

OPERATOR'S MANUAL
SUPPLEMENT
Model No. 640L

⚠ WARNING:

Read Engine
Owner's Manual,
Vehicle Operator's
Manual, and
Supplement
Carefully Before
Operating Vehicle.

Parts List



4404 Engle Ridge Drive, Fort Wayne, IN 46804
ph (260) 432-1596 fx (260) 432-7870

**THIS VEHICLE IS FOR
OFF-ROAD USE ONLY**

BEFORE OPERATING THIS VEHICLE, THE OWNER AND/OR OPERATOR MUST UNDERSTAND THE VEHICLE WAS NOT DESIGNED OR MANUFACTURED TO MEET SPECIFICATIONS FOR USE ON STREETS, HIGHWAYS, OR THOROUGHFARES AND HAVE READ AND HAVE AN UNDERSTANDING OF ALL THE INSTRUCTIONS FOR SAFE ASSEMBLY AND OPERATION AS WELL AS THE INSTRUCTIONS GOVERNING THE ENGINE AND OTHER PORTIONS OF THE VEHICLE.

PARTS LIST MODEL 640L

REF	PART #	DESCRIPTION
1	13376-2	FRAME – BLACK
2	10834	BOLT ½-13 X 7.00 HHCS G5 ZINC
3	9145	BOLT 3/8-16 X 1.750 HHCS G5 ZINC
4	12015	SHOCK ABSORBER
5	13217-40Z	TOP SWINGARM W/ZERK - SILVER
6	9022	WASHER ½ STD FLAT ZINC
7	13343	BOLT ½-13 X 5.50 HHCS G8 ZINC
8	13297-2	LEFT SPINDLE – BLACK
NI	13296-2	RIGHT SPINDLE – BLACK
9	13191	WH ASM 16 X 6.5 – 8 BADLAND SILVER
NI	13486	REPLACEMENT TIRE FOR #9
10	13354	NUT 5/8-11 CENTERLOCK HEX
11	13503	NUT – ½-13 CENTERLOCK HEX ZINC
12	13281-2Z	SPINDLE PIVOT W/ZERK - BLACK
13	12141	BOLT SHOULDER ½ X 1.875
14	9146	BOLT 3/8-16 X 1.500 HHCS G5 ZINC
15	13316	TIE ROD ASSY 15INCH (INCL 67 – 71)
16	13216-40Z	BOTTOM SWINGARM W/ZERK – SILVER
17	9091	WASHER 3/8 FLAT SAE - ZINC
18	1447	BOLT SHOULDER - 5/16-18 X 11/16
19	6293-16	BRAKE PEDAL
NI	9929	BLACK VINYL CAP – ¼ INCH
21	9057	NUT ½-20 TOPLOCK HEX ZINC
22	1854	WASHER NBR 14 FLAT ZINC
23	1189	NUT 5/16-18 TOPLOCK HEX ZINC
24	13375-2	BRAKE ROD LONG – BLACK
25	1389	BUSHING .25 ID X .031G X .313 – ZINC
26	9503	PEDAL SPRING – BRAKE
27	9160	BOLT ½-20 X .875 HHCS G5 ZINC
28	1848	BOLT ½-20 X 1.25 HHCS G5 ZINC
29	9158	BOLT 3/8-16 X 2.25 HHCS G5 ZINC
30	9125	WASHER 3/8 FLAT USS W ZINC
31	13456	BOLT 3/8-24 X 1.00 NYLOCK HHCS G5
32	13454-2	STEERING LINK BRACKET – BLACK
33	4355	TIE ROD ASSY 9.50INCH (INCL 72 – 76)
34	C1000	RACK & PINION ASSEMBLY
37	6442	BRAKE HANDLE COVER – RED
39	13604	PARKING BRAKE CABLE

