

YZ400D, IT400D
CRANKCASE EPOXY PLUGS

A small number of YZ400D and IT400D machines may have faulty epoxy plugs in the right crankcase. The precise location of these plugs is described in this Bulletin. Complete serial number information is not yet available. All machines in the indicated ranges should be inspected and repaired if necessary.

AFFECTED MACHINES

The following machines should be inspected:

YZ400D: 000101 ~ 003240

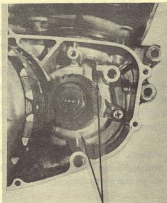
IT400D: 000101 ~ 001795

INSPECTION:

Initial inspection does not require disassembly of the machine.

- Following set-up adjustments, run the engine for 15 ~ 30 minutes using Yamalube "R" mixed with premium gasoline at a gas:oil ratio of 24:1. Observe the exhaust smoke. There will be heavy smoke at first. After 10 ~ 13 minutes of running, a heavy blue-white smoke could indicate leakage of transmission oil into the center of the crankcases. Also check for oil residue around the muffler.
- If a machine is to be put into use immediately, check for consumption of transmission oil by periodically inspecting the oil dip stick. The oil may be leaking into the center of the crankcases.
- If the spark plug fouls and shows oil contamination, the transmission oil may be leaking through the plugs.

If any of the above inspections indicate the possibility of transmission oil leaking, see the following procedures.



THE EPOXY PLUGS ARE LOCATED
NEAR THE PRIMARY DRIVE GEAR



PROCEDURE

1. Drain transmission oil. Remove right footpeg, brake lever, and kick starter crank. Remove the right crankcase cover.
2. Thoroughly clean the area around and above the plugs. The slightest oil residue will contaminate the new epoxy. Use acetone or electrical contact point cleaner for the final cleaning.
3. Replace the plug as follows:
 - (1) Use a 5mm (0.20 inch) drill bit. Drill 5mm into each plug. Mark the drill bit with tape to indicate proper depth.
 - (2) Countersink the hole about 1mm deep. Use a slightly larger drill bit for a countersink. Again clean the area surrounding the hole. Make sure no solvent or epoxy residue is left in the hole.
4. Use epoxy (see following NOTE) to fill the cleaned holes. It may be helpful to warm the area with a lightbulb to speed curing.

NOTE: Use any suitable epoxy for this repair. Also, epoxy is available from Yamaha Service Centers. Dealers wishing to use this epoxy to replace the original epoxy plugs can request it from these Centers. One epoxy set is available per dealer and is sufficient for more than 50 machines. The Yamaha "3-LOY" epoxy is mixed in an epoxy-hardener ratio of 10:1. Allow 24 hours for curing time.

5. Inspect the new epoxy plugs for completeness and hardness. Add 1,100cc of Yamalube 20W40 oil to the transmission.

WARRANTY

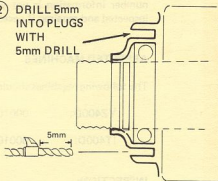
An allowance will be paid for the repair of YZ400D and IT400D machines with faulty epoxy plugs.

Job Code: 2502

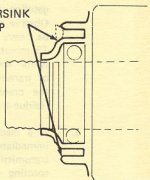
Problem Code: 90AC

① CLEAN ENTIRE AREA

② DRILL 5mm INTO PLUGS WITH 5mm DRILL



③ COUNTERSINK 1mm DEEP



④ CLEAN ENTIRE AREA AND APPLY EPOXY