

GL1800 Frame Preparation/Re-assembly

IMPORTANT: Before you begin the **RE-ASSEMBLY** procedures in this section, you **MUST** inspect the new TIG welds.

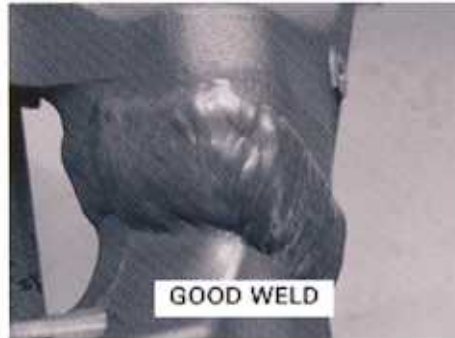
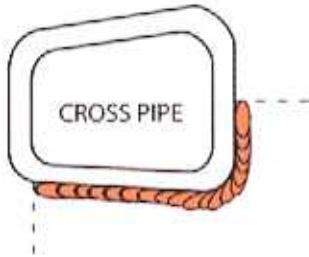
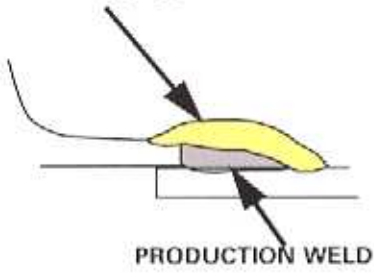
If you find any **No Good** welds during your inspection, call your DSM or TechLine at (800) 421-1900 for further instructions.

Thoroughly read and study the following **TIG WELD IDENTIFICATION** section. Knowing how to accurately identify the quality of a TIG weld is very important and will assist in the correct and accurate fulfillment of this Safety Recall.

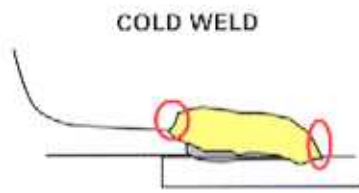
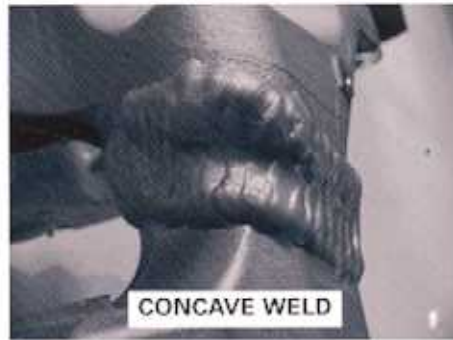
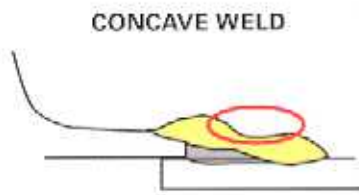
"GOOD" AND "NO GOOD" TIG WELD IDENTIFICATION

This section shows you how to accurately identify **GOOD** TIG welds.

New weld shape is convex,
overlapping production weld.



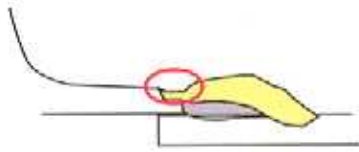
This section shows you how to accurately identify the following types of **NO GOOD TIG** welds: **Concave Weld**, **Cold Weld**.



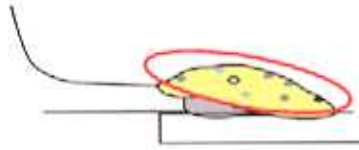
Proceed to page 4 for more NO GOOD TIG weld descriptions.

This section shows you how to accurately identify the following types of **NO GOOD TIG** welds: **Undercut Weld**, **Dirty Weld**.

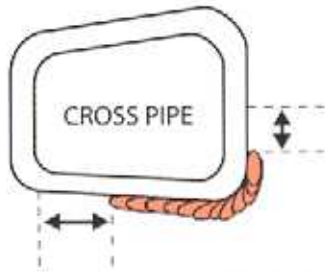
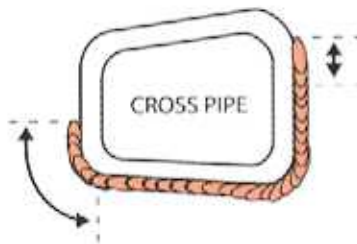
UNDERCUT WELD



DIRTY WELD



This section shows you how to accurately identify the following types of **NO GOOD TIG** welds: **Weld Too Short**, **Weld Too Long**.

WELD TOO SHORT**WELD TOO LONG**

DUST SEAL REMOVAL/INSTALLATION

1. **USING COMPRESSED AIR, BLOW OUT ANY METAL SHAVINGS LEFT OVER FROM THE WELDING PROCEDURE**

2. **USING AT LEAST TWO PEOPLE, GENTLY LAY THE VEHICLE DOWN ON ITS RIGHT SIDE ON APPROPRIATE PADDING**

Lock the handlebars to the left before you lay the vehicle down. Make sure you place thick, non-abrasive padding (such as furniture blankets) on the ground before you lay the vehicle on its side. No painted parts should be contacting the ground or the padding.

3. **INSPECT THE WELDS, REFERRING TO THE WELD INSPECTION SECTION**

If you find any No Good welds, call your DSM or TechLine at (800) 421-1900 for further instructions.

4. **REMOVE THE SHOCK LINK-TO-FRAME NUT**



5. REMOVE THE DUST SEALS (BOTH SIDES) AND INSTALL NEW ONES

Make sure you clean any residual grease from the needle bearings. Lubricate the needle bearings with new **ProHonda Moly 60 Paste** (P/N: 08734-0001, H/C: 2963866).



6. INSTALL THE SHOCK LINK

Tighten the shock link-to-frame nut to the specified torque.

