

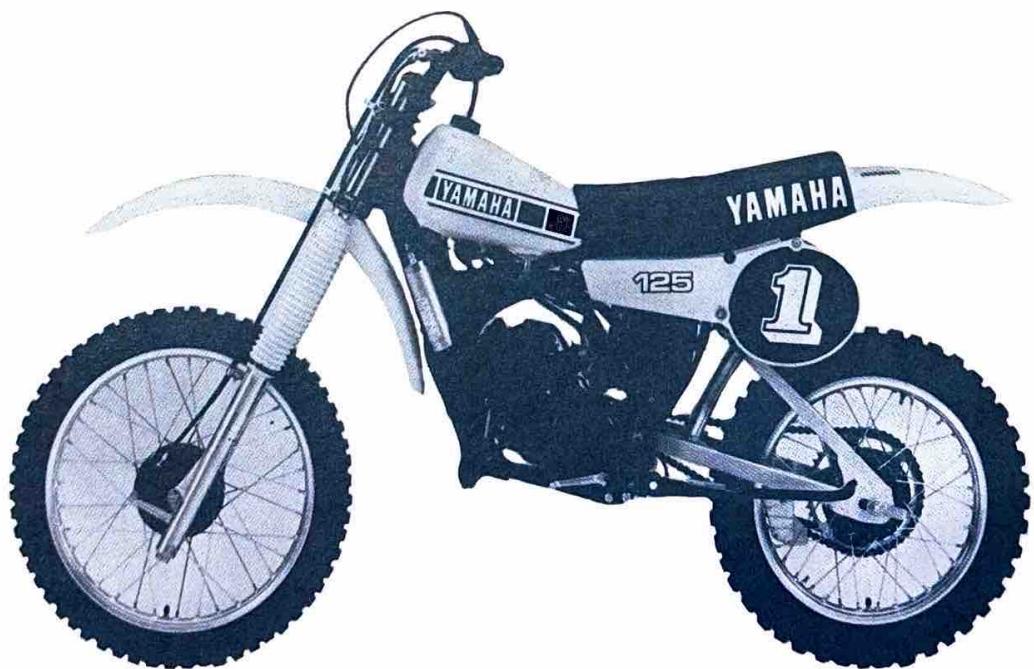


YAMAHA

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YZ125G

ASSEMBLY MANUAL



FOREWORD

This Assembly Manual contains the information required for the unpacking and assembly of Yamaha machines so that the Yamaha serviceman can assemble the machines 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 study the service of Yamaha machines 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. Modifications are inevitable and significant changes in specifications or procedures will be forwarded to Authorized Yamaha dealers. 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 harm to the rider.

CONCERNING CRATE DAMAGE:

Follow the Instructions in the Dealer Warranty Handbook, Procedure Section.

Particularly important information is distinguished in this manual by the following notations:

- NOTE:** A NOTE provides key information to make procedures easier or clearer.
- CAUTION:** A CAUTION indicates special procedures that must be followed to avoid damage to the machine.
- WARNING:** A WARNING indicates special procedures that must be followed to avoid injury to a machine operator or person inspecting or repairing the machine.

YZ125G ASSEMBLY MANUAL

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PREPARATION

To assemble the machine correctly, the following supplies and working space are required.

Supplies

Oils, greases, shop rags, electrical contact cleaner.

Workshop

The workshop where the machine is assembled should be clean and large. The floor should be level.

UNPACKING

Note on transportation

Use caution when transporting the crate to service shop. Do not subject crate to heavy shock.

Procedure for unpacking

To remove the machine and parts packed in the card board 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

Before starting the assembly, check for damaged or missing parts (listed below). Also check the machine for damage, scratches and other defects.

NOTE:

The sizes of bolts, nuts, washers and collars are shown below. The sizes of special parts are indicated in the respective tables.

Parts List A: Foam tray

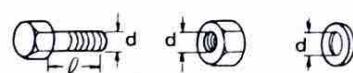
No.	Part name	Q'ty
A-1	Owner's manual	1
A-2	Tool kit	1
A-3	Fuel tank breather pipe	1
A-4	Brake shoe plate assembly	1
A-5	Handlebar assembly	1
A-6	Side cover left	1
A-7	Vinyl bag "1"	1
A-8	Vinyl bag "2"	1
A-9	Air check gauge	1
A-10	Change pedal	1
A-11	Footrest right	1
A-12	Footrest left	1

Parts List B: Carton box

No.	Part name	Q'ty
B-1	Semi double seat	1
B-2	Front fender	1
B-3	Rear fender	1
B-4	Front wheel assembly	1

Parts List C: Vinyl bag "1"

