



2002 TRANSMISSION KIT KIT PN 2202433

THE NEW AMERICAN MOTORCYCLE™

Application

2002 V92C Standard, Deluxe Cruiser, Touring Cruiser, Deluxe Touring Cruiser

Before you begin, it is very important that you read and understand these instructions. These instructions are to be used in conjunction with the appropriate Victory Service Manual. Make sure you follow them exactly. Make certain all parts and tools are accounted for. Please retain these installation instructions for future reference and parts ordering information.

This kit contains all parts required to change a model year 2002 Victory motorcycle to the latest transmission components and must be installed by a certified Victory technician. If components not contained in this kit are worn or damaged beyond specifications, it is the service technician's responsibility to identify and replace those parts during installation.

IMPORTANT! INSTALL ALL PARTS INCLUDED IN THIS KIT.

Kit Contents

<u>Qty.</u>	<u>Part Description</u>	<u>Part No.</u>
1	Clutch Shaft Assembly (5th Gear)	1341411
1	Main Shaft Assembly	1341451
1	Gear, Main Shaft 4th, Counter Shaft 3rd, 26T	6230262
1	Countershaft Assembly	1341452
1	Gasket, Cam Drive Cover	5830118
2	Gasket, Valve Cover	5830202
2	Gasket, Cylinder Base	5244365
2	Gasket, Cylinder Head	5244363
4	Screw, M5 x 12 Torx	7517255
2	Gasket, Tensioner	5830117
1	Double Row Bearing	3513524 or 3514443
1	O-Ring, Oil Drain Plug	5412020
1	O-Ring	3610091
1	Sleeve, Seal	5133394
1	Sprocket, Front, Drive	5133262
1	Hex Nut, M36 x 1.5	7547209
2	Fork, Shift, Mainshaft	5133255
1	Fork, Shift, Countershaft	5133256
1	Instruction, Kit, Trans Update, 2002	9918387

You will need to supply:

- Primary Cover Gasket (P/N 5830119)
- 2002 Victory Service Manual (P/N 9918130)
- Torque wrench, 0-100 ft. lb. (0-136 Nm)
- Torque wrench, 0-50 in. lb. (0-6 Nm)
- Loctite 598 Ultra Black® RTV Silicone Sealant
- Loctite Clean 'N Prime Primer N® (P/N 2870585)
- Loctite 262 Threadlocker® (P/N 2871952 6ml Tube)

and the Special Service Tools listed below:

TOOL	PART NUMBER
Clutch Shaft Holder	PV-45028
Output Shaft / Crankcase Installer	PV-46299
Spacer (For Press)	PV-45031
Crankshaft Protector	PV-43504
Mainshaft Press Tool	PV-45029
Engine Lock Tool	PV-43502-A

 WARNING

The engine and exhaust system become very hot during operation and remains hot for a period of time after the engine is shut off. Wear insulated protection for hands and arms or wait until the engine and exhaust system have cooled before working on the machine.

 WARNING

CARBON MONOXIDE Never run an engine in an enclosed area. Exhaust contains poisonous carbon monoxide gas that can cause loss of consciousness and may lead to death. If you must run the engine to do some repairs, do so in an open area or with an exhaust evacuation system connected and functioning properly.

 WARNING

The engine exhaust from this product contains chemicals known to cause cancer, birth defects or other reproductive harm.

IMPORTANT: Refer to the appropriate Victory Service Manual and these instructions to install this kit.

NOTE: Make certain motorcycle is secured properly for engine removal. Stabilize the motorcycle on a flat surface. The front wheel should be secured in a wheel clamp prior to removing engine. (Refer to Chapter 6)

IMPORTANT: ALWAYS clean and prime threads of screws and threads in crankcase with Loctite Primer N and allow to dry before applying threadlocking agent.

1. Drain engine oil and remove engine. (Refer to Chapter 6)
2. Disassemble engine to the extent required to access transmission, including removal of RH crankcase. (Refer Chapter 7-10)

NOTE: To separate crankcase use Main Shaft Press Tool PV-45029.

NOTE: The output shaft in this kit has a different thread (M36x1.5). To assemble the case after the new transmission is installed and ensure proper crankcase sealing, you must use Output Shaft / Crankcase Installer PV-46299.

3. Remove oil pump from engine case. (Refer to Chapter 4)
4. Disassemble pump and inspect all components for wear or damage. (Refer to Chapter 4)
5. Remove shift rails, shift forks, and shift drum, then remove the mainshaft and countershaft assemblies. (Refer to Chapter 10)
6. Remove the clutch shaft. (Refer to Chapter 10)

NOTE: Clutch Shaft Assembly (5th Gear) PN 1341411 MUST be installed as directed. This part looks similar to the old clutch shaft (PN 1341345) but is in fact different.

