view, left side view)

3. Front brake cable

Lever (R.H.) → In front of clutch cable → Cable holder (left side of handle crown) → In front of number plate → Cable holder (left side of under bracket) → Cable holder (left side of front fork, on outer tube) → Lever camshaft
(Front view, left side view)

4. Handle switch, switch cord

Ahead of lever holder (L.H.) → Clamp on handle (two places) → Wire holder (above the handle crown) → Left side of head pipe → Clamp together with holder wire harness (on main pipe) → Connect to sub-lead wire
(Front view, left side view)

5. High-tension cord

Ignition coil → Upper left side of seat pillar tube (inside) → Left side of throttle cable → Right side of fuel pipe → Clamp the high-tension cord at the absorber on the cylinder head → Spark plug
(Left forward view, left side view)

6. Sub-lead wire

Taping the sub-lead wire on the main pipe after connecting the switch cord → Clamp the sub-lead wire at upper of inside the seat pillar tube (L.H.) after connected to the ignition coil
(Left side view)

7. Breather pipe

Install the breather pipe to the fuel tank cap → Taping the breather pipe on the handle tension bar (two portions)
(Front view)

8. Fuel pipe

Fuel petcock → Left side of high-tension cord → Carburetor
(Left forward view)

9. Breather pipe of transmission oil

Straight down between the cross tube and the engine mounting boss

10. Overflow pipe of carburetor

Straight down between the engine mounting boss and the cross tube

11. C.D.I. magneto wire

Between the seat pillar tube and the air cleaner → Connect the C.D.I. magneto wire to the C.D.I. unit wire (Clamp on the connector of C.D.I. unit wire)
(Part A view, left forward view, left side view)

12. C.D.I. unit wire

Install the C.D.I. unit wire to the clamp on the front left of the air cleaner → Connect the C.D.I. unit wire to the sub-lead wire and the C.D.I. magneto wire.
(Part A view, left forward view, left side view)

- MEMO -

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YAMAHA MOTOR CO., LTD.

IWATA, JAPAN

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