

YAMAHA

YZ50G

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.

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.

**YZ50G
ASSEMBLY MANUAL
FIRST EDITION, MAY 1979
OVERSEAS SERVICE DEPARTMENT
YAMAHA MOTOR CO., LTD.
IWATA, JAPAN
LIT-11666-01-73**

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

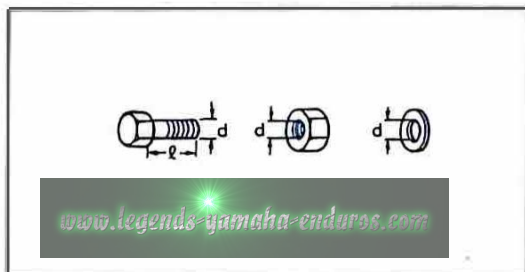
To remove the machine and parts packed in the card board crate, cut the vinyl bands around the box using a cutter or scissors. Next, remove the exterior carton by lifting it straight up.

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.

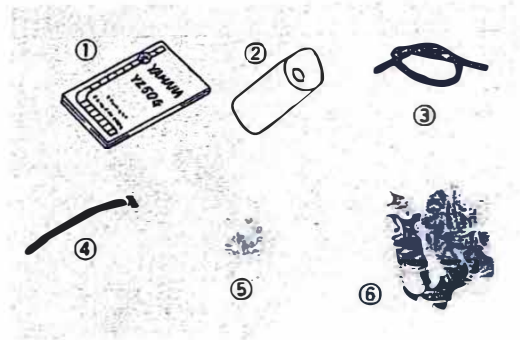
NOTE:

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



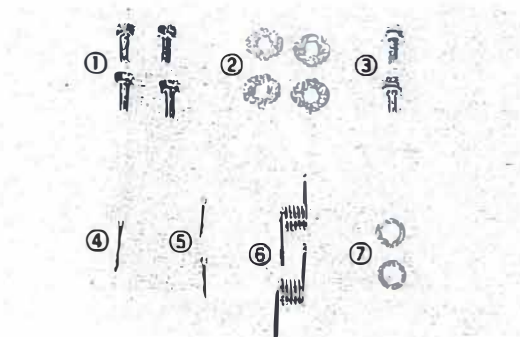
Parts list: Carton box

No.	Part name	Q'ty
1	Owner's manual	1
2	Tool kit	1
3	Tank breather hose	1
4	Switch cord band	1
5	Vinyl bag "A"	1
6	Vinyl bag "B"	1



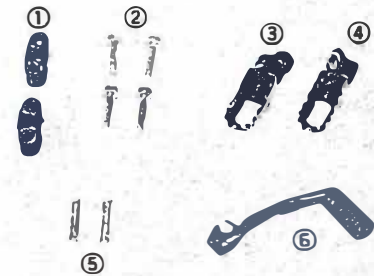
Parts list: Vinyl bag "A"

No.	Part name	Q'ty	Remarks
1	Bolt with spring washer (d = 6 mm (0.24 in), ℓ = 16 mm (0.63 in))	4	Front fender
2	Plate washer (d = 6 mm (0.24 in))	4	
3	Bolt with spring washer (d = 6 mm (0.24 in), ℓ = 16 mm (0.63 in))	2	Seat
4	Cotter pin	1	Front wheel
5	Cotter pin	2	Footrest
6	Torsion spring	2	
7	Washer (d = 8 mm (0.31 in))	2	



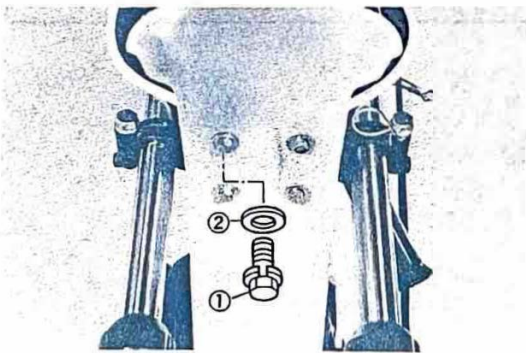
Parts list: Vinyl bag "B"

No.	Part name	Q'ty	Remarks
1	Handle upper holder	2	Handlebar
2	Flange bolt (d=8 mm (0.31 in), ℓ=35 mm (1.38 in))	4	
3	Footrest (L)	1	Footrest
4	Footrest (R)	1	
5	Clevis pin	2	Change pedal
6	Change pedal (Bolt)	1	



SET-UP PROCEDURES

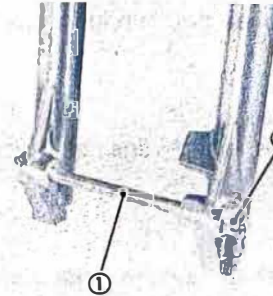
- To install the front fender and front wheel, place a proper-size wooden box or a wooden block under the engine to keep the front of the machine raised off the floor. Take care so that the machine does not fall over.
- Insert the front fender between the front fork legs, and secure the front fender using the bolts with washers and plate washers.