REF	PART #	DESCRIPTION
42	C1001	HYDRAULIC BRAKE ASSEMBLY (INCL. PARTS C1002 – C1008 & #141)
NI	C1002	CALIPER ASSY
NI	C1003	BRAKE PAD SET
NI	C1004	MASTER CYLINDER ASSY
NI	C1005	BRAKE HOSE – CALIPER TO MAST CYL
NI	C1006	BRAKE RESEVOIR ASSY
NI	C1007	BRAKE HOSE – RES TO MASTER CYL
NI	C1008	BANJO BOLT AND WASHERS
43	13309-2	BRAKE LINK - BLACK
44	13355	NUT ¾-10 CENTERLOCK HEX ZINC
45	1031	KEY 3/16 SQ X .500
46	13381	SPROCKET 15T 420P ¾ BORE
47	1194	WASHER ¾ SAE FLAT - ZINC
48	12783	BEARING ¾ ID X 1 ¾ OD W/SNAP RING
49	13372	SPANNER ¾ ID X 11G X 7.250
50	13385	JACKSHAFT ¾ X 12.500
51	13369-2	CHAIN COVER PLATE – BLK
52	8227	TINNERMAN ¼-20 CLIP
53	1398	WASHER 21/64ID X 1 ¼ ZINC
54	9176	BOLT 5/16-18 X 1.000 HHCS G5 ZINC
55	13286	CHAIN COVER
56	1876	BOLT ½-20 X .625 HH WF ZINC
57	13382	SPROCKET 25T 420P ¾ BORE
58	13308	CHAIN 420P X 58 (INCLUDES #59)
59	2037	MASTER LINK 420P
60	13307	CHAIN 420P X 100 (INCLUDES #59)
61	8251	THROTTLE CABLE 74.50 LONG
62	6309-16	THROTTLE PEDAL
63	9502	PEDAL SPRING – THROTTLE
64	13323-2	STEERING PIVOT - BLACK
65	2386	BOLT 3/8-16 X 3.500 HHCS G5 ZINC
66	9674-16	SPACER 3/8 ID X 3/8 L ZINC
67	13315	TIE ROD END – LEFT
68	13342	NUT ½-20 HEX JAM – LEFT
69	13313	TIE ROD – 15.00
70	9169	NUT ½-20 HEX JAM – RIGHT
71	13314	TIE ROD END – RIGHT
72	1414	TIE ROD END – RIGHT

REF	PART #	DESCRIPTION
73	9092	NUT 3/8-24 HEX JAM – RIGHT
74	4352	TIE ROD – 9.50
75	9024	NUT 3/8-24 HEX JAM – LEFT
76	1415	TIE ROD END – LEFT
77	9085	NUT 3/8-16 TL HEX ZINC
78	13388	BOLT 3/8-16 X 3.750 HHCS G5 ZINC
79	13339-40	REAR BAR - SILVER
80	13264-2	CENTER BAR - BLACK
81	6452	BOLT 3/8-16 X 5.00 HHCS G5 ZINC
82	13259-40	FRONT BAR - SILVER
83	6320	HEADREST
84	8778	HARNES LAP/SHOULDER
85	5447	SAFETY FLAG – 6 FT
86	11361	FLAG MOUNTING BOLT
87	2449	TINNERMAN ¼ NUT
88	11387	LOOP CLAMP 1.25 ID
89	13387-2	LEFT LIGHT BRACKET – BLACK
NI	13386-2	RIGHT LIGHT BRACKET - BLACK
90	13097	RUNNING LIGHT - PAIR
NI	13096	REPLACEMENT BULB 35 WATT
NI	9389	REPLACEMENT FUSE 10AMP
NI	13475	STOP SWITCH/RUN LIGHT WIRING
WD	13590	WIRING HARNESS
91	12496	STEERING WHEEL
92	9103	BOLT ½-20 X 2.00 HHCS G2 ZINC
93	12481	CAP STEERING WHEEL
94	1263	NUT 5/16-18 HEX WHIZ FLG ZINC
95	6734	SEAT SLIDE (PAIR)
96	12550-2	SEAT FRAME - BLACK
97	12634	SEAT
98	12638	SIDE PANEL – RIGHT
NI	12637	SIDE PANEL – LEFT
99	13504	BOLT ½-13 X 1.00 HHCS G5 ZINC
100	9006	BOLT ½-20 X .500 WF ZINC
101	2388	NUT 3/8-24 HEX ZINC
102	1847	BOLT ½-20 X 1.00 HHCS G5 ZINC
103	13252	BOLT 3/8-16 X 5.000 FULL THD G5 ZINC
104	13491	BELT COVER ASSEMBLY
105	1119	SPACER .625 ID X 1.062 OD X .12