TORQUE: 64 N·m (6.5 kgf·m, 47 lbf·ft)

WELD PAINTING

1. USING APPROPRIATE MATERIALS, MASK THE AREA SURROUNDING THE WELDS

NOTE: Make sure the area to be painted is free of grease, oil, or dirt.



2. PAINT THE WELDS

Use either of the following commercially available paint products.

Plasti-kote

1542 Burnished Silver M

Dupli-color

DAL 1679 Silver Metallic



RE-ASSEMBLY

IMPORTANT: Do not install the centerstand until 24 hours after the welding procedure was completed. This will give the welds time to cure.

1. USING AT LEAST TWO PEOPLE, RAISE THE VEHICLE AND PLACE IT ON ITS SIDESTAND.

2. INSTALL THE CENTERSTAND

Place the motorcycle on its sidestand. Install the centerstand spring post and tighten.

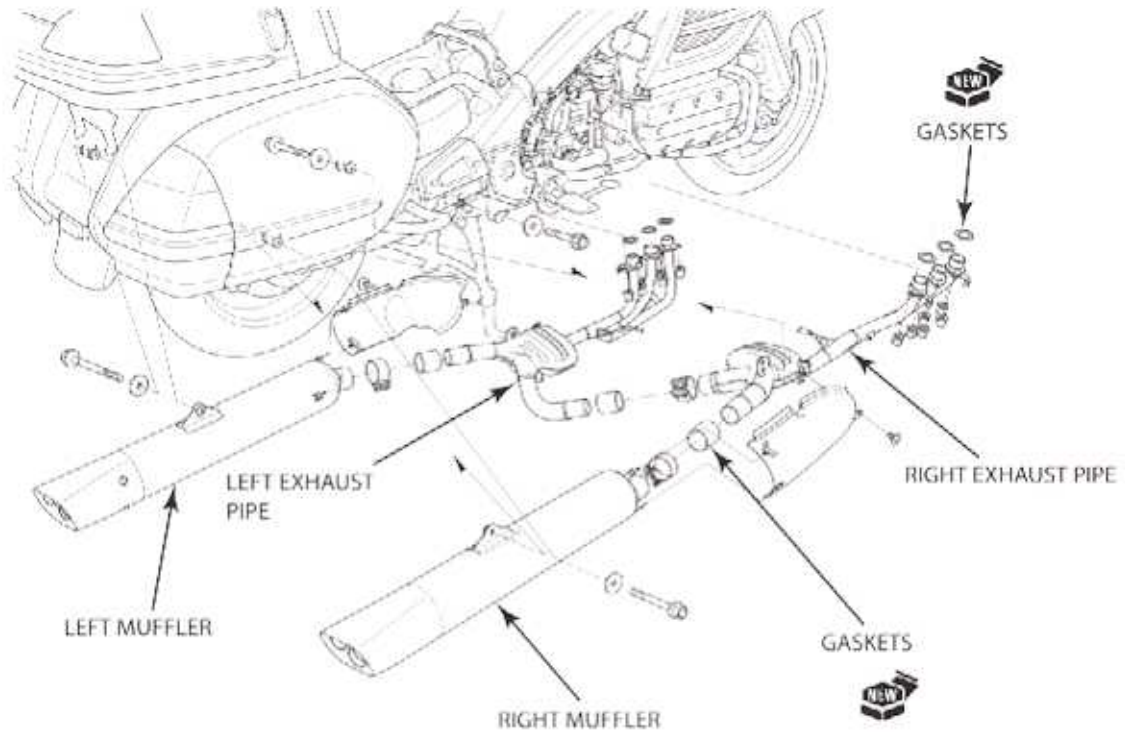
Install the centerstand and secure it using the hex bolt on the left side and the **left-handed threaded bolt** on the right side.

Use **HondaLock 2** (P/N: 08713-0002, H/C: 2963833) on the left-handed threaded bolt. Tighten the bolts to the specified torque.
TORQUE: 39 N·m (4.0 kgf·m, 29 lbf·ft)



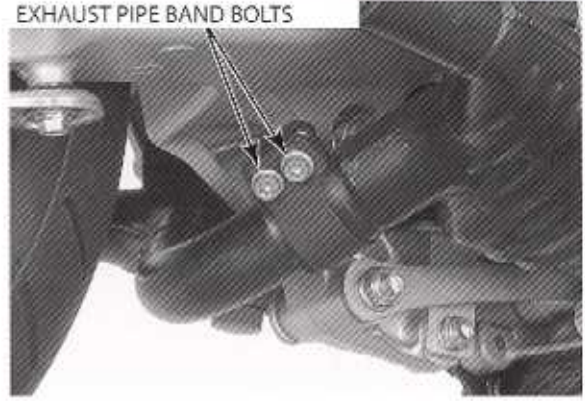
3. INSTALL THE EXHAUST

Wearing gloves, install both exhaust pipes with new gaskets provided in the parts kit. Loosely tighten all nuts and bolts.

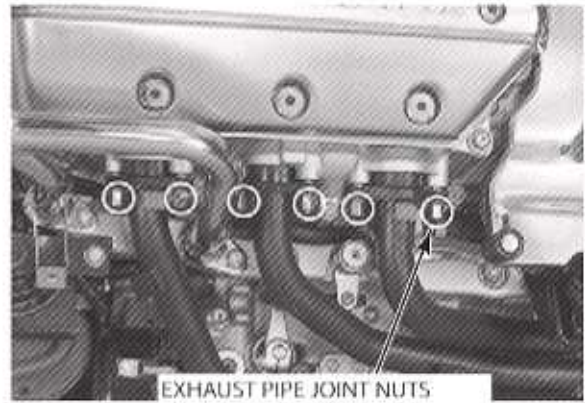


Tighten the exhaust pipe band bolts.
TORQUE: 26 N·m (2.7 kgf·m, 20 lbf·ft)

