

SETUP INSTRUCTIONS 2012

350 SX-F EU

350 SX-F CAIROLI REPLICA EU

350 SX-F USA

350 XC-F USA

Art. no. 3211817en



KTM

The work described in these setup instructions must be performed before the vehicle is delivered to the customer.

Read the setup instructions in their entirety before beginning work.

Print out the current **PDI** form found on the **KTM DEALER.NET**.

These setup instructions were written to correspond to the latest state of this series. We reserve the right to make changes in the interest of technical advancement without at the same time updating this manual.

We shall not provide a description of general workshop methods. Likewise, safety rules that apply in a workshop are not specified here. It is assumed that the work will be performed by a fully trained mechanic.

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Issued by: TÜV Management Service

REG.NO. 12 100 6061

KTM-Sportmotorcycle AG
5230 Mattighofen, Austria

Symbols used

The meaning of specific symbols is described below.

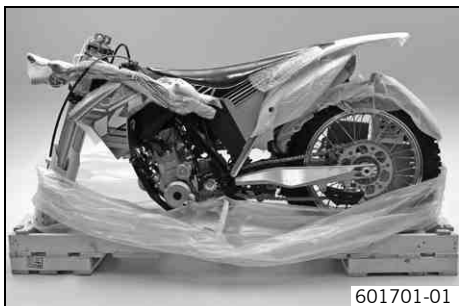
	Indicates an expected reaction (e.g. of a work step or a function).
	Indicates an unexpected reaction (e.g. of a work step or a function).
	Indicates a page reference (more information is provided on the specified page).
	Indicates information with more details or tips.
	Indicates the result of a testing step.
	Denotes a voltage measurement.
	Denotes a current measurement.
	Denotes a resistance measurement.

Formats used

The typographical formats used in this document are explained below.

Proprietary name	Identifies a proprietary name.
Name[®]	Identifies a protected name.
Brand[™]	Identifies a trademark.

Unpacking and setting up the vehicle



601701-01

Packaging 2

- Remove the box and the plastic packaging.



Info

To avoid damaging the motorcycle during the setup, leave the protective film on the vehicle until you have finished.

- Remove the separate enclosure and unpack it. Check that the scope of delivery is complete on the basis of the enclosed packing list.
- Have a lift stand available.

Lift stand (54829055000)

- Carefully loosen and remove the footrest mount.



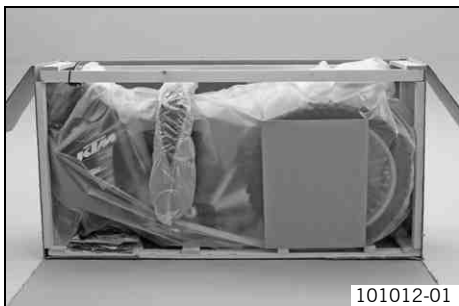
Info

An assistant prevents the motorcycle from falling over.

- Together with an assistant, take the vehicle off the palette.
- Position the vehicle on a lift stand.
- Check the vehicle for transport damage.



101010-01



101012-01



101013-01

Package 12

- Remove the box and the plastic packaging.



Info

An assistant prevents the motorcycle from falling over.

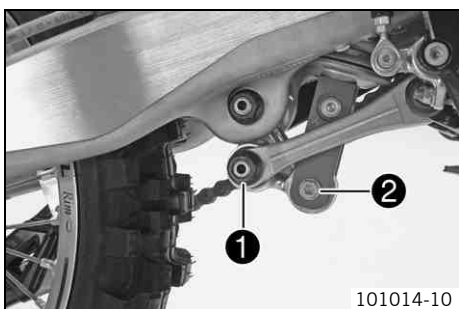
To avoid damaging the motorcycle during the setup, leave the protective film on the vehicle until you have finished.

- Remove the separate enclosure and unpack it. Check that the scope of delivery is complete on the basis of the enclosed packing list.

- Have a lift stand available.

Lift stand (54829055000)

- Together with an assistant, take the vehicle off the palette.
- Position the vehicle on a lift stand.
- Check the vehicle for transport damage.



101014-10

- Remove the cardboard from around the shock absorber.
- Position the angle lever and linkage lever.
- Mount and tighten screw cap ①.

