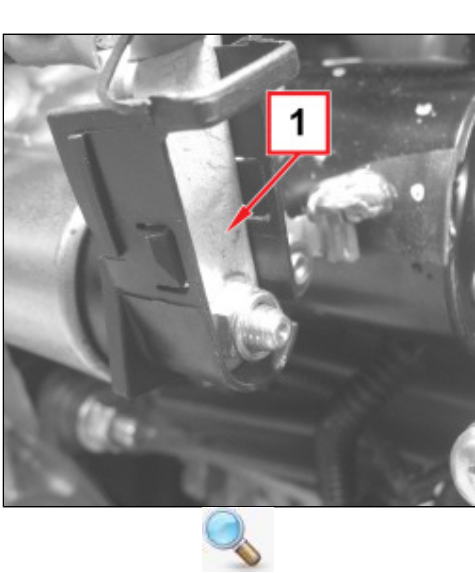
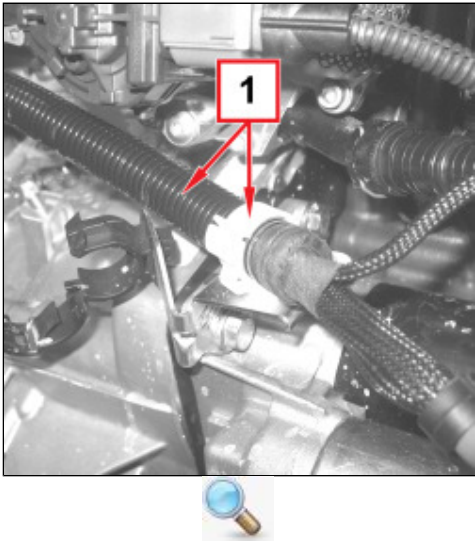


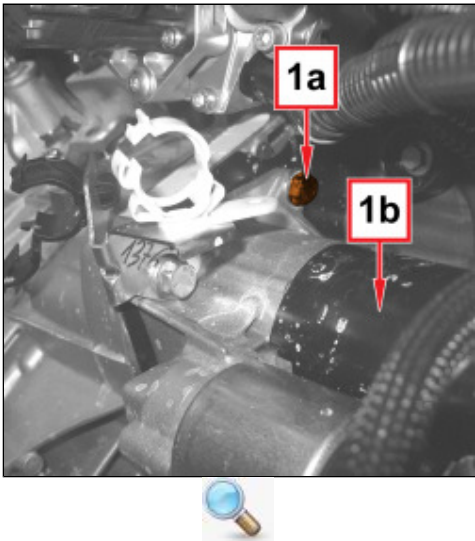


 Removing ([Refitting](#) )

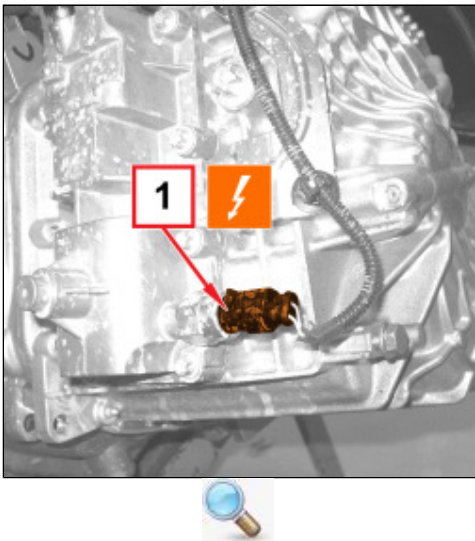
1. Open the protective cover, undo the nuts and disconnect the wiring from the starter motor.