No.	Part name	Q'ty	Remarks
C-1	Plate washer (d = 6 mm (0.24 in))	4	Front fender
C-2	Bolt with washer (d = 6 mm (0.24 in), l = 20 mm (0.79 in))	4	
C-3	Washer (d = 6 mm (0.24 in))	4	
C-4	Cotter pin	1	Front wheel
C-5	Plate washer (d=6mm(0.24in))	2	
C-6	Nut (d = 6 mm (0.24 in))	1	
C-7	Bolt (d = 6 mm (0.24 in), l = 16 mm (0.63 in))	2	
C-8	U nut (d = 6 mm (0.24 in))	2	Rear fender
C-9	Bolt (d = 6 mm (0.24 in), l = 35 mm (1.38 in))	2	
C-10	U nut (d = 6 mm (0.24 in))	2	
C-11	Washer (d = 6.5 mm)	2	
			Semi double seat



SET-UP PROCEDURES



C-8



C-10

C-3

Parts List D: Vinyl bag "2"

No.	Part name	Q'ty	Remarks
D-1	Plate washer (d = 6 mm (0.24 in))	2	
D-2	Bolt with washer (d=6mm (0.24 in), l = 14 mm (0.55 in))	2	Front fender
D-3	Handle upper holder	2	
D-4	Flange bolt (d = 8 mm (0.31 in), l=35mm(1.38 in))	4	Handlebar
D-5	Torsion spring	2	
D-6	U nut (d = 8 mm (0.31 in))	2	Footrest (right)
D-7	Bolt (d=8mm (0.31 in), l = 28 mm (1.10 in))	2	
D-8	Collar	1	Front wheel
D-9	Bolt (d = 12 mm (0.47 in))	1	Footrest
D-10	Flange bolt (d = 10 mm (0.4 in), l = 20 mm(0.79 in))	1	(left)
D-11	Bolt (d = 6 mm (0.24 in), l = 25 mm (1 in))	1	Change pedal
D-12	Plate washer (d = 6.5 mm)	2	
D-13	Panhead screw with washer (d = 6 mm (0.24 in), l = 16 mm (0.63 in))	2	Side cover (left)



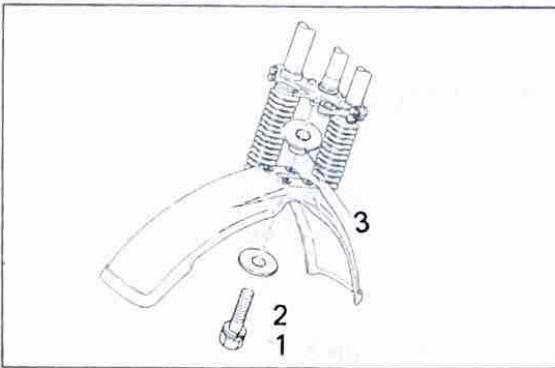
D-3



D-4



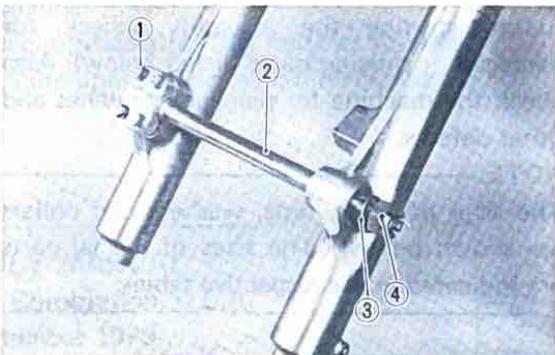
D-6



1. Bolt with washer (C-2) 2. Plate washer (C-1)
3. Washer (C-3)

Tightening torque: 0.6 m-kg (4 ft-lb)

- Loosen the axle holder nuts and remove the front wheel axle nut. Then remove the wheel axle.



1. Axle holder nuts
3. Wheel axle washer
2. Wheel axle
4. Wheel axle nut

- Install the brake shoe plate assembly in the front wheel hub.
 - Clean the inner surface of the front wheel hub with a clean cloth.



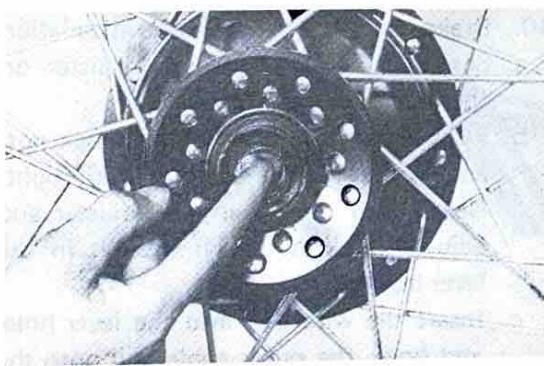
- b. Make sure the brake shoes and springs are correctly installed in the shoe plate assembly. If any one of them is out of position, correct per the figure.



