



Re-rivet the primary drive and install the clutch on the Vespa PX



Required components: input shaft gear cog set, primary drive repair kit (part no 16020), input shaft bearing (part no 90060) and pins (part no 900810), as well as retaining ring (part no 66420).



Ensure the correct installation of the primary gear cog, the edges have to be flush. The small image shows what it should not look like.



Insert the primary springs with the large set of pliers. Please note: on the Vespa PX200, two springs are intertwined.



Waved cover disc to gear cog set, flat cover disc to clutch side. Fit rivets (head to flat disc). Fit the last rivet the other way around in order to start with the riveting work.



In order to rivet, put the input shaft on flat surface under vice. Attach the cover disc using the screwdriver. Tap in the first rivet using blunt driving hammer / hammer.



SIP Tip: before fitting heat the rivets up until they glow using a small gas burner for easier deformation and to ensure perfect fit. Ends of rivets have to be tapped in flush in order to avoid streaks in the case.



Put the input shaft in the gear cog set, bearings (put in freezer beforehand) with appropriate socket wrench insert (nut) tap in bearings until end stop. Secure with retaining circlip.



Thread the input shaft package into the engine case. Leave the input shaft sticking out a little to be able to insert the pins (part no 900810).



SIP Tip: thread in the pins apart from the last one and attach them with a suitable O-ring (from seal set, part no 92050). Pull the input shaft out a little and fit the last pin.



Screw in the input shaft with the lock washer, spacer washer and nut. Bend the lock washer on the nut with the driving hammer in order to secure it.



Clutch installation: put the woodruff key (part no 87070) in the groove. Make sure that it doesn't fly into the gearbox, groove pointing upwards! Then position the flat washer (part no 2229770) on the bearing with the bevel pointing downwards.



Push the clutch carefully over the woodruff key with the groove until it is positioned on the flat washer. Don't forget the wavy disc (part no 69820), then screw on the clutch nut.



Tighten the clutch nut with the impact wrench (45Nm). Those who do not have an impact wrench are advised to use the clutch retaining tool (part no 909910).



Fit the clutch pressure plate, firstly thread in the open spring ends then push down the spring with the flat screw driver until it snaps into position.



Put the O-ring (part no 92130) in the cover, insert the push rod (part no 87080), and attach the cover to the case with 3 screws.