1. Bolt with spring washer 2. Plate washer

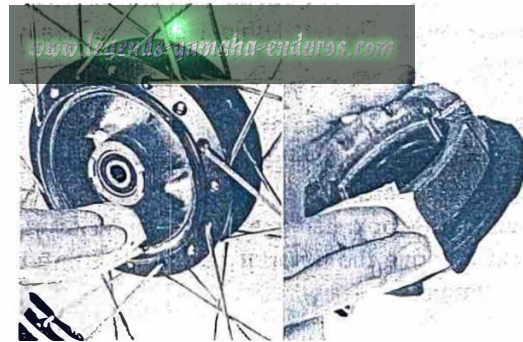
Tightening torque: 0.6 m·kg (4 ft·lb)

- Remove the front wheel axle nut and plain washer. Then remove the wheel axle.



1. Wheel axle 2. 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.



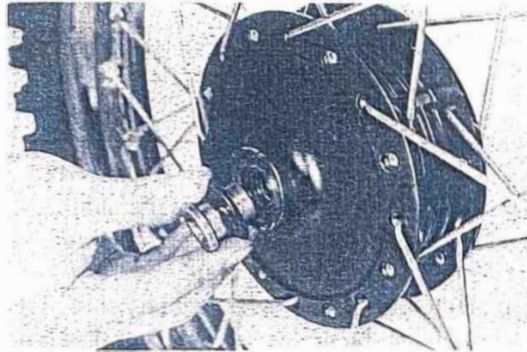
- Make sure the brake shoes and springs are correctly installed in the shoe plate assembly. If any one of them is out of position, correct per the figure.



- Install the brake shoe plate assembly in the wheel hub.
- 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.



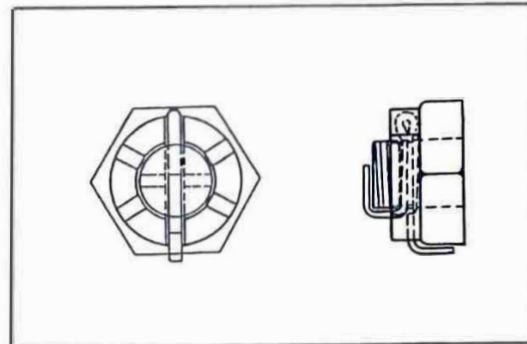
6. Install the front wheel on the front forks.
 - a. Insert the front wheel between the front fork legs so that the stopper (projection) on the front fork end is correctly engaged the slot in the brake shoe plate.



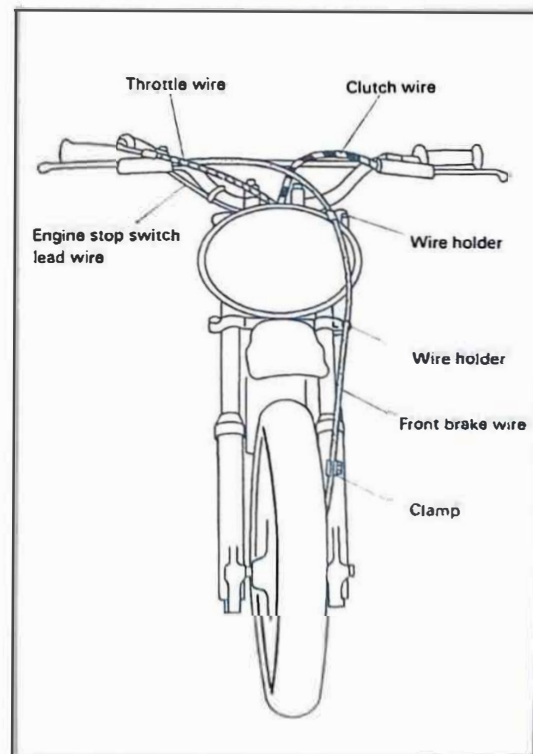
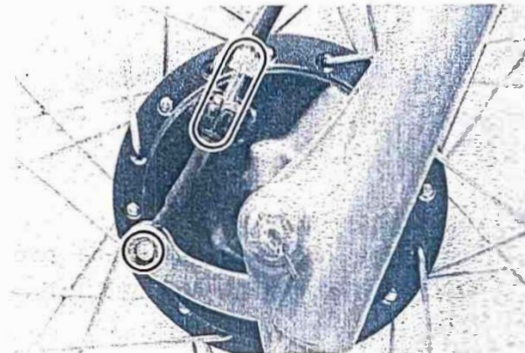
- b. Insert axle, and install the axle nut.
 - c. Torque the axle nut to specification.

