

SUBJECT: CFORCE 400/500 Rear Gearcase Replacement

VEHICLE(S) AFFECTED: MY2021 CFORCE 400/500 ATVs (606 VINs)

ISSUED: October 12, 2021

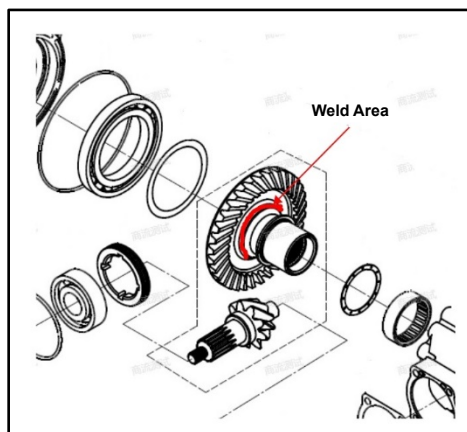
PLEASE NOTE: This dealer-only publication is intended to inform service personnel regarding factory authorized warranty repairs to CFMOTO products. No other warranty coverage applies, is implied, or is to be inferred as a result of this publication. Questions regarding this publication should be directed to CFMOTO-USA Technical Service.

Dealer Sign-off Section – Please notify the appropriate personnel

Sales Manager	
Warranty/Svc Manager	
Technician(s)	

ISSUE:

CFMOTO has identified a potential for rear gear case failure on a select number of MY2021 CFORCE 400 and 500 ATVs due to a welding process error at the base of the ring gear. A limited number of ATVs are affected.



MANDATORY Bulletin WAR-2021-07 has been issued for replacement of the rear gear case assembly on the select vehicles. This bulletin is required to be performed on the affected vehicles before they are sold, or at the first service opportunity if already sold.

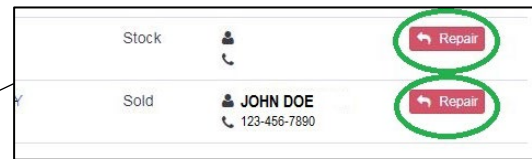
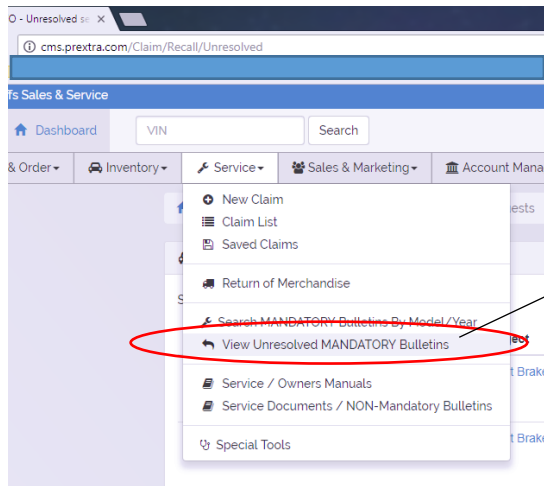
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CFMOTO DEALER RESPONSIBILITY:

NOTE: All affected CFORCE 400/500 Vehicle Identification Numbers are connected to WAR-2021-07 in the CFMOTO warranty system. WAR-2021-07 applies to these vehicles ONLY.

Dealerships are required to check their CFMOTO Dealer Portal account for affected VINs sold and unsold, and contact affected registered owners to have this Mandatory Warranty Bulletin repair completed:

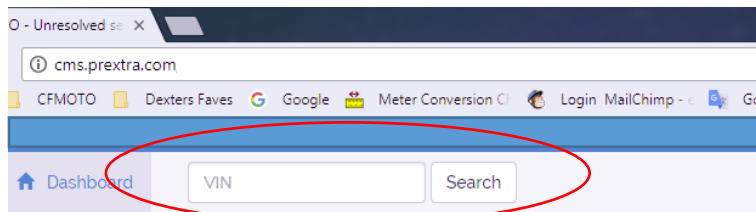
Navigate: 'Service' > 'View Unresolved MANDATORY Bulletins'. Vehicles in your unit history (sold and unsold) that require a Mandatory Warranty Bulletin repair will display. Clicking the red 'REPAIR' button auto-fills a claim. **Do not submit the claim until parts are ordered and work has been completed.** Claims are approved and paid when submitted.