EXHAUST PIPE BAND BOLTS

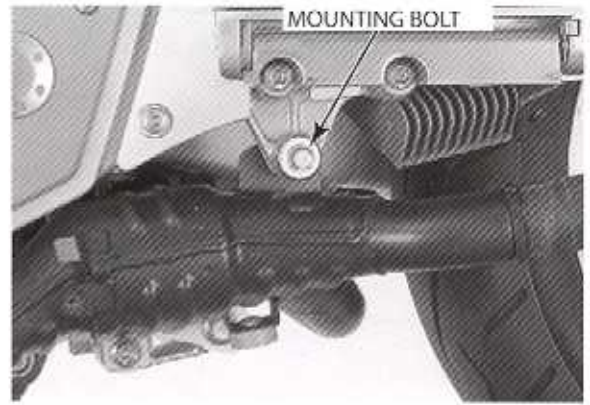


Tighten the exhaust pipe joint nuts.
TORQUE: 12 N·m (1.2 kgf·m, 9 lbf·ft)

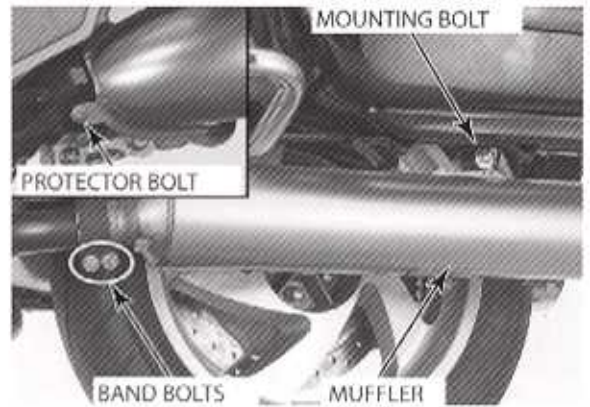


EXHAUST PIPE JOINT NUTS

Tighten the exhaust pipe mounting bolts.
TORQUE: 26 N-m (2.7 kgf-m, 20 lbf-ft)



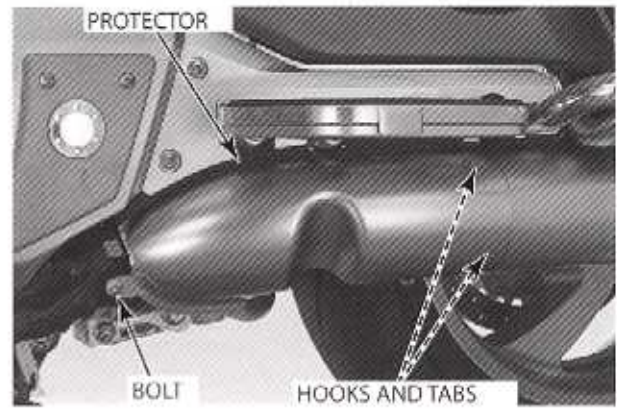
Tighten the muffler band bolts.
TORQUE: 26 N-m (2.7 kgf-m, 20 lbf-ft)



4. INSTALL THE REAR EXHAUST PIPE PROTECTORS

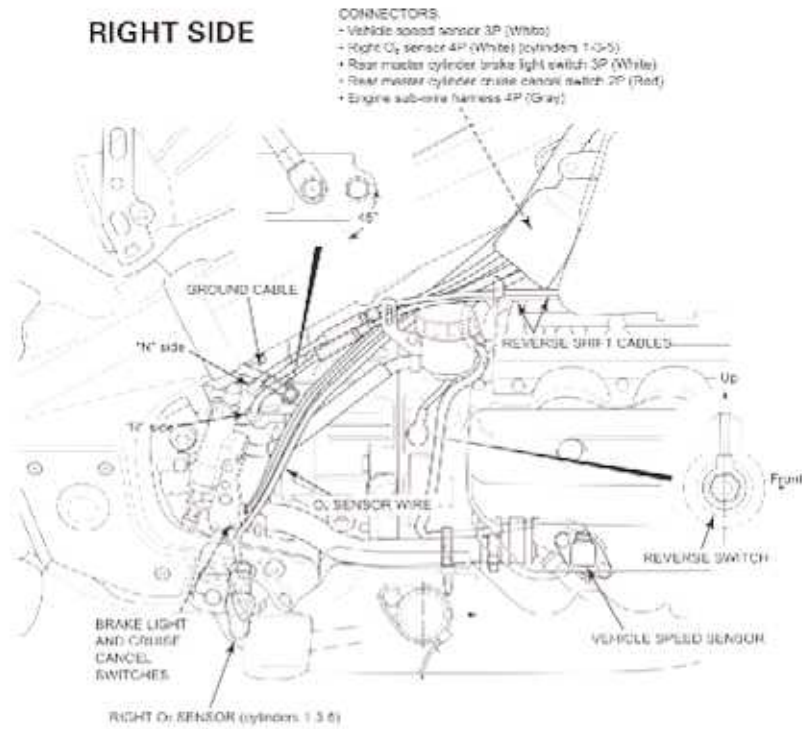
Make sure the hook rubbers are on the tabs, then install the rear exhaust protectors. Tighten the bolt to the specified torque.