Tightening torque: 3.5 m·kg (25 ft·lb)

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



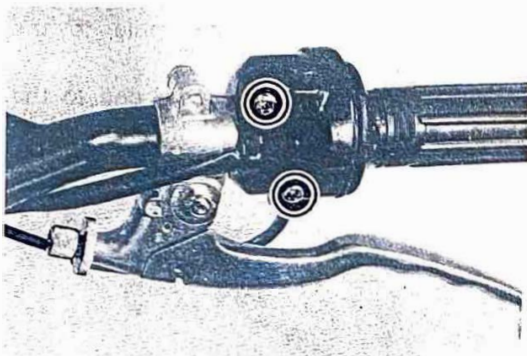
7. Install the front brake cable to the wheel hub.
Insert the front brake wire end to the camshaft lever and hook the outer cable end onto the adjuster.



8. Loosen the two screws securing the throttle housing assembly.
Grease the right end of handlebar and the throttle grip housing. Install the throttle grip and tighten the screws.

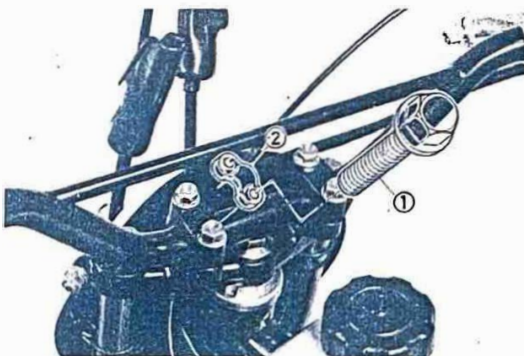
CAUTION:

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



9. Handlebar installation

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

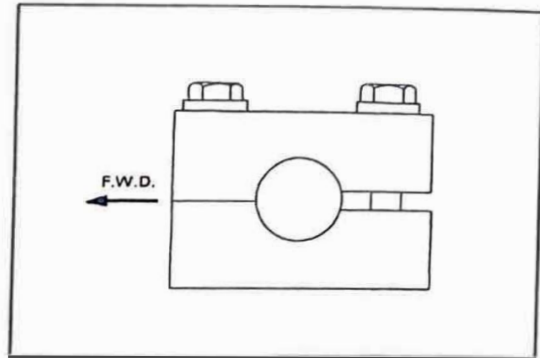


1. Flange bolt 2. Handle upper holder

Tightening torque: 1.5 m·kg (11 ft·lb)

CAUTION:

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



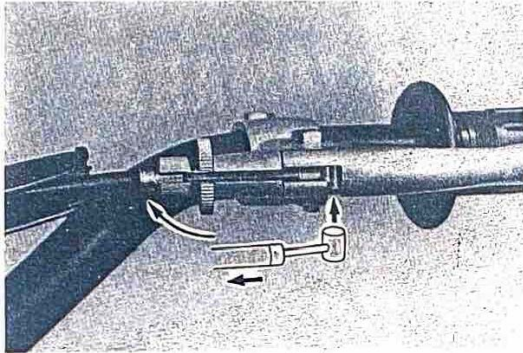
10. Brake wire and clutch wire installation
- Screw in the cable length adjuster on the front brake shoe plate.
 - Fully loosen the lever adjuster lock nut, and screw in the adjuster until tight. Next, align the slit in the adjuster and adjuster lock nut with the slit in the lever holder.