Contact CFMOTO Technical Service for assistance if you determine a vehicle requires WAR-2021-07, but is not listed as an affected vehicle in the warranty system.

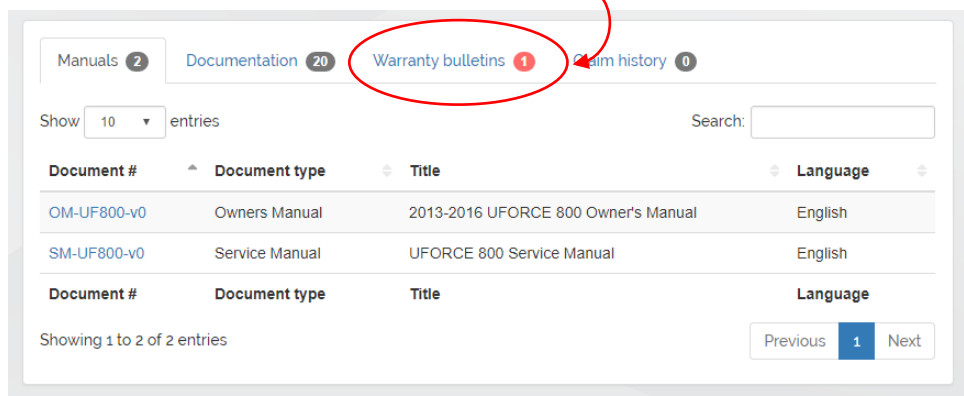
OR, to check a VIN:

Enter the VIN into the Dashboard Search:



The 'Warranty bulletins' tab will indicate if a bulletin exists.

If the warranty tab has no red indicator, the vehicle was built before or after the issue and it is not affected.



Labor Compensation:

2.0 Hr Labor/unit* (*0.2hr added to the labor time for shipping cost and supplies)

Part(s) Required:

PART NUMBER	DESCRIPTION	QUANTITY PER UNIT
Q520-330000-0000S	GEAR CASE ASSEMBLY**	1

****Other Requirement(s):****Parts are not auto-shipped and must be ordered.**

If additional repairs or parts are required, a separate warranty claim must be filed.

INSTRUCTIONS:**Before You Begin:** Read and understand these instructions. Have the tools and materials ready to perform repairs as necessary.**Tools and Supplies:** Jack, Support Stands, 8mm Male Hex Socket, 15mm Socket and Wrench, 17mm Socket, 36mm Socket, Swivels, Extensions, Hammer, Punch, Torque Wrench, Blue Thread-locker, Grease Gun, Brake Cleaner, SAE80/90-GL5 gear oil.**IMPORTANT:** All references to right and left are as viewed from the rear of the vehicle.

1. Place the vehicle on a level work surface. Verify the main key switch is turned off and the key is removed.
2. Loosen the rear wheel nuts, then lift the rear of the vehicle until the tires are off the ground. Support the vehicle under the rear of the frame with stands.
3. Remove the rear wheel nuts and wheels from each side of the vehicle (17mm).



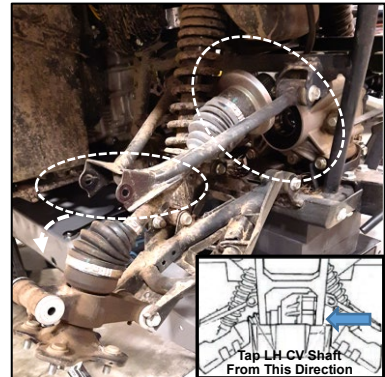
4. Remove the RH CV shaft cotter pin, 36mm nut and washer.



5. Remove the RH upper bearing carrier bolt from the A-Arm. Tilt the carrier downward and remove the RH CV shaft from the carrier, then pull sharply to remove it from the rear gear case.



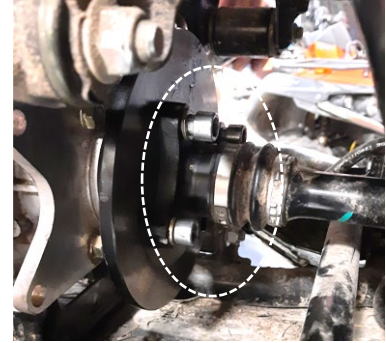
6. Remove the LH upper bearing carrier bolt from the upper A-Arm.
Position a punch through the RH gear case opening and use a hammer to tap out the LH CV shaft, then pull it clear as shown .