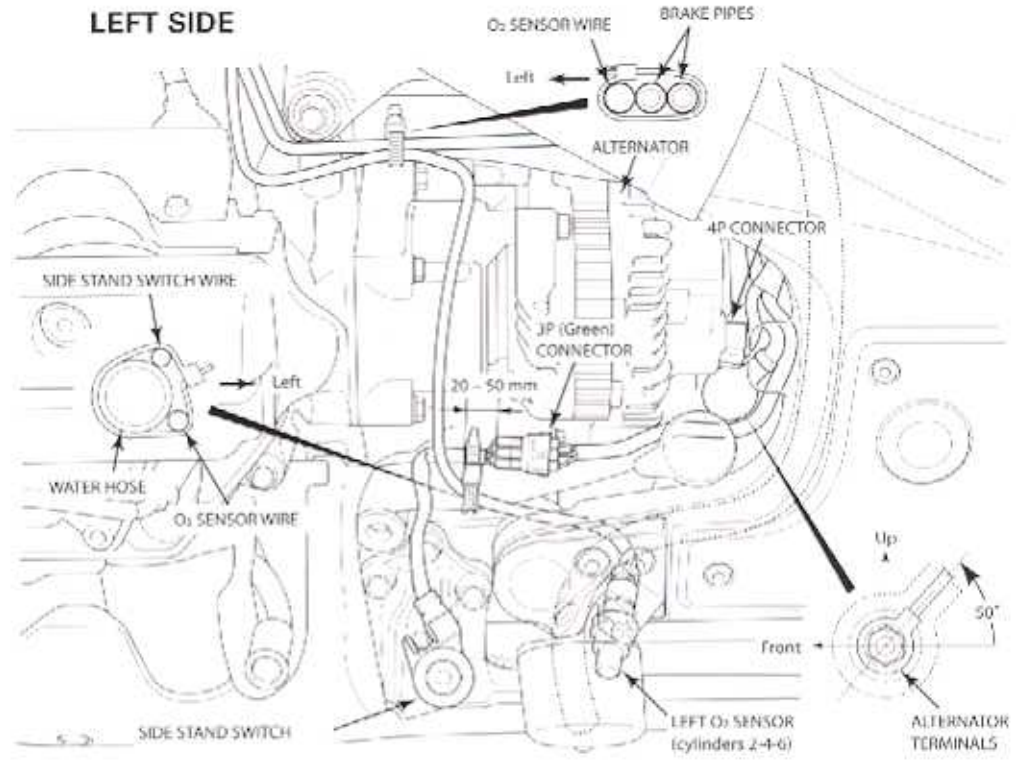
TORQUE: 14 N·m (1.4 kgf·m, 10 lbf·ft)



5. ROUTE THE O₂ SENSOR WIRES

Install and route the sensor wires and secure with the wire bands in the areas shown.



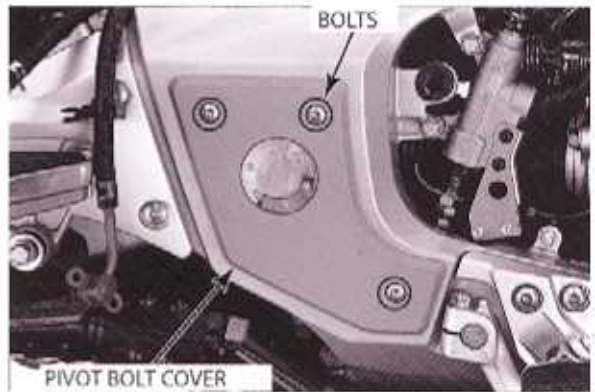


6. INSTALL THE RIDER FOOTPEGS



7. INSTALL THE SWINGARM PIVOT COVERS

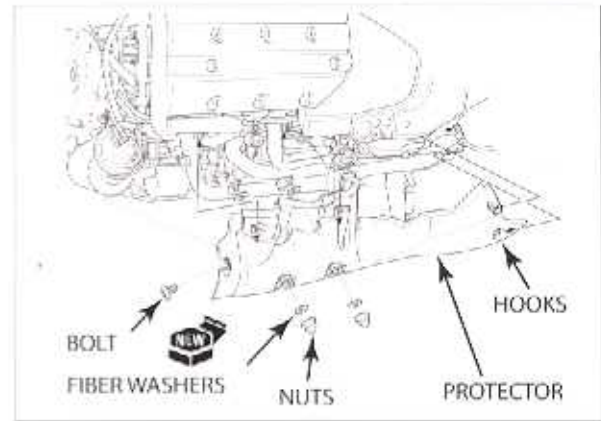
Install the mounting bolts and tighten securely.



8. INSTALL THE FRONT EXHAUST PIPE PROTECTOR

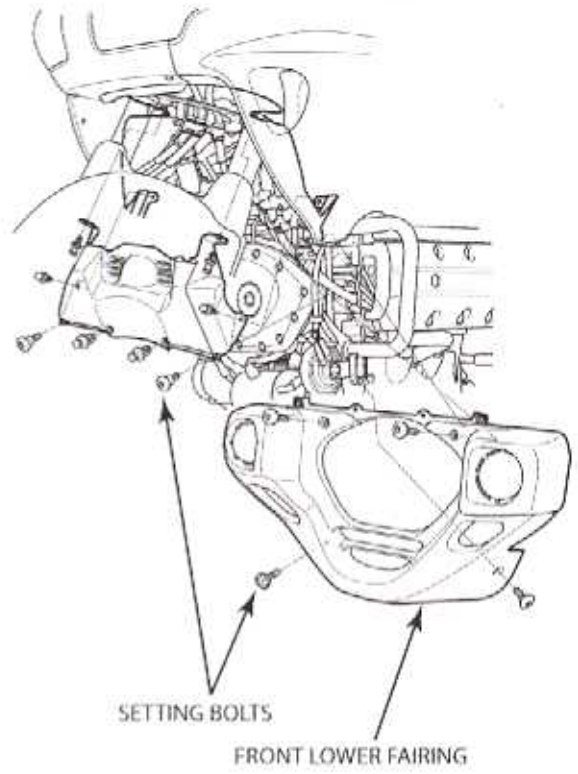
Make sure the hook rubbers are on the tabs. Insert the four hooks into the tabs, then install the lower portion of the protector on the studs.

Using new fiber washers provided in the parts kit, install the bolt, two nuts, and four fiber washers.