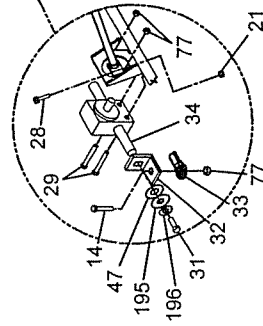
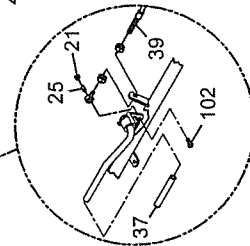
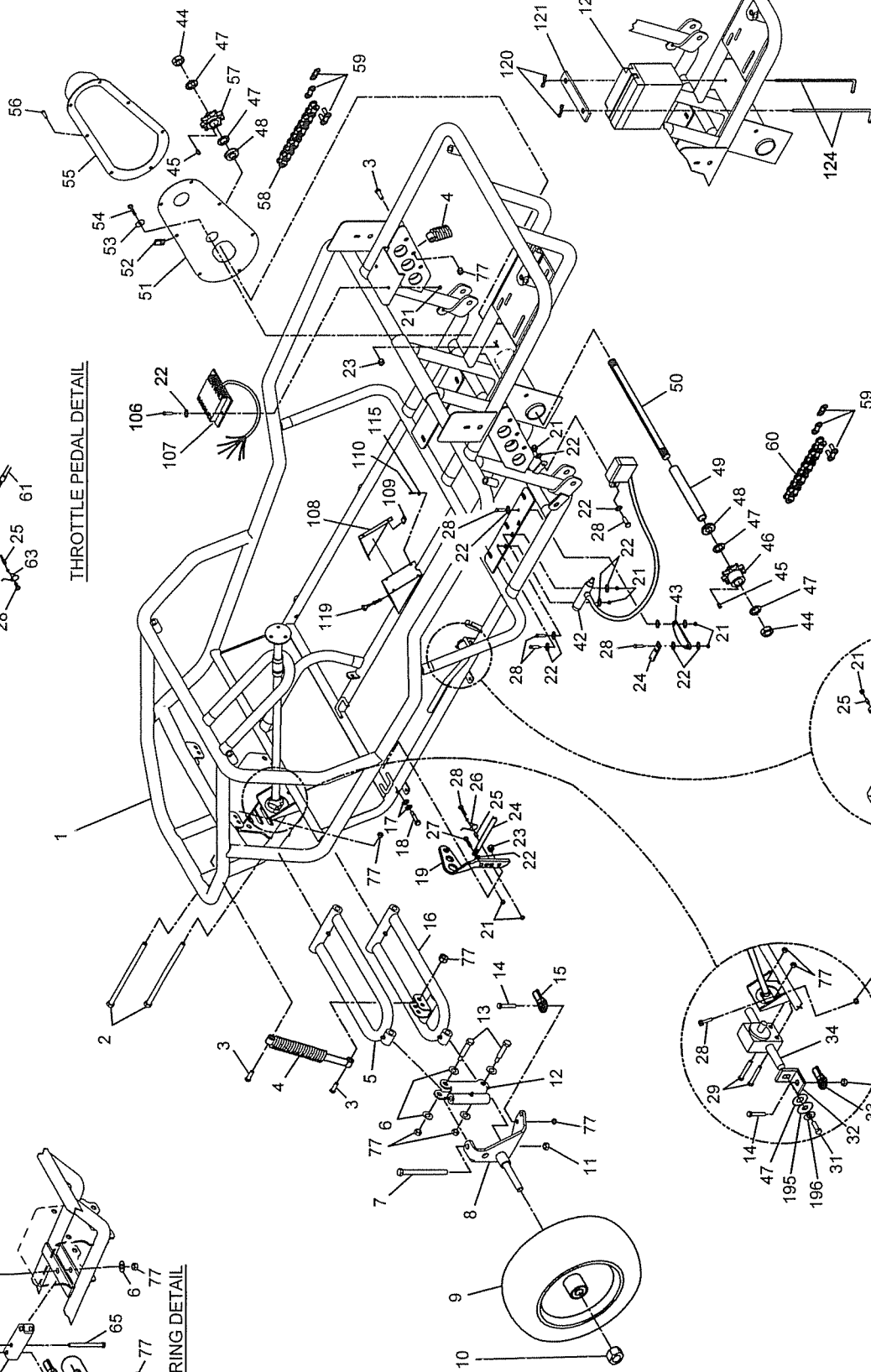
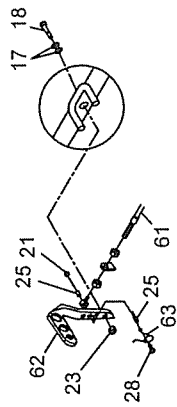
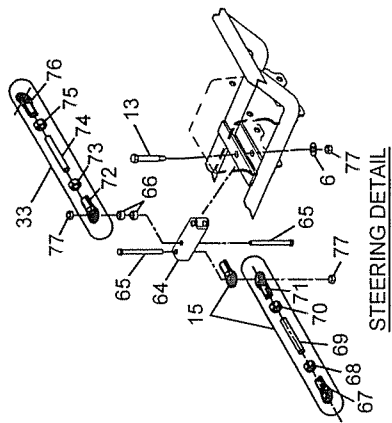
PARTS LIST MODEL 640L