- c. Install the brake shoe plate assembly in the wheel hub.
5. Install the axle collar in the wheel hub on the right side of the front wheel.

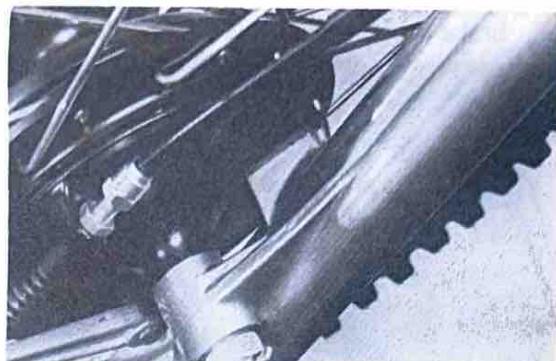
NOTE:

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



6. Install the front wheel on the front forks.
a. Insert the front wheel between the front fork legs so that the stopper (projection)

on the front fork end is correctly engaged the slot in the brake shoe plate.



- b. Insert the axle, and install the axle nut.
c. Torque the axle nut to specification.

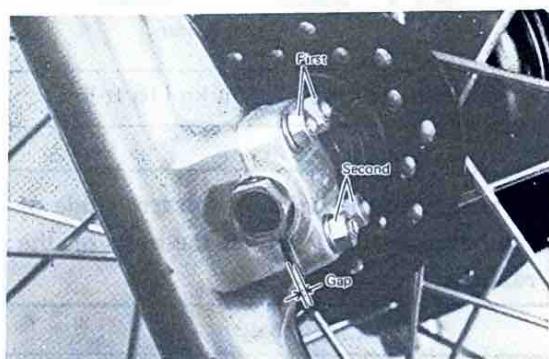
Tightening torque: 8.5 m-kg (60 ft-lb)

- d. Torque the axle holder nuts to specification.

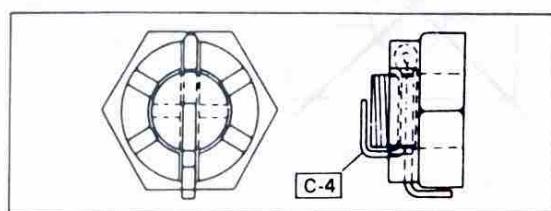
Tightening torque: 1.0 m-kg (7.0 ft-lb)

NOTE:

When tightening the axle holder nut, first tighten the nuts on the upper side of axle holder and tighten the nuts on the lower side.

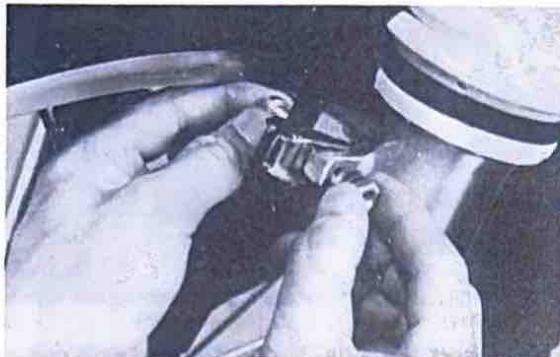


- e. Lock the nut with the cotter pin.
The pin should be inserted downward, and the pin ends should be bent.



7. Brake cable installation

Install the brake cable clamps to the boss on the left front fork leg, then pass the brake cable in the cable guides.



8. Handlebar installation

Install the handlebar using the two handle upper holders and four flange bolts.



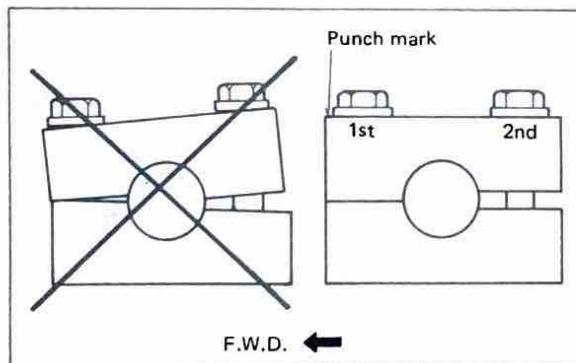
1. Flange bolt

2. Handlebar holder

Tightening torque: 2.3 m-kg (16 ft-lb)

CAUTION:

First tighten the bolts on the front side of the handlebar and tighten the bolts on the rear side.