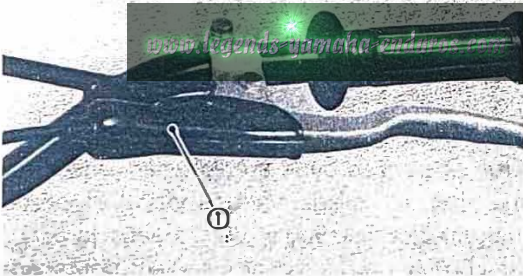
- Insert the wire end into the lever hole, and hook the outer cable end onto the adjuster lock nut, then squeeze the lever. Next, while pulling the outer cable in the direction opposite to the lever, release the lever quickly. While releasing it, seat the outer cable into the adjuster.

CAUTION:

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



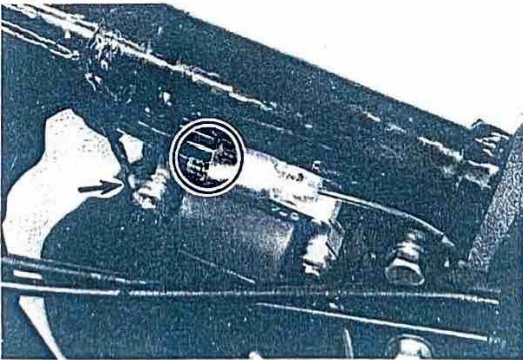
d. Install the lever covers on clutch and brake wires.



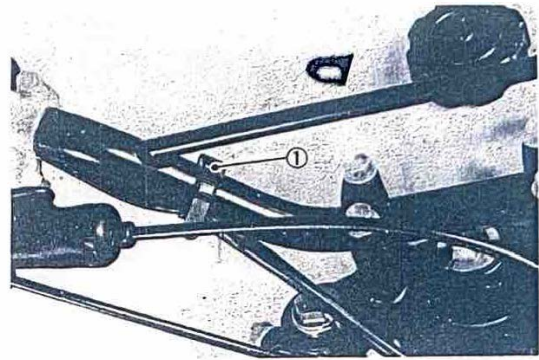
1. Lever cover

11. Engine stop switch connection

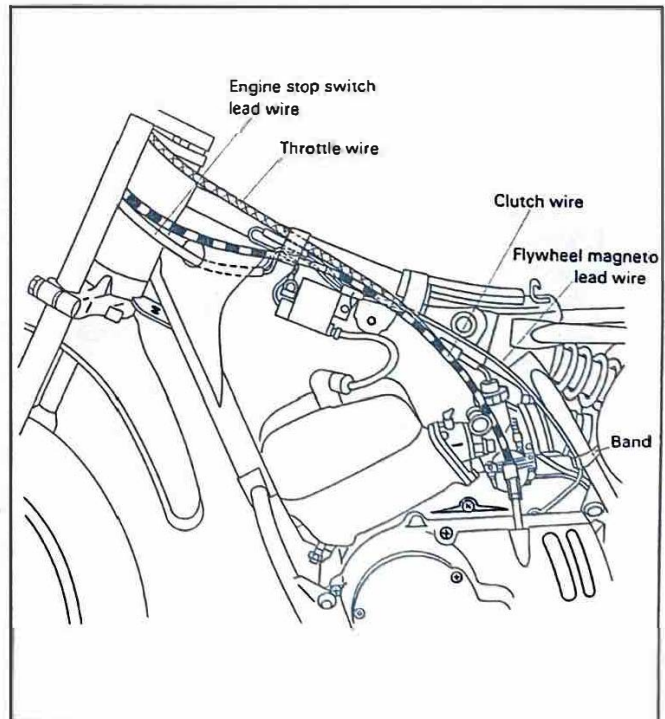
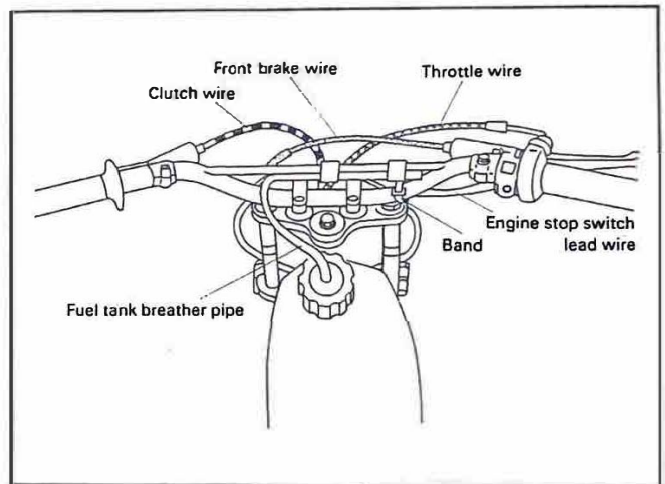
- a. Remove the bolts and tank fitting band. Remove the tank.
- b. Connect the engine stop switch lead wire (coming from the engine stop switch) to the lead wire (black/white) coming from the magneto assembly in the connector.



