



MODEL: Honda TRX 400EX

CENTER CASE MACHINING

The following machine work is required for installation of PC 4000 450cc and 465cc cylinder. 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 dowels all must be removed. DRI also recommends that all transmission and main bearings be removed or covered. (replace any bearings not in good 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 450cc and 465cc cylinders (90.50mm and 92.00mm Pistons)
Machine cases to 96.25 mm
 - * These measurements should be taken across the base gasket surface at the center case seam.
Depth of cut should be 31.00 mm
- For the best possible cut it is recommended to machine cases on a milling machine using a boring head.
- 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 bind engine damage will occur.