

## Chop Source Deluxe XS650 Engine Stand Bracket Assembly Instructions

The following instructions explain the process to assemble the Chop Source Deluxe XS650 Engine Stand Brackets. If you have any questions regarding any part of the assembly process after reading these instructions, please email [sales@chopsource.com](mailto:sales@chopsource.com) or call/text (651) 300-9575.

### Deluxe XS650 Engine Stand Brackets Description

These brackets are used to mount your Yamaha XS650 engine to a typical car engine stand, and it allows the engine to be rotated upside down to split the cases. To do this, the support arms are installed, and the engine is spun upside down on the stand. The lower links can then pivot out the way to allow you to split the case halves. **The support arms are only needed when rotating the engine upside down.**

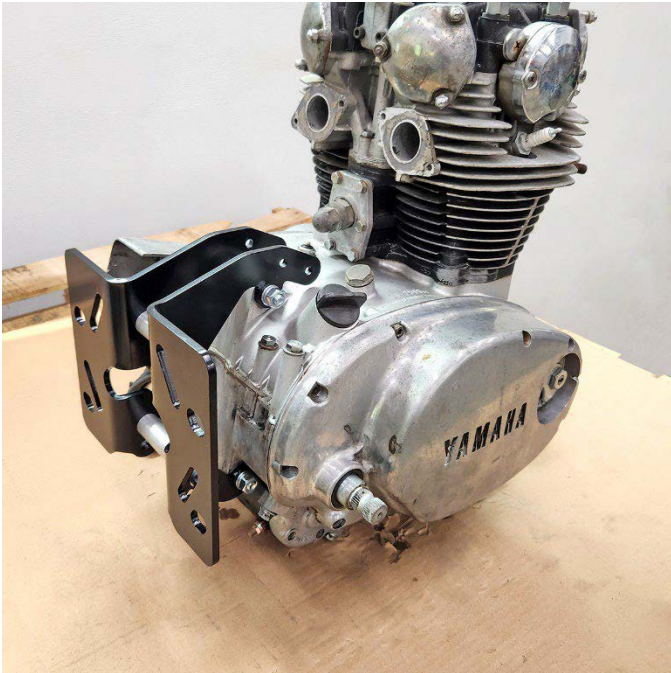
### Assemble Brackets Together

Assemble the brackets as shown below using the two aluminum spacers, one short 10mm bolt, and one long 10mm bolt (each with two washers, and a nut). You do not need to use the lock washers provided unless you are going to use the brackets to make an engine test stand (run the engine on the stand). Note the position and orientation of the lower links. The longer bolt goes through the top holes of the lower bent tabs and can be kept loose for now. Tighten the short bolt to 15ft-lbs.



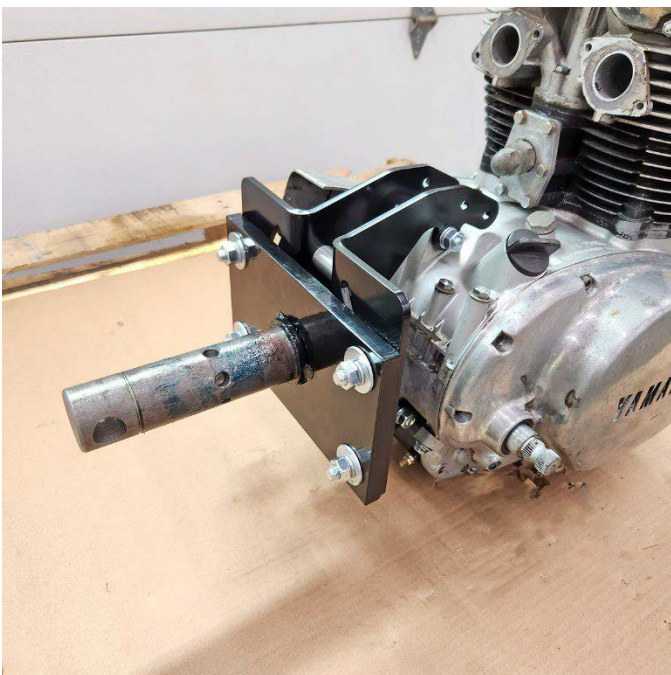
## Attach the Bracket Assembly to the Engine

Attach the bracket assembly to the engine using the remaining 10mm bolts, washers, and nuts. Attach the shorter bolt to the top first, then use the longer bolt to attach the lower links to the engine. Tighten all hardware to 15ft-lbs.