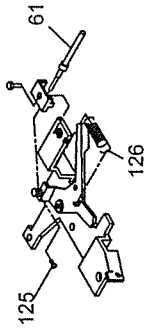
REF	PART #	DESCRIPTION
106	1849	BOLT ¼-20 X 1.500 HHCS G2 ZINC
107	12761	VOLTAGE REGULATOR
108	6803-2	CONTROL PANEL COVER – BLACK
109	5135	TINNERMAN NUT
110	6046	BOLT #10-24 X .500 HHMS ZINC
111	12252	ENGINE – 10HP COIL & ELEC START
112	9101	BOLT 5/16-24 X .500 HHCS G5 ZINC
113	9060	WASHER 5/16 TYPE A PLAIN
114	1136	NUT 5/8-18 CENTERLOCK HEX JAM Z
115	6039	WASHER #10 IL ZINC
116	12346	DRIVE BELT – 10HP
117	5090	BEARING 5/8ID X 1 3/8OD W/ SNAP RING
118	13522	IMPELLER
119	8118	CHOKE CABLE
120	9468	NUT #10-32 NL WING
121	9642-2	BATTERY CLAMP BAR – BLACK
122	13324	BATTERY
NI	12149	BATTERY BOOT – RED
NI	12150	BATTERY BOOT - BLACK
WD	3610	BATTERY CABLE – BLACK
WD	12351	BATTERY CABLE – RED
123	3403	KEY 3/16SQ X 2.000
124	9430	BATTERY HOLD DOWN ROD – ZINC
125	12347	SWIVEL SCREW
126	12348	RETURN SPRING
127	13305	TOP COVER
128	13306	BOTTOM COVER
129	12140	BRONZE BUSHING (INCL W/ #149)
130	13224-2	REAR SUB SWINGARM – BLACK
131	13298	AXLE 1" HEX – YELLOW ZINC
132	13300	BEARING FLANGE
133	9099	BOLT 3/8-16 X 1.000 HHCS G5 ZINC
134	13344-16	SPACER 1.25ID X 12G
135	13359-2	BELT COVER PLATE – BLACK
136	G0725	LOOM 7.25 X 1.625ID
137	13302	HUB 1 INCH HEX W/STUDS – SILVER
138	1428	NUT ½-20 CONE WHEEL
139	13299	BEARING 1" INCH HEX
140	13303	BRAKE HUB

REF	PART #	DESCRIPTION
141	C1010	BRAKE ROTOR
142	13331	BOLT M8 X 12 HHCS NYLOCK
143	9338	SPROCKET 60T 420P
144	13301	SPROCKET HUB 1 INCH HEX
145	6701	BOLT 5/16-18 X 1.250 SHCS
146	9192	NUT 3/8-16 HEX WF ZINC
147	13190	WHEEL/HUB ASSEMBLY (INCL #148)
148	13488	TIRE – 22 X 11-8 BADLAND
149	13378	REAR SWINGARM BLACK (INCL #129)
150	9188	BOLT 1/2-13 X 1.50 HHCS G5 ZINC
		REF NO'S 151 THROUGH 162 NOT USED
163	2594	DRIVER PULLEY (INCLUDES 164 – 172)
164	**	COVER AND DRIVE PLATE
165	2471	SPRING CLIP
166	**	MOVEABLE FACE AND HUB
167	2472	EXTENSION SPRING
168	2470	CAM ROLLER
169	2474	GUIDE BUSHING
170	2475	COMPRESSION SPRING
171	**	RETAINING RING
172	**	FIXED FACE AND POST
173	2468	PILOT WASHER
174	2467	WASHER 7/16 SL
175	8604	NUT 7/16-20 HEX
176	12350	BOLT STUD 7/16-20 X 4.25 G5 ZINC
177	8402	NUT 7/16-20 TL HEX
178	1082	SPACER 1.00ID X 12G X .750 ZINC
179	3887	SPACER 1.00ID X 1/16
180	8664	DRIVEN PULLEY (INCLUDES 181 – 188)
181	2477	RETAINING RING
182	2478	THRUST WASHER
183	**	FIXED CAM
184	2480	TORSION SPRING
185	2516	BUTTON INSERT
186	**	MOVEABLE FACE AND CAM
187	2483	SPACER
188	**	FIXED FACE AND POST
189	6818	JACKSHAFT 5/8 X 15.500
190	10817	SPANNER 5/8ID X 8.125