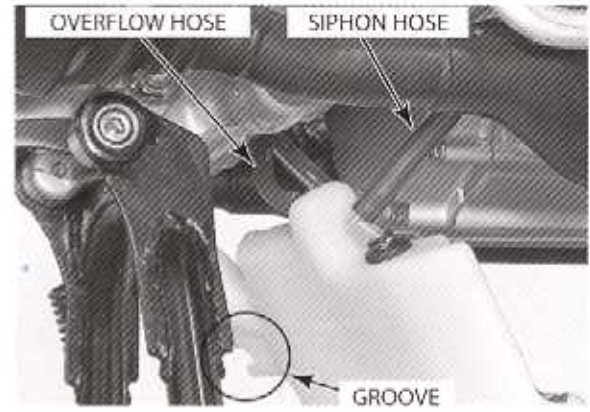
9. INSTALL THE FRONT LOWER FAIRING

Install the four setting bolts and front lower fairing.

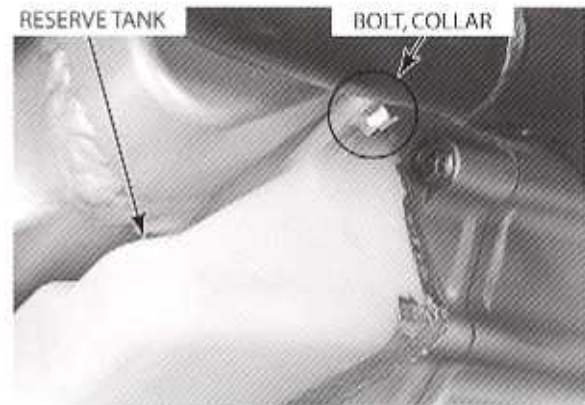


10. INSTALL THE COOLANT RESERVE TANK

Connect the siphon hose and overflow hose.
Install the reserve tank by hooking the groove
into the frame properly.



Install the collar and mounting bolt. Tighten the
bolt securely.



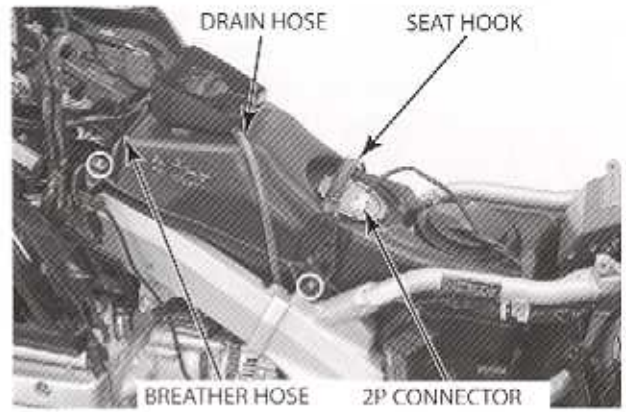
11. INSTALL THE FUEL TANK

Tilt the fuel tank to the right and install it from the left side of the motorcycle.

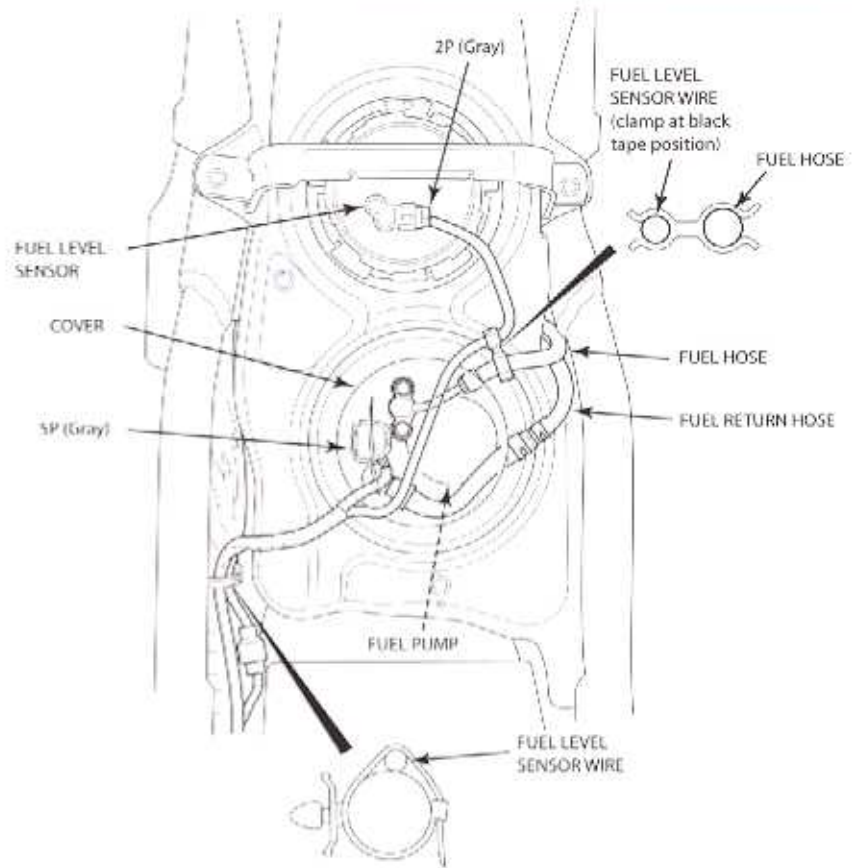
Install the two washers, four bolts, and seat hook.