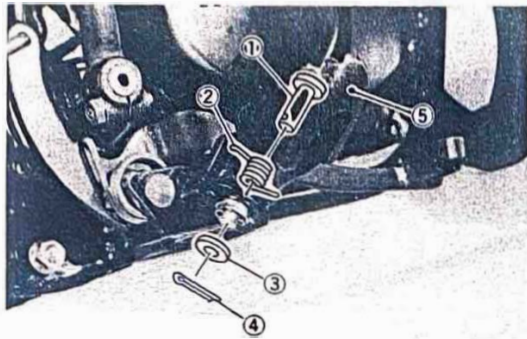
c. Install the engine stop switch lead wire on the handlebar using switch cord band.



1. Switch cord band

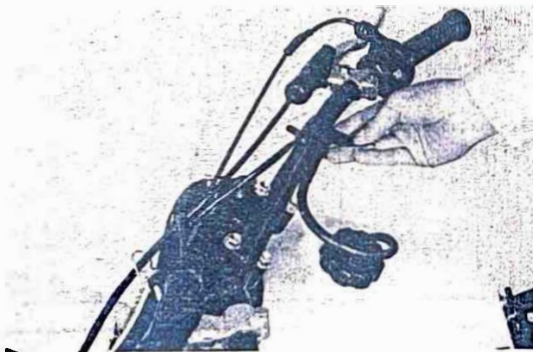


12. Install the footrest.

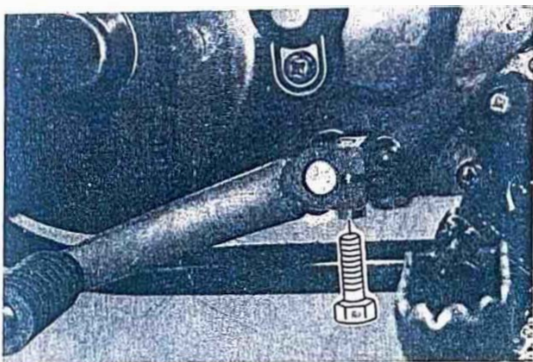


- 1. Clevis pin 3. Washer 5. Footrest
- 2. Torsion spring 4. Cotter pin

13. Connect the tank breather pipe to the fuel tank cap, next tape the breather pipe with tension bag.



14. Change pedal
Install the change pedal using a bolt.



Tightening torque: 1.0 m-k \ddot{g} (7 ft-lb)

15. Seat installation
Insert the hook on the end of the seat into the frame, and secure both sides of the seat with bolt with spring washer.



Tightening torque: 1.0 m-k \ddot{g} (7 ft-lb)

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 boltTightening torque
Carburetor jointsTightness
FootrestPosition, mounting
Shift pedalOperation, mounting
Brake pedalOperation, freeplay, mounting
SeatMounting
Fuel tankMounting
Fuel pipeConnection, mounting
Fuel breather pipeConnection, routing
Rear shock absorberMounting, cotter pin
Swing arm pivot shaftTightening torque
Chain pullerAlignment
TransmissionOil level
Control cablesLubrication
Electrical componentsOperation adjustment

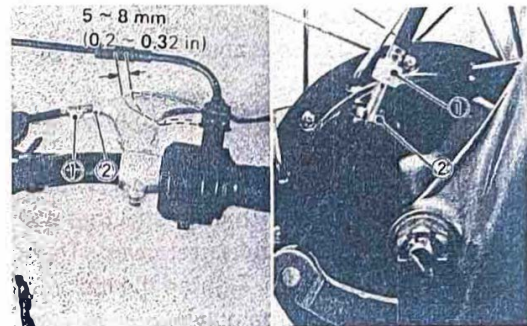
Adjustment

NOTE: _____

This section deals with the main points only. For details, refer to the YZ50G Owner's Service Manual.