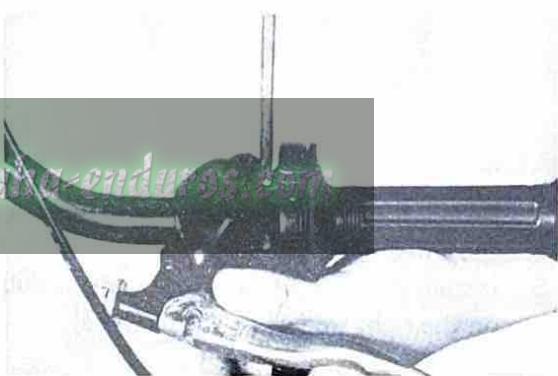
9. Throttle grip installation

a. Remove the screws from the throttle grip housing, then remove the throttle cable.

b. Grease the right end of the handlebar and the throttle grip housing.



c. Install the throttle grip to the handlebar and tighten the screws.



CAUTION:

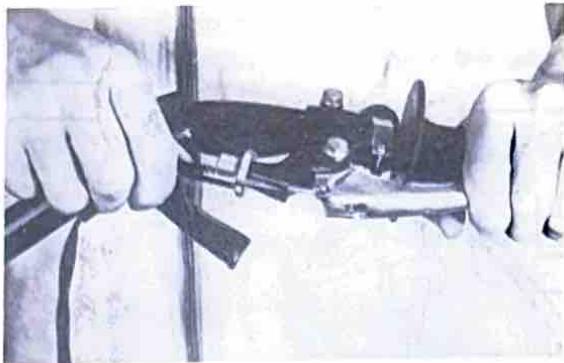
Make certain the throttle rotates on handlebar freely, without binding. If not, normal throttle return will impaired.

10. Brake wire and clutch wire installation

a. Screw in the cable length adjuster on the front brake shoe plate.

b. Fully loosen the lever adjuster lock nut, and screw in the adjuster until tight. Next, align the slit in the adjuster and adjuster lock nut with the slit in the lever holder.

c. Insert the wire end into the lever hole, and hook the outer cable end onto the adjuster lock nut, then squeeze the lever.



Next, while pulling the outer cable in the direction opposite to the lever, release the lever quickly. While releasing it, seat the outer cable into the adjuster.

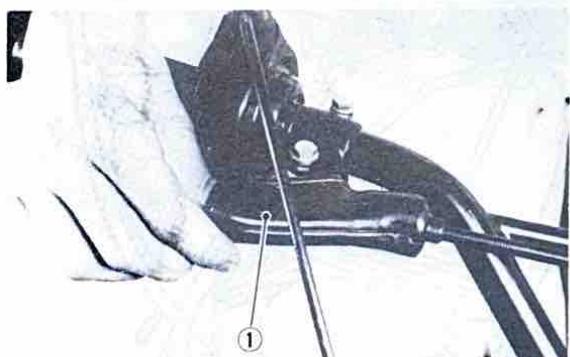
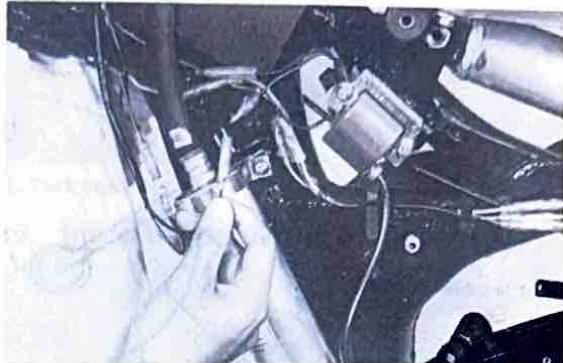


CAUTION:

Proper cable and wire routing is essential to insure safe vehicle operation. For details of the cable routing, refer to "CABLE ROUTING DIAGRAM".