1. Open the clip fixing the starter supply cable then remove it.



1. Undo the bolts (1a) and remove the starter motor (1b).

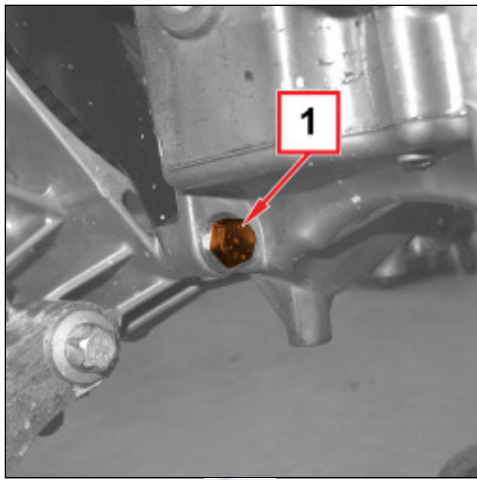


1. Disconnect the electrical connection for the reversing light switch.

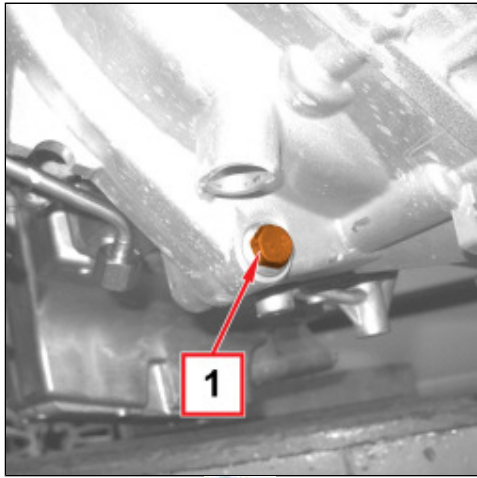
	Description	Connector
1	Reversing light switch	See I020 REVERSING LIGHTS SWITCH

2. Undo the screw fixing the wiring mounting bracket then move the wiring aside.

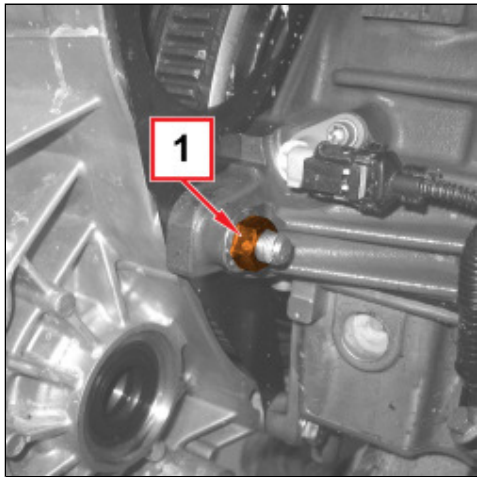
1. Undo the rear lower screw fixing the gearbox to the engine.



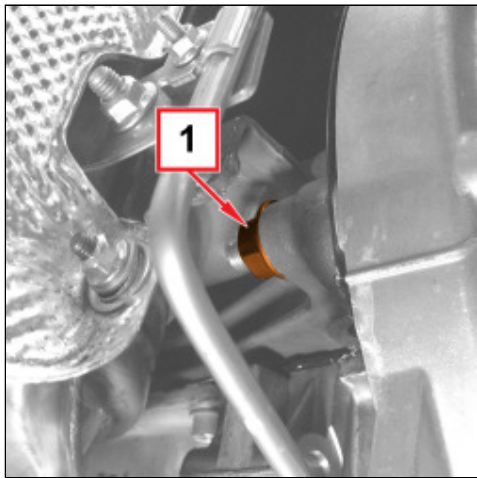
1. Undo the front lower screw fixing the gearbox to the engine.