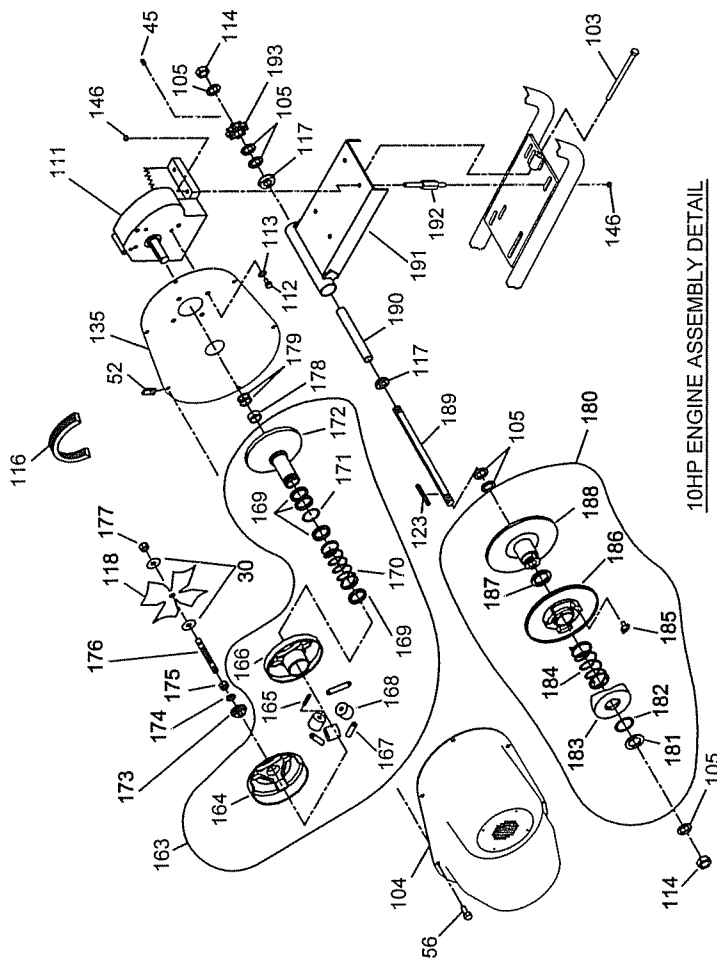
REF	PART #	DESCRIPTION
191	13356-2	TAV CHASSIS 10HP – BLACK 10HP
192	12349	ENGINE STUD ASSEMBLY
193	8761	SPROCKET 15T 420P 5/8 BORE
194	5732	WASHER ¼ IEL ZINC
195	200841	WASHER .391ID X 1.250D X .12
196	1130	WASHER 3/8 SL Z
197	G1300	LOOM 13.00 X 1.625
198	G0312	LOOM 3.125 X 1.625