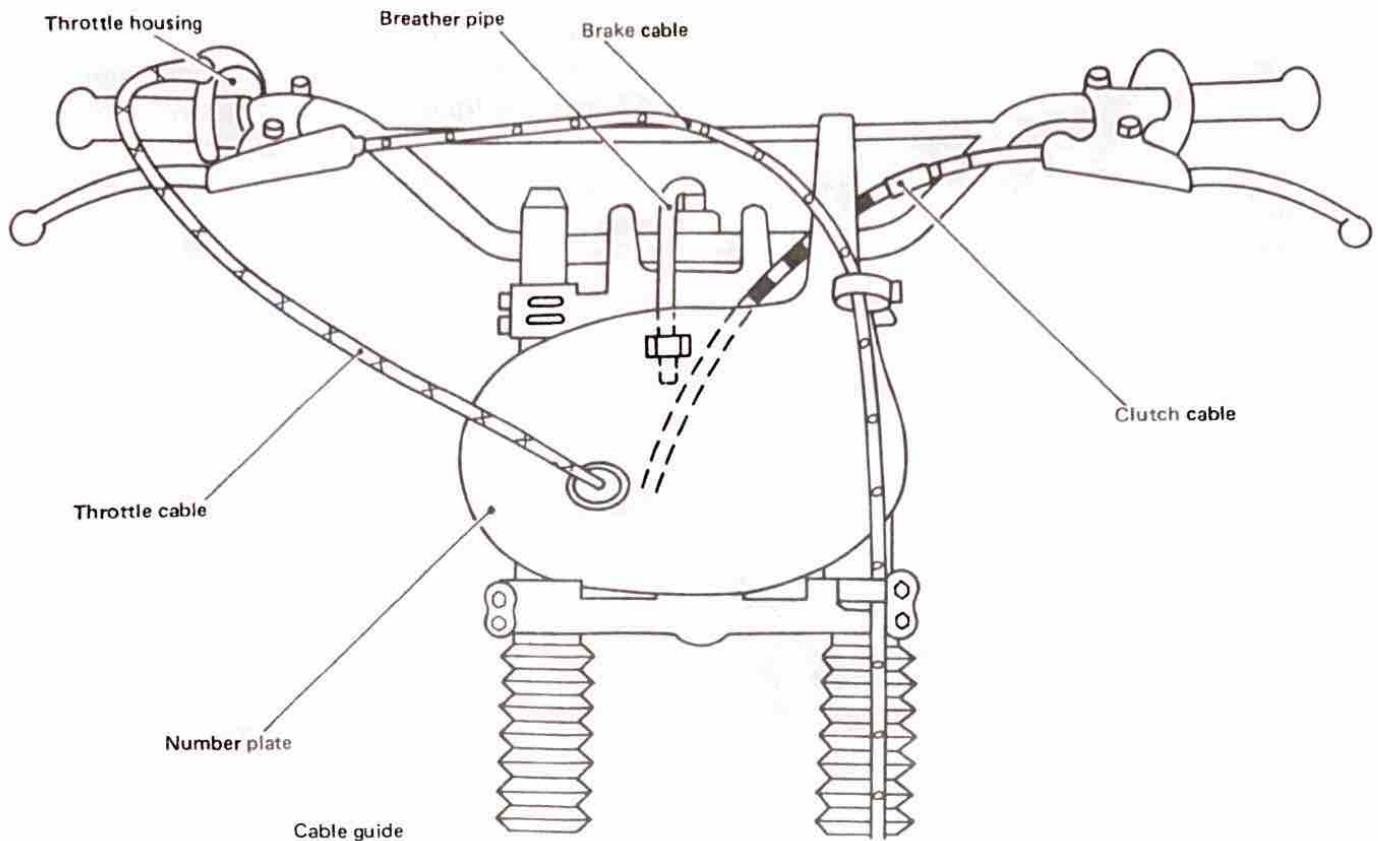
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11. Engine stop switch connection
Connect the engine stop switch lead wire (coming from the engine stop switch) to the lead wire (brake/white) coming from the magneto assembly in the connector.