Connect the following:

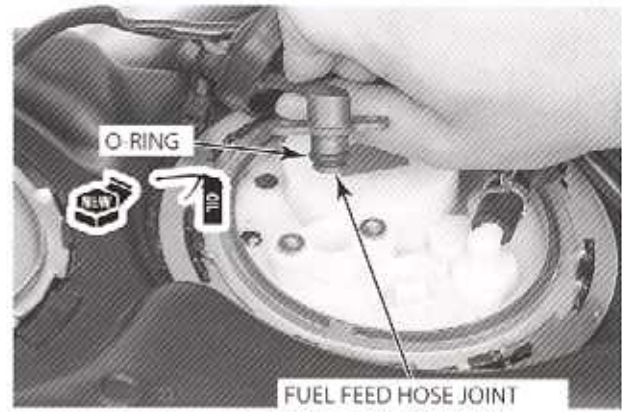
- fuel level sensor 2P connector
- fuel tank tray drain hose
- fuel tank breather hose



Route the hoses and wires according to the illustration.



Remove the 8 mm bolt from the fuel return hose and connect the hose to the fuel pump. Secure the hose with the spring clip. Remove the shop towel covering the fuel feed hose joint. Remove the duct tape from the fuel feed hose. Coat a new O-ring with engine oil and install it into the fuel feed hose joint groove. Install the hose joint into the fuel pump by pushing it straight down, being careful not to damage the fuel pump joint. Install and tighten the hose joint bolts.



TORQUE: 10 N·m (1.0 kgf·m, 7 lbf·ft)

Connect the 5P connector to the fuel pump.

12. INSTALL THE BATTERY

Install the wiring harness main ground.

Install the battery in the case.

Install and secure the battery holder with the bolt.

Install the battery plate and trim clip.

With the ignition switched to "OFF," connect the positive (+) cable first, then connect the negative (-) cable.

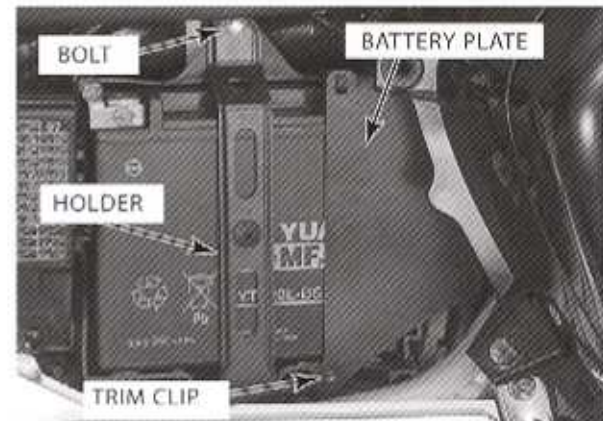
After connecting the battery cables, coat the terminals with grease.

Turn the ignition and engine stop switch to "ON" and check that there is no fuel leakage from the fuel return or fuel feed hoses.

Install the rubber cap over the fuel pump.



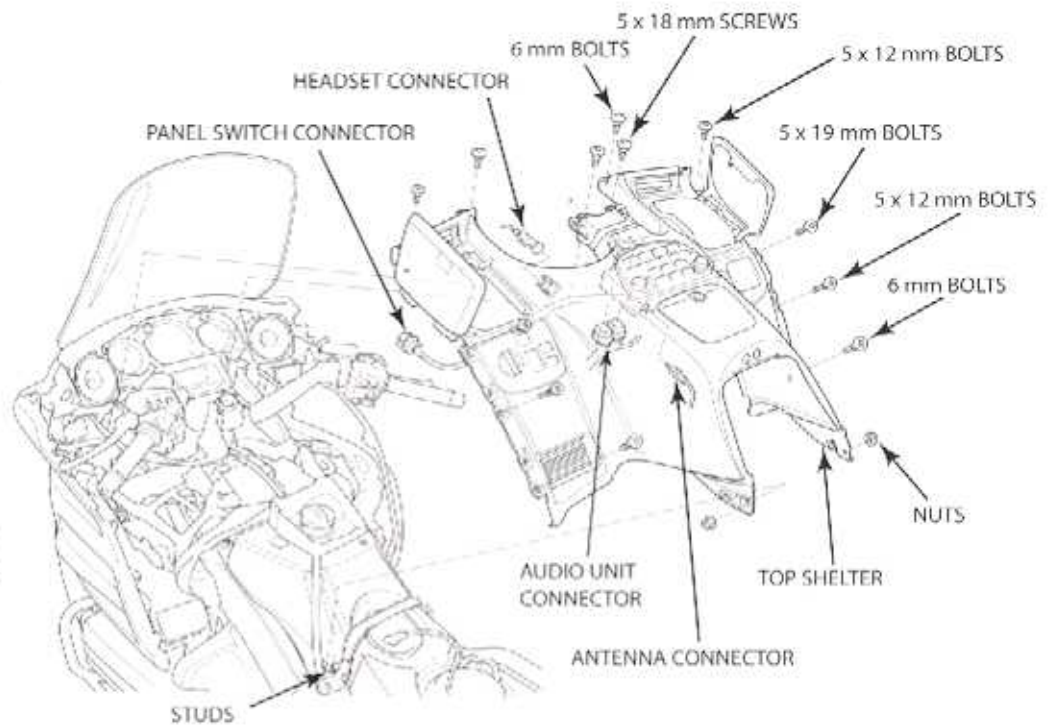
WIRING HARNESS GROUND



13. INSTALL THE TOP SHELTER

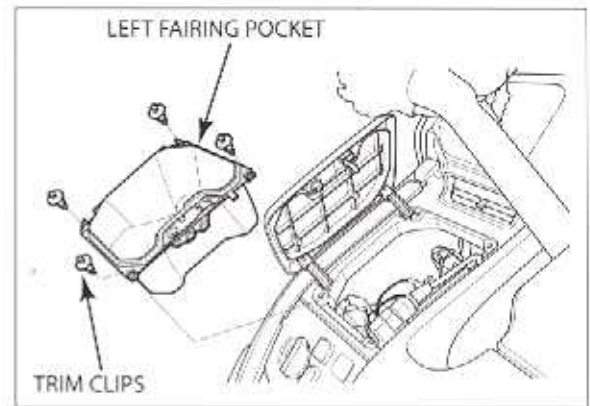
Connect the left panel switch assembly, antenna and audio unit connectors. Install the rear ends of the top shelter on the studs and secure with the two nuts.