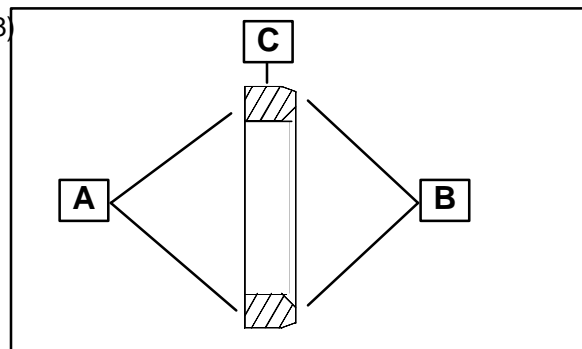
7. Clean and inspect all components thoroughly.
8. Replace clutch shaft bearing with double row bearing (PN 3513524) from kit.
9. Replace (4) retaining plate screws with 5x12 Torx screws from kit (PN 7517255) when reinstalling the bearing retainer plate.
10. Inspect all bearings and oil passages. Be sure they are clean and free of dirt and metallic debris.
11. Replace all worn or damaged components.
12. Assemble transmission using ALL components contained in this kit. (Refer to Chapter 10)
13. Assemble oil pump and install into case. (Refer to Chapter 4)
14. Assemble crankcase and primary drive. (Refer to Chapter 9 and 10)

15. Assemble engine top end. (Refer to Chapter 7 and 8)

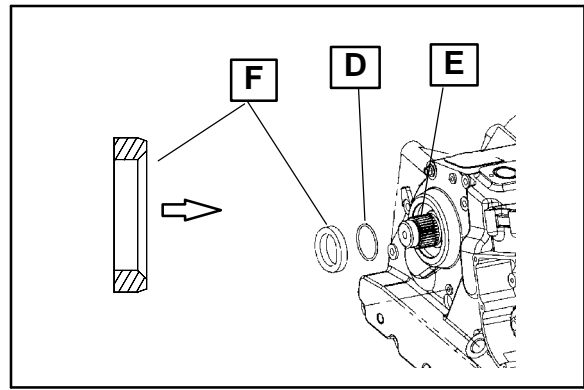
16. Install engine in frame. (Refer to Chapter 6)

17. Install the inner sprocket cover.

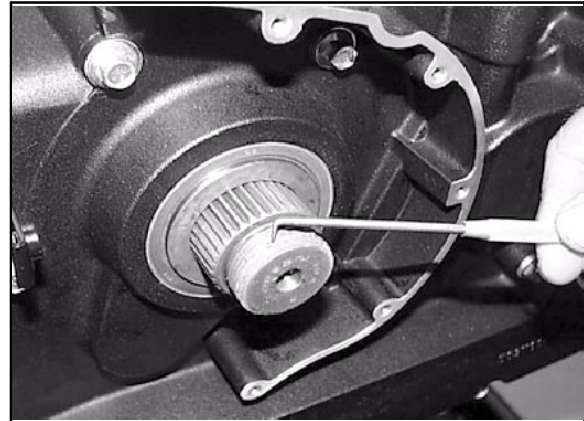
18. Inspect outer surface (A), inner surface (B), and sealing surface (C) of seal sleeve. Surfaces must be flat without wear or galling. Replace the sleeve if worn, or if the surface appears rough or chafed. The O-ring sealing surface of chamfered edge must be smooth to seal the shaft.



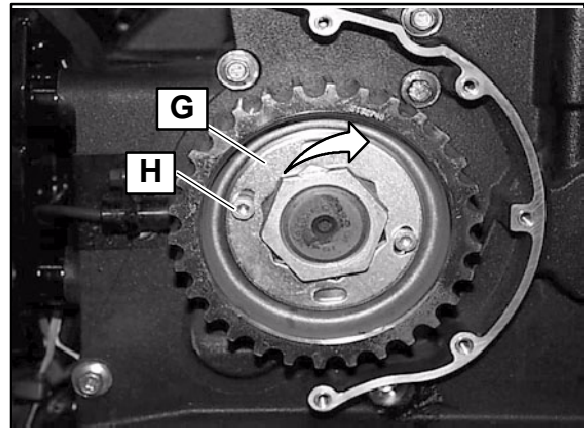
19. Apply grease to a new O-ring (D) (if it was not previously installed) and install on mainshaft (E).
20. Install seal sleeve (F) with chamfer facing in, toward O-ring.



21. Clean the shaft threads and sprocket nut of old thread locking agent and apply Loctite Primer N™. Allow 5 minutes drying time for the Primer N.
22. Place belt onto the front sprocket and place sprocket over splines of output shaft.
23. Tighten rear axle then back it off about 1 turn.
24. Adjust belt tension visually to provide enough tension to keep belt from jumping the teeth of sprocket while torquing sprocket nut.
25. Apply Loctite 262 to threads of output shaft and nut.
26. Install drive sprocket nut.
27. Apply rear brake and torque drive sprocket nut to 125 ft-lbs (170 Nm).



28. Install lock plate (G).
- NOTE:** The lock plate can be installed in many positions and either side of the plate can be used. If you cannot find a position that will work, flip the plate over and again try to install it. If the plate still does not align, tighten the sprocket nut slightly and try to fit the lock plate again.
29. Install lock plate screws (H).
 30. Rotate the plate CLOCKWISE until it stops and hold it firmly against the nut.



31. Tighten lock plate screws to 85 in-lbs (10 Nm)
 32. Adjust drive belt tension and wheel alignment. Refer to Service Manual for procedure.
- BELT DEFLECTION:**
STANDARD CRUISER / DELUXE CRUISER: 8mm w/ 10 lb. load
TOURING CRUISER: 9mm w/ 10 lb. load

33. Install drive sprocket outer cover and remaining components.
34. Verify proper oil level and that all fasteners are properly tightened.
35. Test ride motorcycle and check for proper operation.