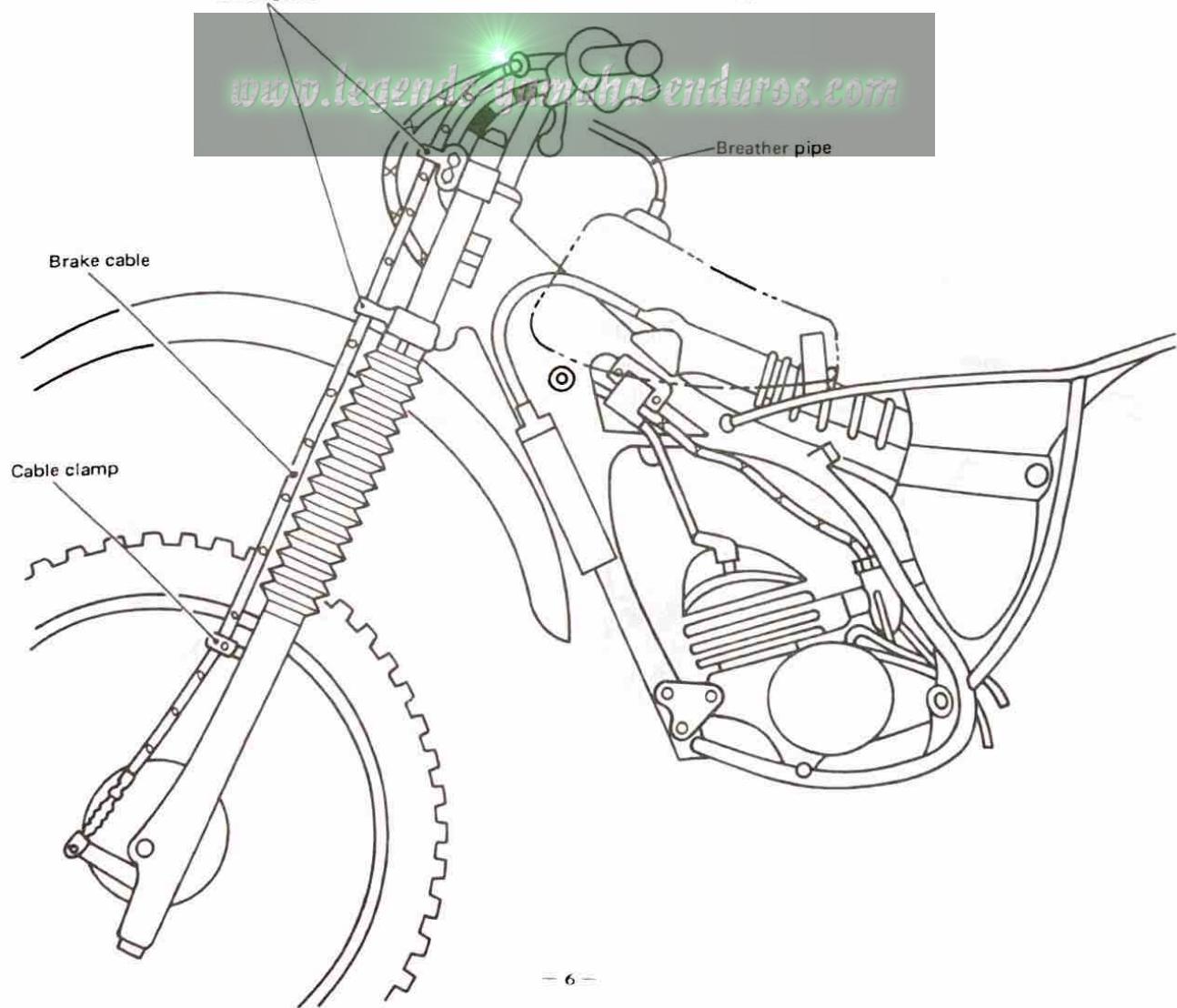


1. Lever cover

CABLE ROUTING DIAGRAM

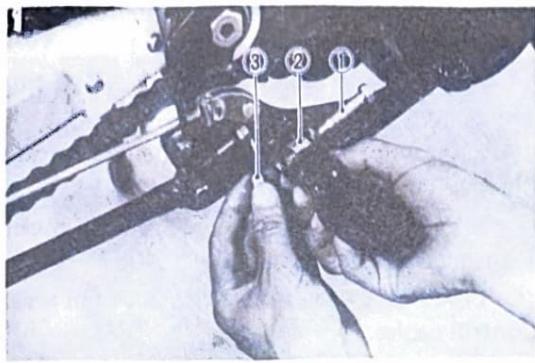


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12. Footrest installation

- Install the right footrest using the bolt, torsion spring and U nut.



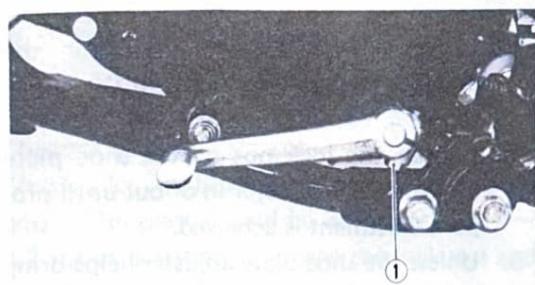
1. Bolt 2. Torsion spring 3. U-nut

- Install the left footrest.

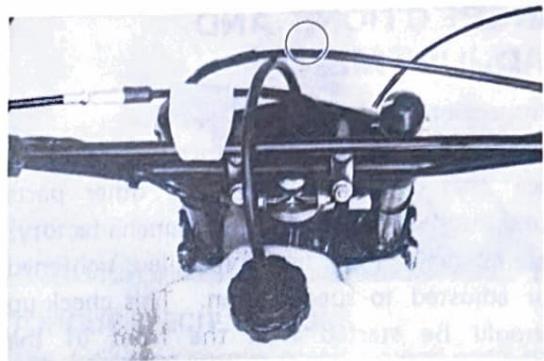


13. Change pedal installation

- Install the change pedal using the hexagon bolt.