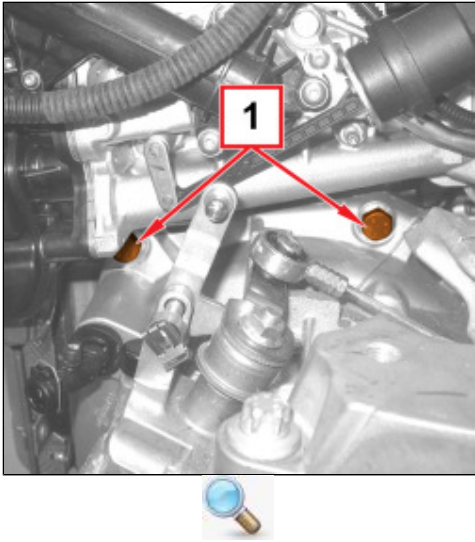
1. Undo the nut fixing the gearbox to the engine, inlet side.



1. Undo the nut fixing the gearbox to the engine, exhaust side.



1. Undo the upper screws fixing the gearbox to the engine the remove the gearbox with the aid of a second operator.



- If necessary, remove the clutch unit, with reference to:

[Op. 1810A24 CLUTCH - R + R WITH GEARBOX REMOVED](#)

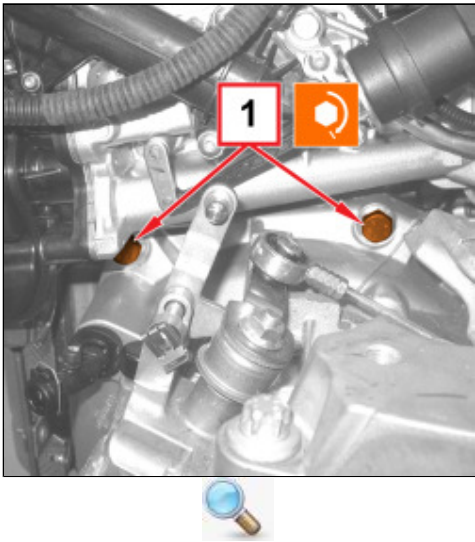
- If necessary, remove the clutch unit, with reference to:

[Op. 1024B22 ENGINE FLYWHEEL - R.R WITH CLUTCH REMOVED FOR VERSIONS WITH MANUAL GEARBOX](#)

 Refitting ([Removing](#) )

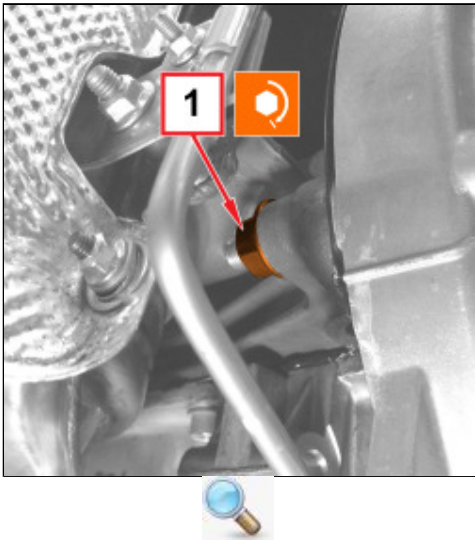
- Approach the manual gearbox to the engine with the help of a second operator.

1. Tighten the upper screws fixing the gearbox to the engine to the prescribed torque.



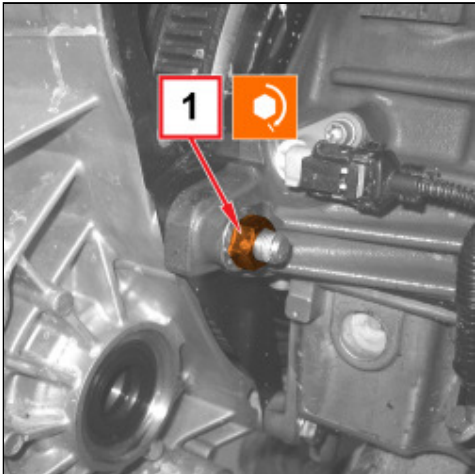
Component	Fastening	Ø	Value (daNm)	Validity
Upper fastening joining gearbox	Screw	M12	5.1 ÷ 6.9	1.6 JTDM