Front brake adjustment

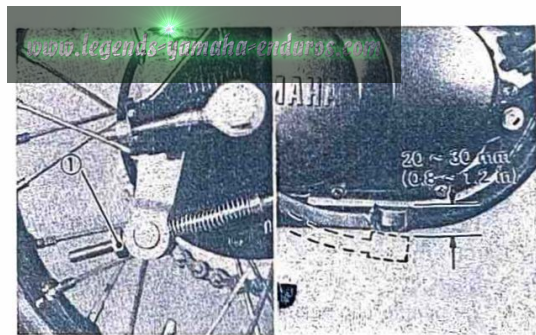
The front brake can be adjusted in two ways; (1) using the adjusters at the front brake lever or (2) at the front brake shoe plate. Adjustment at the front brake lever is normally recommended. Loosen the lock nut and turn the adjuster to adjust the brake lever. As shown in the illustration, the clearance between the brake lever and the brake lever holder should be 5 ~ 8 mm (0.2 ~ 0.32 in). After adjusting be sure the lock nut is tightened firmly.



1. Adjuster 2. Lock nut

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.

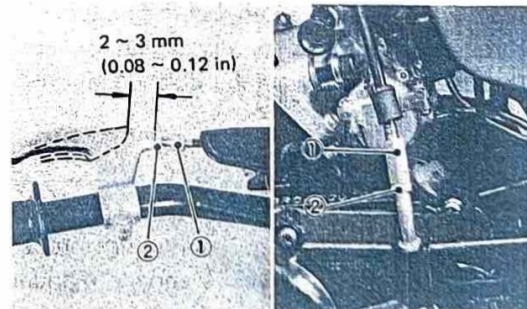


1. Adjuster

Clutch adjustment

1. Free play adjustment

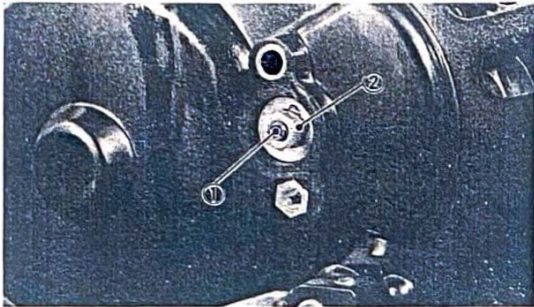
Loosen either the handle lever adjuster lock nut or the cable in-line length adjuster lock nut. Next, turn the length adjuster either in or out until proper lever free play is achieved.



1. Adjuster 2. Lock nut

2. Mechanism adjustment

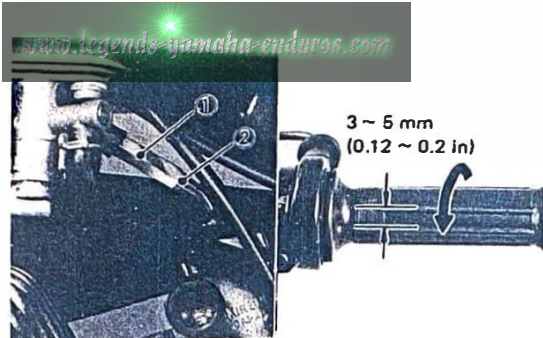
- a. Loosen the lock nut and fully tighten the adjuster.
- b. Remove left side cover and loosen adjuster lock nut.
- c. Slowly tighten the adjusting screw until resistance is felt. This means that the play of the push rod is removed. Then, back it off 1/4 turn. Tighten the lock nut.
- d. Adjust the lever free play.



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

Specification

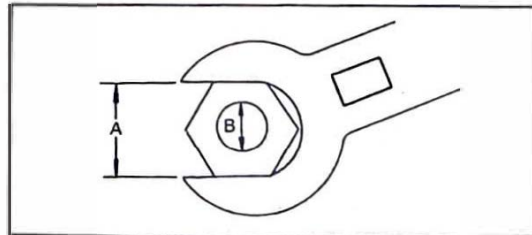
Ignition timing:	B.T.D.C. 17° (STATIONARY) (1.8 ± 0.15 mm (0.071 ± 0.006 in))
Contact breaker:	
Point gap	0.30 ~ 0.40 mm (0.012 ~ 0.016 in)
Carburetor:	
Main jet	#170
Jet needle/clip position	4J13-3
Air screw	1-1/2
Fuel tank capacity:	3.0 lit (0.8 US.gal)
Transmission oil capacity:	Period oil change: 600 ~ 650 cc (0.63 ~ 0.69 US.qt) Overhaul: 650 ~ 700 cc (0.69 ~ 0.74 US.qt)

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. Consult the model Owner's service manual or distributor if a question arises.



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