NI = NOT ILLUSTRATED
WD = WIRING DIAGRAM
** = NOT SOLD SEPERATELY

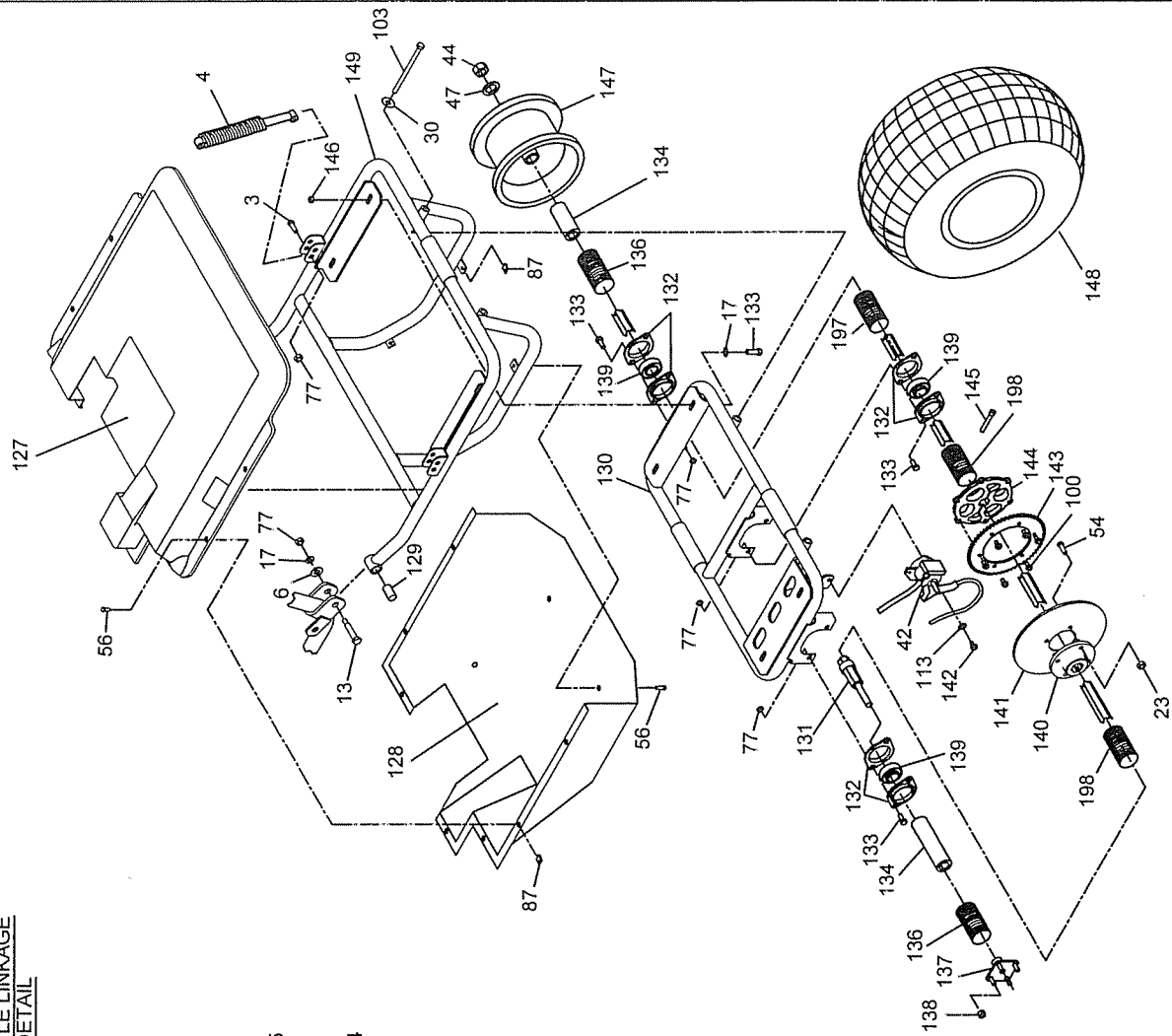