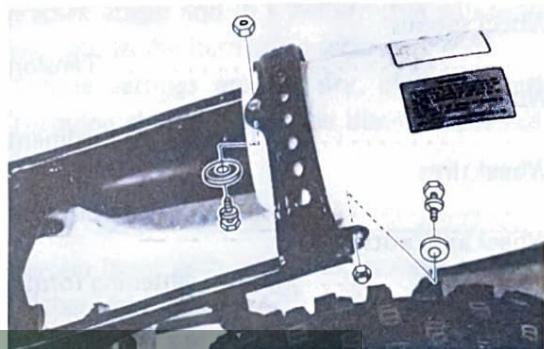


14. Connect the tank breather pipe to the fuel tank cap.

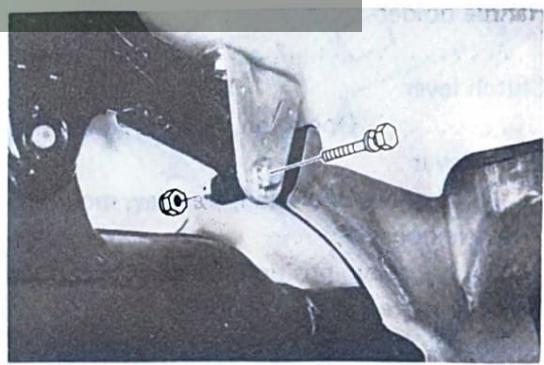


1. Tank breather pipe (A-3)

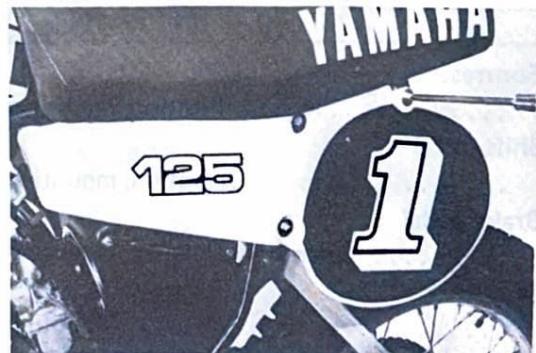
15. Install the rear fender using the bolt.



16. Insert the hook on the end of the seat into the frame, and seat using the bolt.



17. Install the side cover using the panhead screw with washers and plate washers.



INSPECTIONS AND ADJUSTMENTS

Inspection

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, tightened or adjusted to specification. This check-up should be started with the front of the machine.

Item	
Wheel spokes Tension
Wheel rims Deflection, alignment
Wheel tires Tire pressure
Wheel axle nuts Tightening torque
Fenders Mounting
Steering head Operation adjustment
Handle holder Tightening torque
Clutch lever Operation, freeplay, mounting
Brake lever Operation, freeplay, mounting
Throttle housing	... Operation, position, freeplay, mounting
Number plate Mounting
Engine mounting bolt Tightening torque
Carburetor joints Tightness
Footrest Position, mounting
Shift pedal Operation, mounting
Brake pedal Operation, freeplay, mounting
Seat Mounting
Fuel tank Mounting

Fuel pipe

..... Connection, mounting

Fuel breather pipe

..... Connection, routing

Rear shock absorber

..... Mounting, cotter pin

Swing arm pivot shaft

..... Tightening torque

Chain puller

..... Alignment

Transmission

..... Oil level

Control cables

..... Lubrication

Electrical components

..... Operation, adjustment

Adjustment

NOTE:

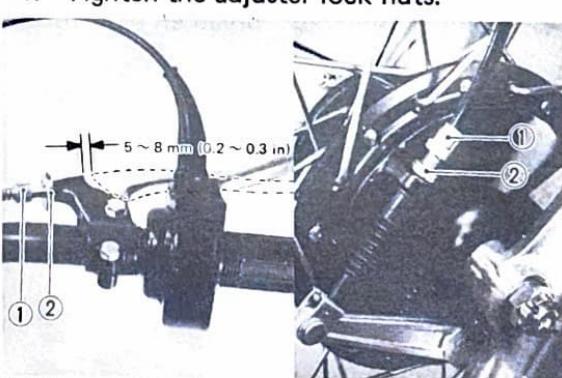
This section deals with the main points only. For details, refer to the YZ125G Owner's Service Manual.

Front brake adjustment

Front brake cable free play can be adjusted to suit rider preference, but a minimum free play of 5~8 mm (0.2~0.3 in) should be maintained.

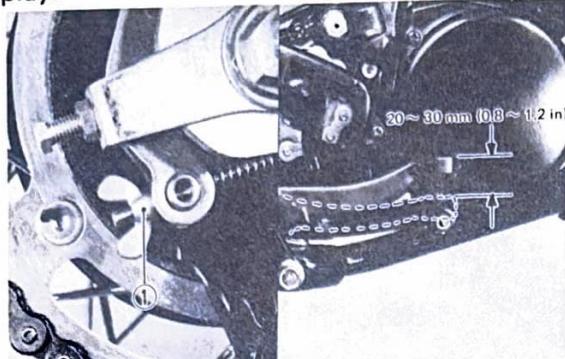
Free play can be adjusted at handle bar lever and brake shoe plate.