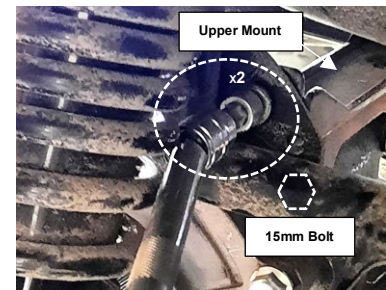
7. Remove the 8mm hex bolts and rear brake caliper assembly from the rear gearcase. Move the caliper out of the way to avoid damage.



8. Remove the 8mm hex bolts attaching the rear output shaft and brake disc to the rear gear case coupler, then pull back the output shaft and remove the brake disc.

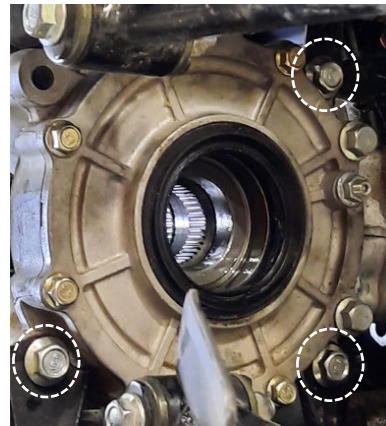


9. Remove the (2) 8mm hex bolts and upper 15mm bolt that secure the gear case upper mount to the frame and remove it.



10. Remove the lower 15mm bolts attaching the gear case to the frame, then remove it from rear of the vehicle.

NOTE: Make sure to disconnect the gear case vent tube.



GEAR CASE INSTALLATION:

11. Place rear gear case Q520-330000-0000S in the frame and install the lower 15mm bolts. Apply blue thread locker to the 15mm nuts, then install them. Torque the nuts to **29-36 ft-lb. (40-50 Nm)**.
12. Place the upper gear case mount into position in the frame and install the upper 15mm bolt. Apply blue thread locker to the (2) 8mm hex screws and 15mm nut, then install them. Torque the nut and hex screws to **29-36 ft-lb. (40-50 Nm)**.

NOTE: Make sure to connect the gear case vent tube.

- 13.** Reinstall the rear brake disc and output shaft. Apply blue thread locker to the hex screws, then install and torque to **29-36 ft-lb. (40-50 Nm)**.

NOTE: Before assembly, inspect the driveshaft coupler spline end for sufficient grease and add if required. Clean the brake disc thoroughly after reassembly.

- 14.** Reinstall the rear brake caliper. Apply blue thread locker to the hex screws, then install and torque to **29-36 ft-lb. (40-50 Nm)**.

- 15.** Install the LH CV shaft into the gear case. Make sure the CV joint is seated properly. Position the LH upper A-arm on the LH bearing carrier and install the 15mm bolt. Apply blue thread locker to the nut, then install and torque to **29-36 ft-lb. (40-50 Nm)**.

NOTE: Apply grease to the bearing carrier zerks as required.

- 16.** Install the RH CV shaft into the gear case and RH bearing carrier. Make sure the CV joint is seated properly. Position the RH upper A-arm on the RH bearing carrier and install the 15mm bolt. Apply blue thread locker to the nut, then install and torque to **29-36 ft-lb. (40-50 Nm)**.
Install the RH CV shaft washer and nut, then torque to **162-184 ft-lb. (220-250 Nm)** and install the cotter pin.

- 17.** Inspect the gear case for proper lubricant level, and add SAE80/90-GL5 gear oil as required.

NOTE: Fluid Capacity – 8.45 oz. (250ml). Fill plug torque – 18.4 ft-lb. (25 Nm)

- 18.** Reinstall the rear wheels and wheel nuts. Remove the support stands and lower the vehicle, then torque the wheel nuts to **27-32 ft-lb. (37-44 Nm)**.

- 19.** Test drive the vehicle to confirm installation is complete.

IMPORTANT: In accordance with the CFMOTO warranty terms regarding factory ownership of all removed parts, discard the removed gear case responsibly. Reuse of any part of the removed gearcase for repair of another vehicle is strictly prohibited.

NOTE: If additional repairs or parts are required, a separate warranty claim must be filed for consideration with CFMOTO.