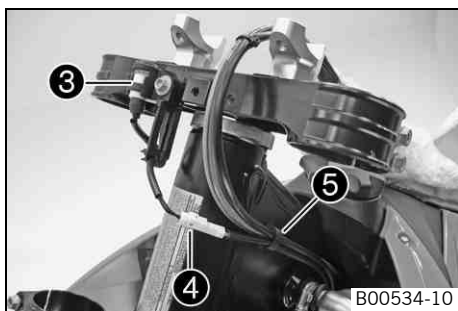
Guideline

Nut, linkage lever to angle lever	M14x1.5	80 Nm (59 lbf ft)
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- Mount and tighten screw ②.

Guideline

Screw, bottom shock absorber	M10	60 Nm (44.3 lbf ft)	Loctite® 2701
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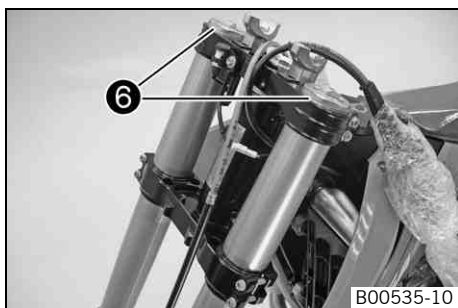


- Position **FI** warning lamp with holder **3**. Mount and tighten screw.

Guideline

Remaining screws, chassis	M6	10 Nm (7.4 lbf ft)
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- Attach connector **4** to the wiring harness.
- Mount cable holder **5** to the frame.



- Route the clutch line with the clutch master cylinder toward the front between the upper and lower triple clamps.
- Position the fork legs and tighten the screws of the triple clamp.

Guideline

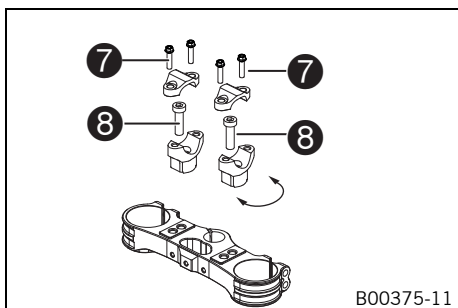
Screw, top triple clamp	M8	17 Nm (12.5 lbf ft)
Screw, bottom triple clamp	M8	12 Nm (8.9 lbf ft)



Info

The topmost milled groove in the fork leg must be flush with the top edge of the upper triple clamp.

Position bleeder screws **6** toward the front.



- Remove screws **7**. Take off the handlebar clamps.
- Remove screws **8**. Remove the handlebar supports.
- Place the handlebar supports in the required position. Mount and tighten screws **8**.

Guideline

Screw, handlebar support	M10	40 Nm (29.5 lbf ft)	Loctite® 243™
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Info

Position the left and right handlebar supports evenly.



- Position the handlebar.



Info

Make sure the cables and wiring are positioned correctly.

- Position the handlebar clamps. Mount and tighten the screws.

Guideline

Screw, handlebar clamp	M8	20 Nm (14.8 lbf ft)
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Info

The markings on the handlebar should be at the center of the handlebar clamps.

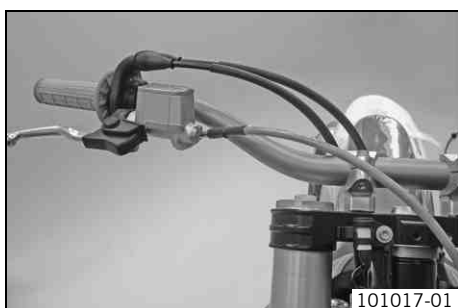
Keep the gap widths equal when tightening.

- Position the controls on the right half of the handlebar.



Info

The routing of the cables can be seen in the figure.





101018-01

- Position the controls on the left half of the handlebar.



Info

The figure shows how to route the clutch line and wiring harness.

- Install the front fender. (☛ p. 6)
- Install the front wheel. (☛ p. 6)
- Correctly mount the fuel tank breather.



C00138-01

- Mount the handlebar cushion.
- Install the start number plate. (☛ p. 7)



101019-01

- Mount the footrests with the springs and bolts. Secure the bolts using the washers and pins.

Pliers for footrest spring (58429083000)



800035-10



Warning

Risk of injury Battery acid and battery gases cause serious chemical burns.

