



MODEL: Honda TRX 250R

CENTER CASE MACHINING

The following machine work is required for installation of PC 2000 305cc and 340cc Power Valve Cylinders. Failure to machine cases properly can cause severe engine damage. All machine work must be performed by a skilled competent machinist. *DRI does offer complete engine disassembly and case machining. Call for additional details.*

Center cases must be completely disassembled. Transmission, crankshaft, cylinder base studs all must be removed. DRI also recommends that all transmission and main bearings be removed (replace any bearings not in new condition, after machine work). Wash and clean center cases thoroughly and be sure all gasket surfaces are flat. Before machining.

- Cases must be opened to the following measurements:
 - For 340cc cylinder (77.50mm Piston) Machine cases to 86.50 mm
 - For 305cc cylinder (73.50mm Piston) Machine cases to 85.00 mm
- * These measurements should be taken across the base gasket surface at the center case seam.
- For the best possible cut it is recommended to machine cases on a rotary table and to use a ball style end mill.
- Do not bore the cases out with a full circle cut. This will ruin your center cases. There is not enough casted material above the main bearing bosses to allow for this style of cut.
- After machining is complete be sure to test fit cylinder onto cases. For proper function there needs to be at least .010" clearance between cylinder skirt and center cases. If cylinder flange is in 9 bind engine damage will occur.
- After machining is complete DRI recommends filling the (4) empty cavities in the top of the center cases (under where base gasket goes) with a high quality epoxy. *JB WELD works very well and is readily available.*