Install the two 5 x 18 mm, four 5 x 2 mm, two 5 x 19 mm and four 6 mm setting bolts. Tighten the bolts securely. Place the headset connector in the holder.

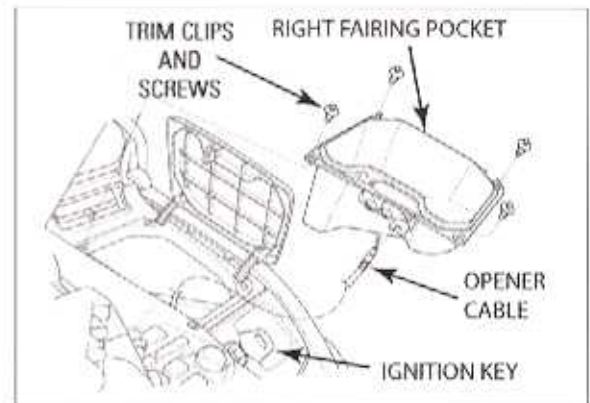


14. INSTALL THE FAIRING POCKETS

Push the opener button and open the left fairing pocket lid.
Install the fairing pocket and secure with the four trim clips.

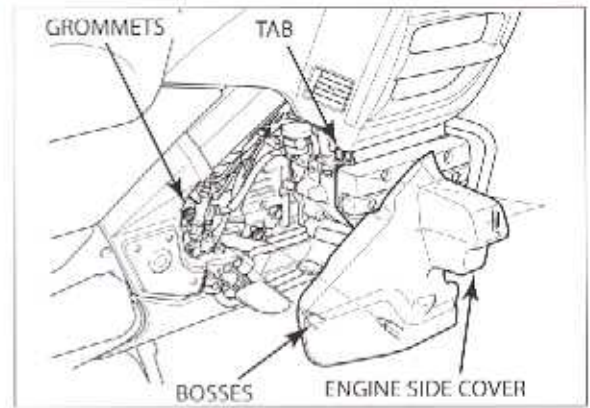


Insert the ignition key into the lock cylinder and open the right fairing pocket lid by turning the key clockwise.
Connect the opener cable and install the fairing pocket. Secure the fairing pocket using two screws and two trim clips.



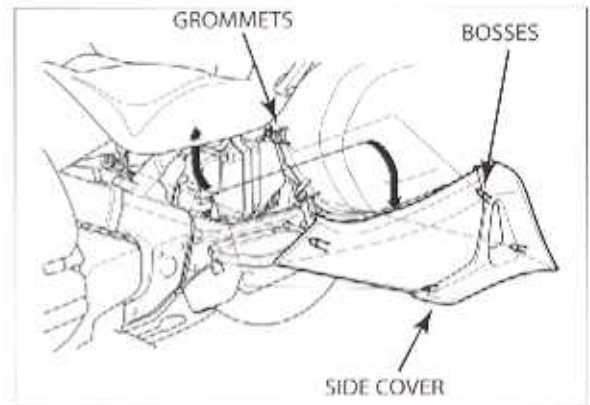
15. INSTALL THE ENGINE SIDE COVERS

Install the engine side cover from the lower side while aligning the slot with the tab of the injector cover. Insert the bosses into the grommets. Repeat for the other side.



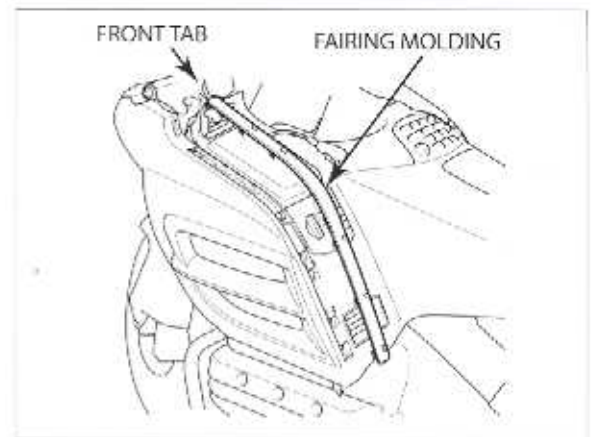
16. INSTALL THE SIDE COVERS

Being careful not to dislodge the grommets, install the side cover by inserting the four bosses into the grommets. Repeat for the other side.