1. Tighten the front nut securing the gearbox to the engine to the recommended torque.



Component	Fastening	Ø	Value (daNm)	Validity
Manual gearbox to engine - crankcase side	Nut	M12	5.1 ÷ 6.9	1.6 JTDM

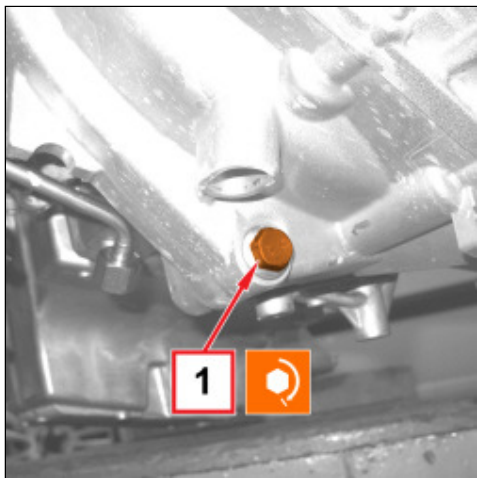
1. Tighten the rear nut securing the gearbox to the engine to the recommended torque.



Component	Fastening	Ø	Value (daNm)	Validity
Rear fastening joining gearbox	Nut	M12	5.1 ÷ 6.9	1.6 JTDM

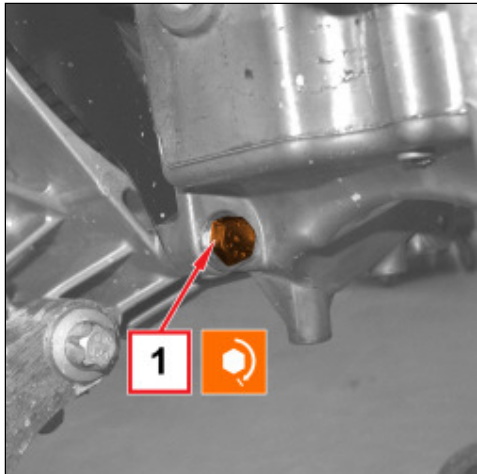


1. Tighten the front lower screw fixing the gearbox to the engine to the prescribed torque.



Component	Fastening	Ø	Value (daNm)	Validity
Upper fastening joining gearbox	Screw	M10	3.6 ÷ 4.4	1.6 JTDM

1. Tighten the rear lower screw fixing the gearbox to the engine to the prescribed torque.

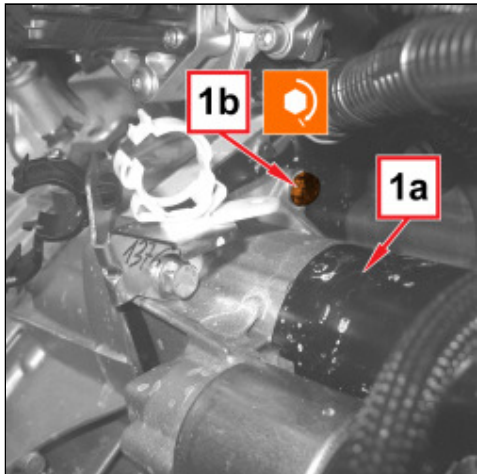


Component	Fastening	Ø	Value (daNm)	Validity
Upper fastening joining gearbox	Screw	M10	3.6 ÷ 4.4	1.6 JTDM

- Connect the electrical connector for the reverse light switch.

- Position the wiring mounting bracket in its housing then tighten the fixing screw.

1. Place the starter (1a) in its housing and tighten the screws (1b) to the prescribed torque.



Component	Fastening	Ø	Value (daNm)	Validity
Starter motor	Screw	M8	2.4 ÷ 3.0	

- Fix the starter supply wiring with the clip.

- Connect the starter motor wiring, tighten the nuts and close the protective cover.