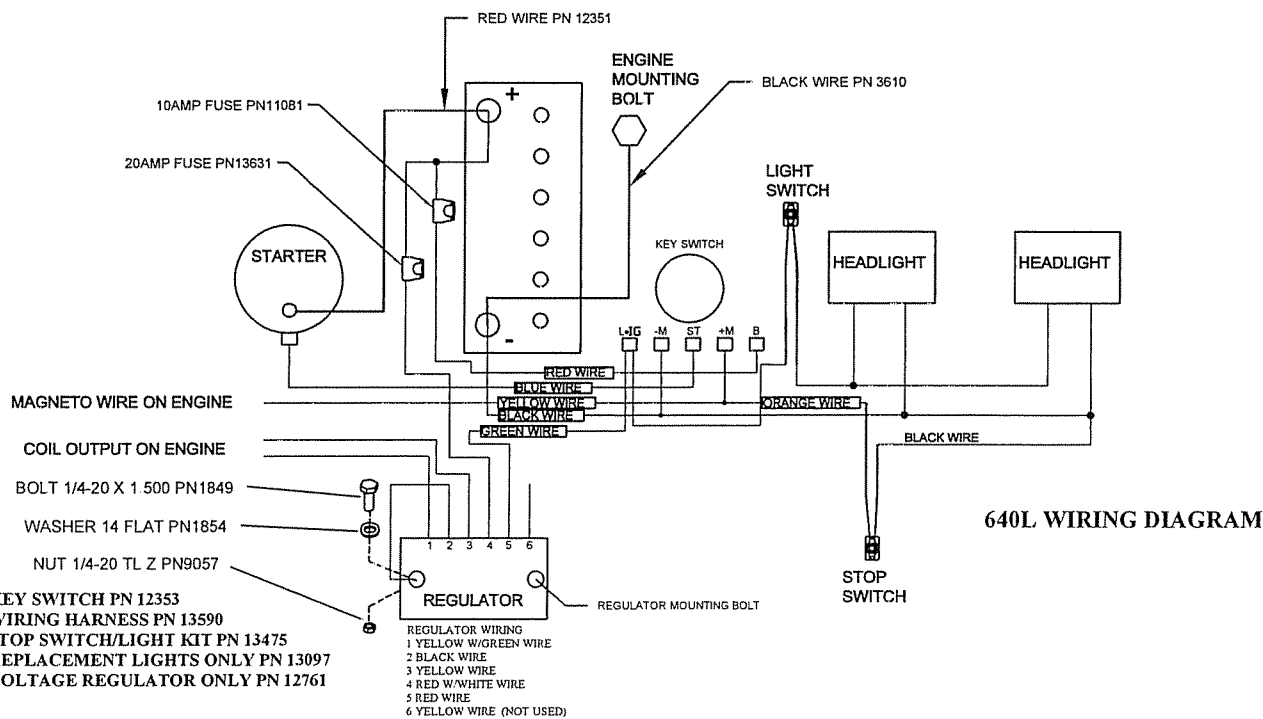
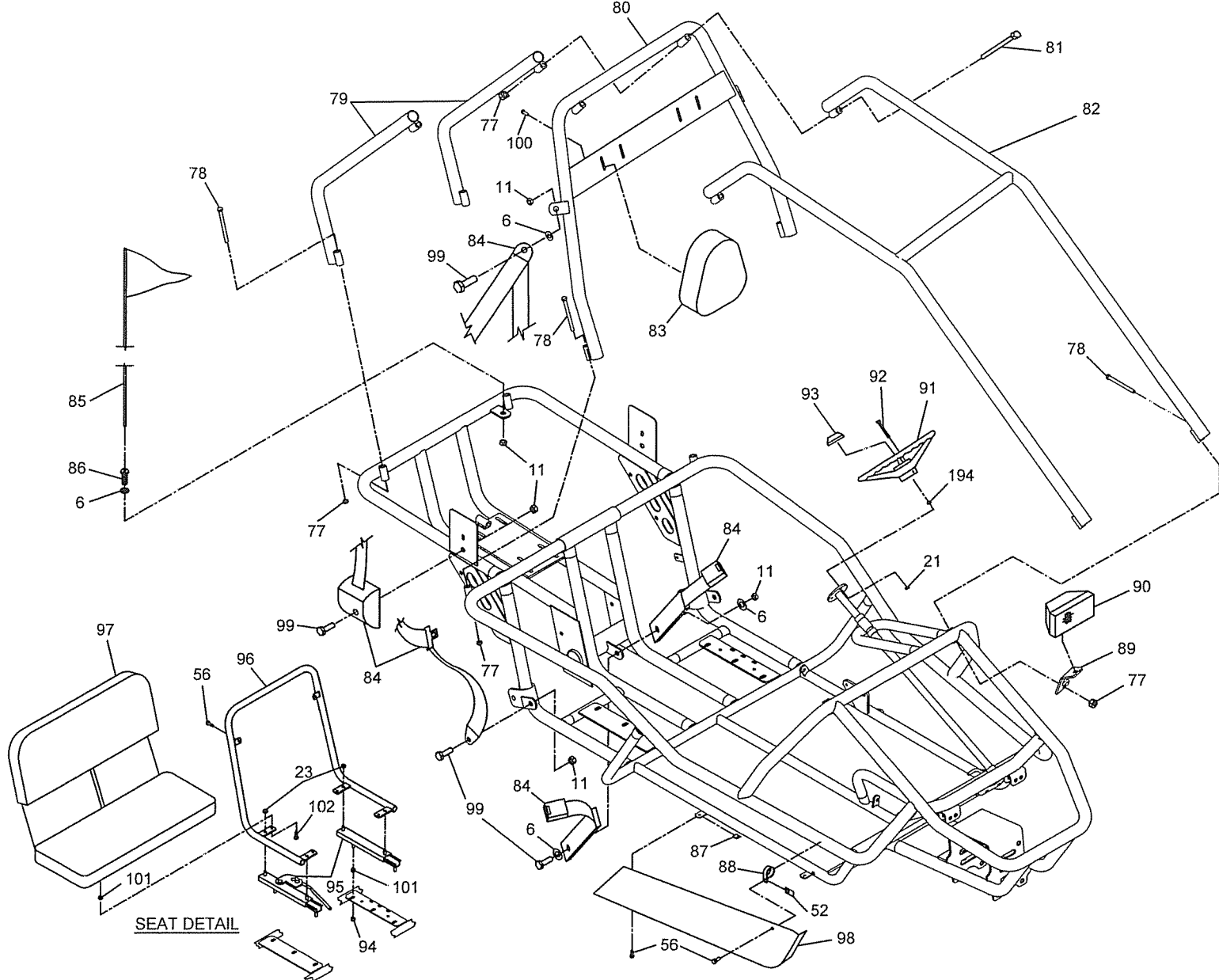
THROTTLE LINKAGE
DETAIL