1. Loosen the adjuster lock nut on the brake lever holder, fully turn the adjuster in.
2. Loosen the lock nut on the shoe plate and turn the adjuster in or out until proper adjustment is achieved.
3. Unless the shoe plate adjuster helps bring a proper play, turn to the lever holder adjuster.
4. Tighten the adjuster lock nuts.



Rear brake adjustment

The rear brake should be adjusted so the end of the brake pedal moves 20~30 mm (0.8~1.2 in). To adjust, turn the adjuster on the brake rod clockwise to reduce play; turn the adjuster counterclockwise to increase play.

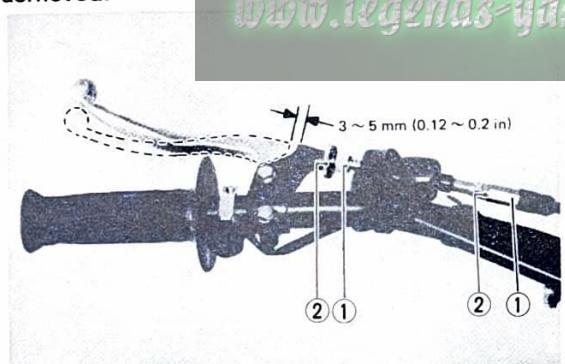


1. Adjuster

Clutch adjustment

Free play adjustment

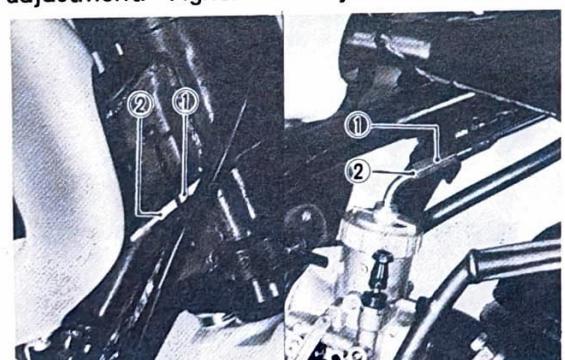
Loosen either the handle lever adjuster lock nut or the cable in-line length adjuster lock nut. Next, turn the length adjuster either in or out until proper lever freeplay is achieved.



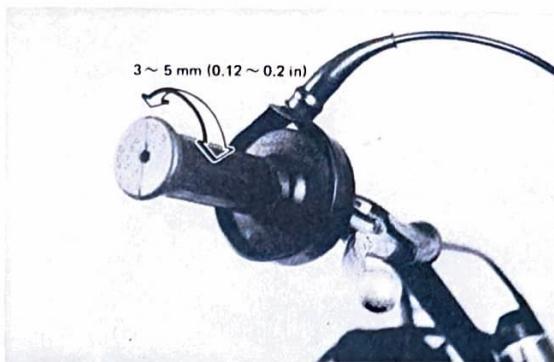
1. Adjuster 2. Lock nut

Throttle cable adjustment

Check play in turning direction of throttle grip. The play should be 3~5 mm (0.12~0.2 in) at grip flange, loosen the lock nut and turn the wire adjuster to make the necessary adjustment. Tighten the adjuster lock nut.



1. Adjuster 2. Lock nut



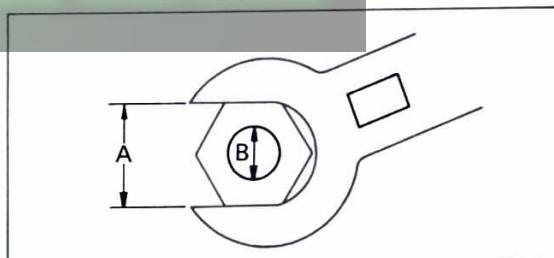
TORQUE SPECIFICATIONS

The following torque specifications must be adhered to on every machine. Components with several studs should be tightened in gradual stages and in a pattern that will avoid warpage to the item being secured.

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

NOTE:

Certain items with other than standard thread pitches may require differing torque. Refer to the Owner's service manual.



A (Nut)	B (Bolt)	General torque specifications	
		m-kg	ft-lb
10 mm	6 mm	0.6	4.5
12 mm	8 mm	1.5	11
14 mm	10 mm	3.0	22
17 mm	12 mm	5.5	40
19 mm	14 mm	8.5	61
22 mm	16 mm	13.0	94

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