## Attached the Brackets and Engine to the Engine Stand

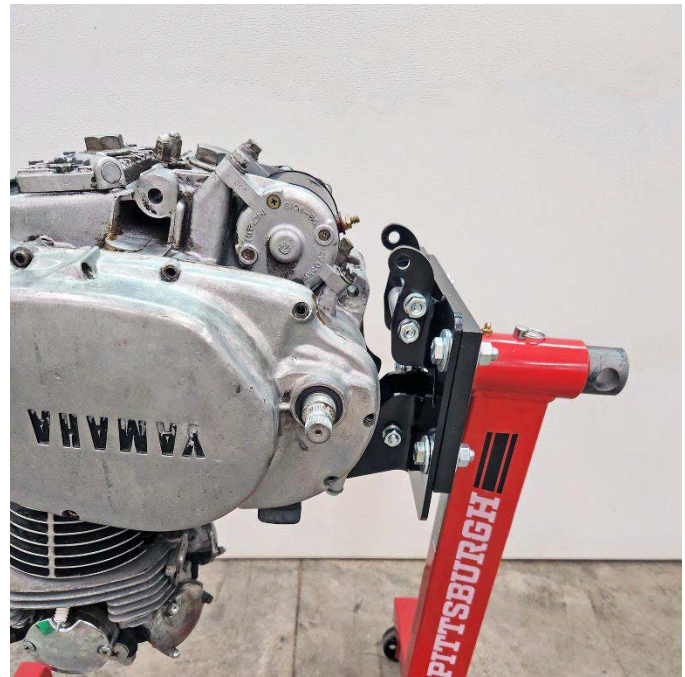
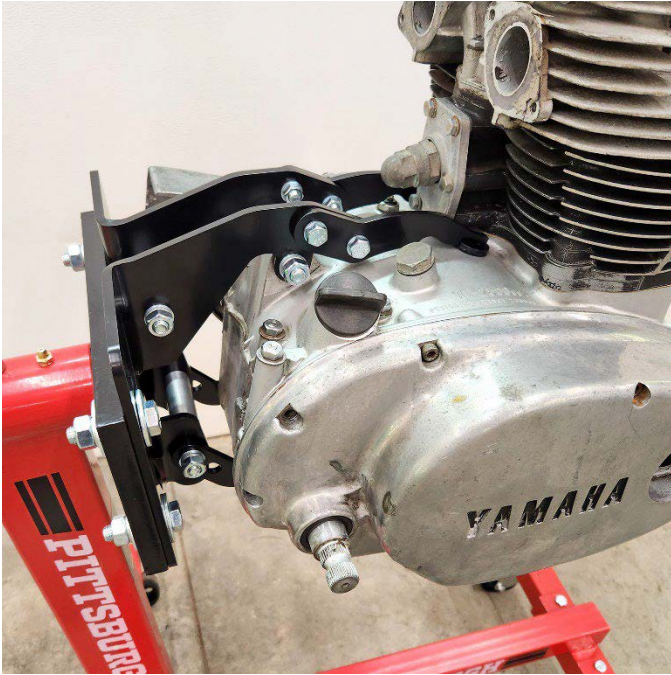
Choose the slots or holes in the brackets that line up with your engine stand mounting plate, and attach them with four 12mm bolts, washers, and nuts. Install the engine stand plate back onto your engine stand.





## Rotating the Engine Upside Down

To rotate the engine upside down, install the support arms using 8mm bolts, washers, and nuts. After ensuring all hardware is tight, you can rotate the engine upside down. To split the cases, loosen the 10mm lower link pivot bolt, and remove the 10mm bolt connecting the lower links to the engine. Pivot the links out of the way. The lower links can be removed completely if more clearance is required. **The support arms are not required when the engine is in the upright position. The support arms must be removed before removing the brackets from the engine, or they will get caught under the cam chain adjuster casting on the cylinders.**



If anything is missing, email [sales@chopsource.com](mailto:sales@chopsource.com) or call (651) 300-9575 and the missing parts will be sent to you right away.