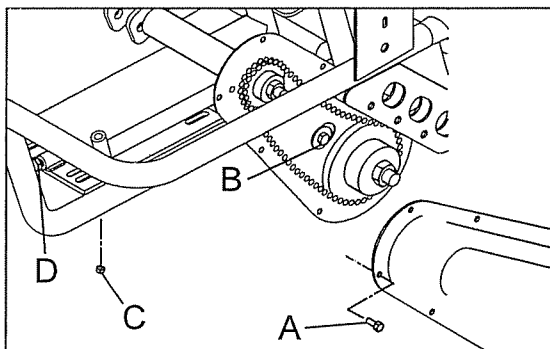
10HP ENGINE ASSEMBLY DETAIL



SWINGARM ASSEMBLY DETAIL

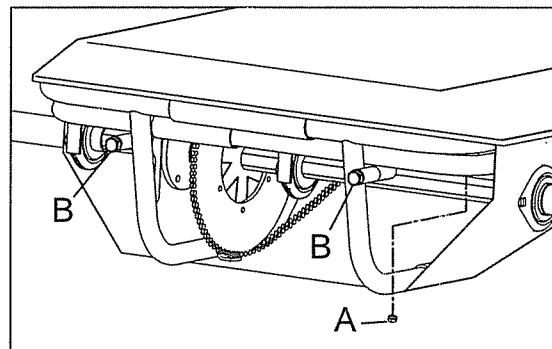


640 MAINTENANCE INSTRUCTIONS



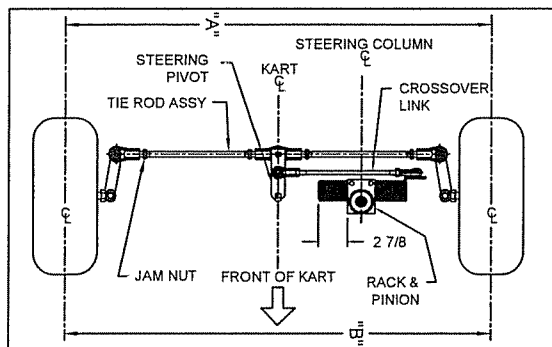
ENGINE CHAIN ADJUSTMENT INSTRUCTIONS

- 1) REMOVE CHAIN COVER BOLTS "A" WITH 3/8" NUT DRIVER OR SOCKET AND REMOVE COVER
- 2) LOOSEN BOLT "B" WITH 1/2" SOCKET AND WRENCH. DO NOT REMOVE
- 3) LOOSEN (4) ENGINE MOUNT NUTS "C" WITH 1/2" SOCKET. DO NOT REMOVE
- 4) TIGHTEN BOLT "D" WITH 9/16" SOCKET UNTIL CHAIN HAS APPROXIMATELY 1/4-3/8" OF SLACK
- 5) RETIGHTEN AND ASSEMBLE IN REVERSE ORDER



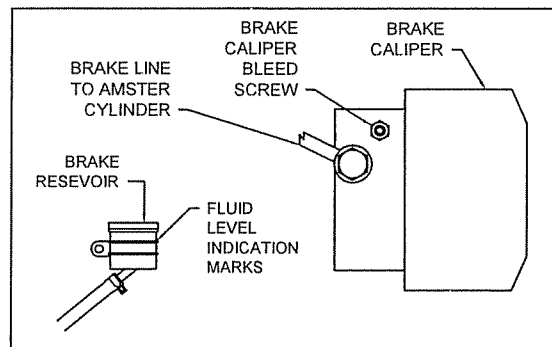
AXLE CHAIN ADJUSTMENT INSTRUCTIONS

- 1) LOOSEN (4) SWINGARM SLIDE BOLTS "A" WITH 9/16" SOCKET AND WRENCH. DO NOT REMOVE
- 2) TIGHTEN BOLTS "B" EVENLY IN AN ALTERNATING FASHION UNTIL CHAIN HAS APPROXIMATELY 1/4-3/8" OF SLACK
- 3) RETIGHTEN BOLTS "A"



STEERING ALIGNMENT INSTRUCTIONS

- 1) LOOSEN ALL TIE ROD NUTS
- 2) ROTATE STEERING WHEEL SUCH THAT DIMENSION FROM THE END OF THE RACK AND PINION TO THE RACK AND PINION BODY IS 2 7/8". REF ABOVE DIAGRAM
- 3) ADJUST THE CROSSOVER LINK SUCH THAT THE STEERING PIVOT RUNS PARALLEL TO THE CENTERLINE OF THE KART AS SHOWN
- 4) TIGHTEN CROSS OVER LINK JAM NUTS
- 5) ADJUST RH AND LH TIE ROD ASSEMBLIES SUCH THAT DIMENSION "A" IS 3/8"-1/2" LONGER THAN DIMENSION "B"
- 6) RETIGHTEN RH AND LH TIE ROD JAM NUTS



BRAKE BLEED/ADJUSTMENT INSTRUCTIONS

- 1) INSPECT FLUID RESEVOIR BEHIND SEAT ENSURE THAT THE FLUID LEVEL IS BETWEEN THE INDICATION MARKS
- 2) ADD DOT 3 BRAKE FLUID IF REQUIRED
- 3) UNCAP AND LOOSEN BRAKE CALIPER BLEED SCREW
- 4) HAVE A SECOND PERSON DEPRESS THE BRAKE PEDAL SLOWLY UNTIL THE PEDAL BOTTOMS OUT
- 5) HOLD THE PEDAL IN THE DEPRESSED POSITION UNTIL THE BLEED SCREW IS RETIGHTENED
- 6) PUMP THE BRAKE PEDAL TWO TO THREE TIMES AND REPEAT PROCEDURE UNTIL THE PEDAL FEELS FIRM DURING THE PEDAL STROKE
- 7) AIR BUBBLES SHOULD BE SEEN AT THE BLEED SCREW DURING THE BLEED PROCEDURE UNTIL PEDAL BECOMES FIRM
- 8) TIGHTEN AND RECAP THE BLEED SCREW