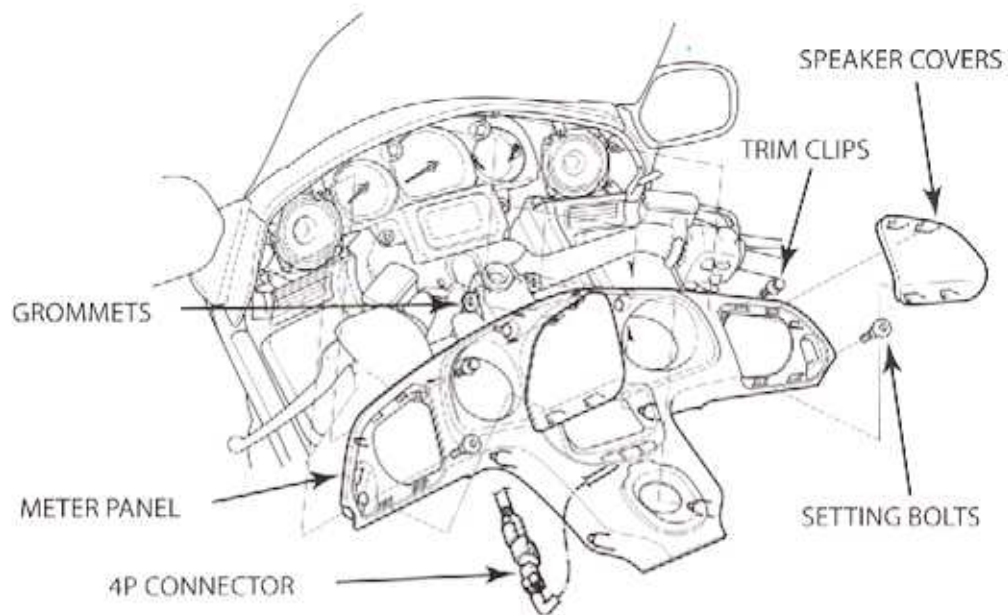
17. INSTALL THE FAIRING MOLDING

Being careful not to damage the tabs, install the fairing molding by gently pressing the bottom tab first, then the other tabs. Repeat for the right side.



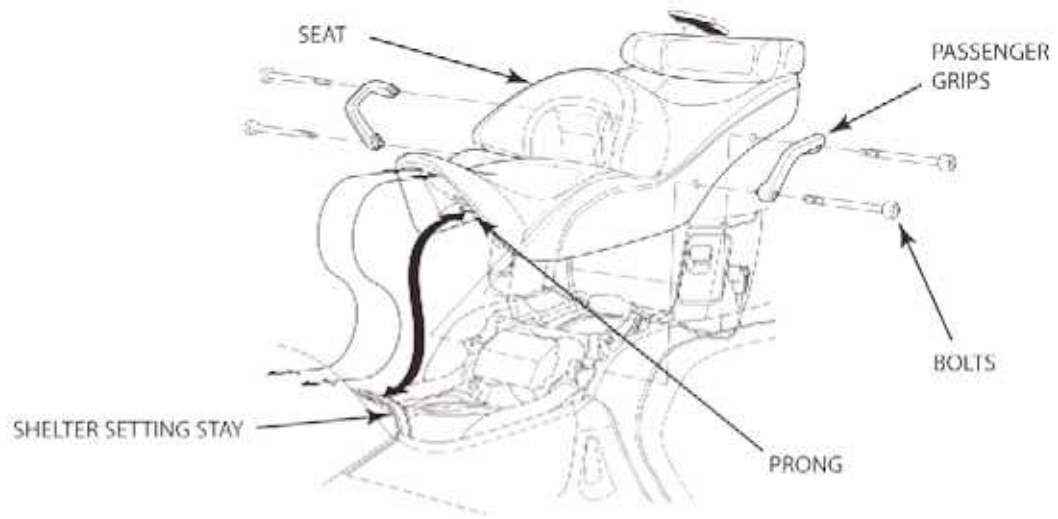
18. INSTALL THE METER PANEL

Being careful not to dislodge the grommets, install the meter panel by aligning the four bosses with the holes and two tabs with the slots. Install the speaker covers by aligning the four tabs. Install the two trim clips and setting bolts.



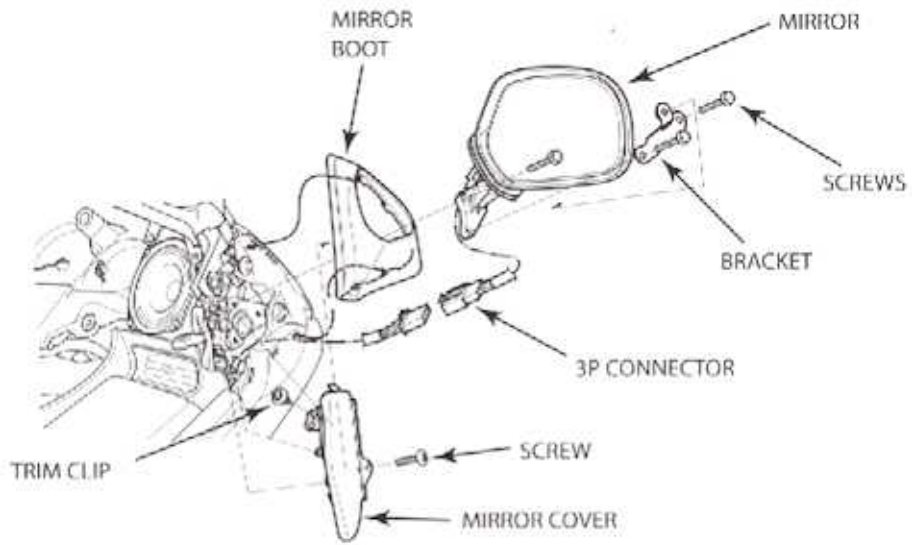
19. INSTALL THE SEAT

Install the seat while inserting the tabs under the top shelter and the prong under the shelter setting stay. Push down the rear of the seat. Install the passenger grips and tighten the four bolts securely.



20. INSTALL THE REARVIEW MIRRORS

Connect the turn signal light 3P connector.
Install the three screws, bracket and mirror.
Install the trim clip, screw, and mirror cover.
Install the mirror boot from the front fairing.
Repeat for the left side.



21. INSTALL THE HANDLEBAR WEIGHTS

Install the handlebar weight and secure with the mounting screw. Use **HondaLock 1** (P/N: 08713-0001, H/C: 2963825) on the mounting screw. Repeat for the other side.

**22. INSTALL THE ANTENNA WHIP(S)****23. INSTALL ACCESSORIES**

If removed, reinstall any Genuine Honda or after-market accessories to their original configuration.

24. CHECK PROPER OPERATION

Check proper operation of the throttle, brakes, clutch, radio, accessories, and all functions of the LH and RH handlebar switches.

**25. COMPLETE THE WARRANTY
INFORMATION**

Refer to Service Bulletin GL1800/A #14 to submit
warranty information.



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