

## SG400K (Black): Chain Block Yamaha YZF450F (2006) & YZF250F (2006)

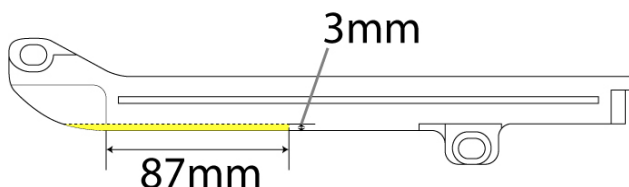
### PARTS LIST

- Chain Block 1
- Bolts, Socket Head M5 x 25mm 3



◀◀◀◀ IT IS RECOMMENDED THAT THIS PRODUCT BE INSTALLED BY A QUALIFIED TECHNICIAN ▶▶▶▶

- 1) Please be sure the motorcycle is cooled down and safe to work on.
- 2) Remove the stock chain buffer.
- 3) You will need to trim the stock chain buffer in order to clear the Graves Motorsports chain block. Refer to the diagram below, you will be cutting out the area highlighted in yellow.



- 4) Loosen the rear wheel and pull it back in the swingarm thus in effect tightening the chain. Check make sure they is no deflection in the chain.
- 5) You need to check to make sure the front and rear sprockets are in alignment. Measure from the center of the swingarm pivot to the center of the rear wheel axle. Do this for both sides. The left and right side measurements should be identical. If not adjust accordingly.
- 6) Place the chain block **lightly** against the inside of the chain. The chain block should not cause any deflection in the chain.
- 7) Line up the #3 hole over the weld as indicated in the diagram.
- 8) Be sure the chain block is perfectly parallel with the chain. The chain block should not cause any deflection in the chain.
- 9) Use a 5.1mm index punch and mark the #1 hole only.
- 10) Use a 4.2mm drill bit and drill out the #1 hole.
- 11) Use a M5 x .8 tap and tap the #1 hole.
- 12) Install the chain block and secure with the M5 x 25mm bolt into the #1 hole.
- 13) Realign the chain block being sure it is parallel to the chain and that the #3 hole is over the weld (refer to diagram). Use a 5.1mm index punch and mark the #2 hole only.
- 14) Remove the chain block.
- 15) Use a 4.2mm drill bit and drill out the #2 hole.
- 16) Use a M5 x .8 tap and tap the #2 hole.
- 17) Install the chain block and secure with the M5 x 25mm bolts into the #1 and #2 holes.
- 18) Realign the chain block being sure it is parallel to the chain. The chain block should not cause any deflection in the chain. Use a 5.1mm index punch and mark the #3 hole.

- 19) To drill the #3 hole you will use the chain block as a drill guide. Insert the 4.2mm drill bit into the #3 hole and drill.
- 20) Remove the chain block and clean any metal shaving from the area.
- 21) Tap the hole with a M5 x .8 tap.
- 22) Using a generous amount of **RED THREADLOCK COMPOUND** on all three of the M5 x 25mm bolts, install the chain block. **Be very careful not to strip the threads from the swingarm.**
- 23) Reinstall the chain buffer. This should fit neatly around the chain block. If not trim some more until it does.
- 24) Readjust rear wheel for proper chain tension.