- Keep batteries out of the reach of children.
- Wear suitable protective clothing and goggles.
- Avoid contact with battery acid and battery gases.
- Keep the battery away from sparks or open flames. Charge only in well-ventilated areas.
- In the event of skin contact, rinse with large amounts of water. If battery acid gets in the eyes, rinse with water for at least 15 minutes and contact a physician.

- Fill the battery.



Info

Read the notes in the battery package.

- Charge the battery. (☛ p. 7)
- Install the battery. (☛ p. 7)
- Unpack and mount the **KTM PowerParts** included in the delivery (optional).



Info

Read the accompanying **KTM PowerParts** installation instructions.

- Apply the label included in the delivery (optional).
- Refuel. (☛ p. 9)
- Position all controls in their exact positions on the handlebar. Tighten all screws.
- Print out the current **PDI** form found on **KTM DEALER.NET** and perform the delivery inspection.

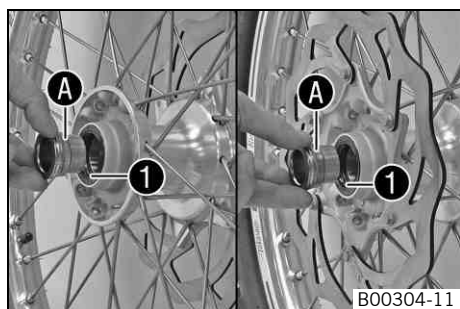
Installing the front wheel



Warning

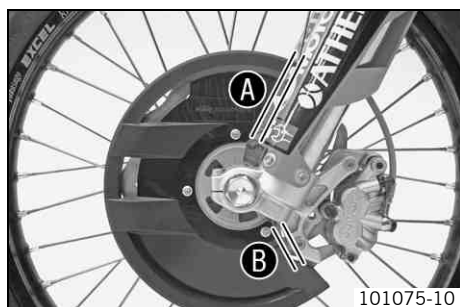
Danger of accidents Reduced braking efficiency due to oil or grease on the brake discs.

- Always keep the brake discs free of oil and grease, and clean them with brake cleaner when necessary.



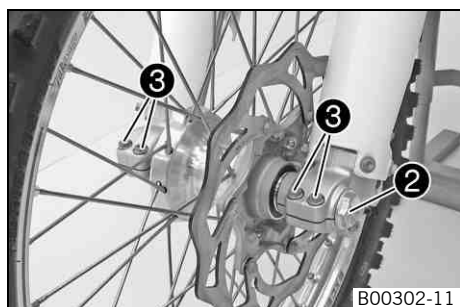
- Check the wheel bearing for damage and wear.
 - » If the wheel bearing is damaged or worn:
 - Change the wheel bearing.
- Clean and grease the shaft seal rings ① and contact surface ② of the spacers.

Long-life grease (🔧 p. 13)
- Insert the spacers.
- Lift the front wheel into the fork, position it, and insert the wheel spindle.



(350 SX-F CAIROLI REPLICA EU)

- Align the brake disc guard so that gaps ② and ③ are the same size.



- Mount and tighten screw ②.

Guideline

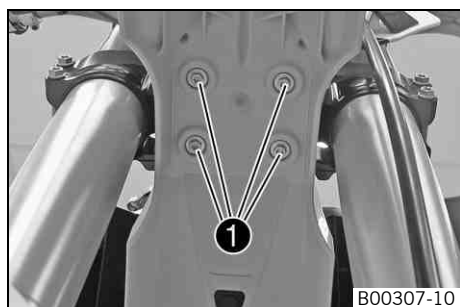
Screw, front wheel spindle	M24x1.5	45 Nm (33.2 lbf ft)
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- Activate the hand brake lever multiple times until the brake linings are in contact with the brake disc.
- Remove the motorcycle from the lift stand.
- Pull the front brake and compress the fork powerfully a few times.
 - ✓ The fork legs straighten.
- Tighten screws ③.

Guideline

Screw, fork stub	M8	15 Nm (11.1 lbf ft)
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Installing the front fender



- Ensure that the spacers are mounted in the fender.
- Position the front fender. Mount and tighten screws ①.

Guideline

Remaining screws, chassis	M6	10 Nm (7.4 lbf ft)
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Info

Make sure the holding lugs engage in the start number plate.

Installing the start number plate



- Position the start number plate. Mount and tighten screw ❶.

Guideline

Remaining screws, chassis	M6	10 Nm (7.4 lbf ft)
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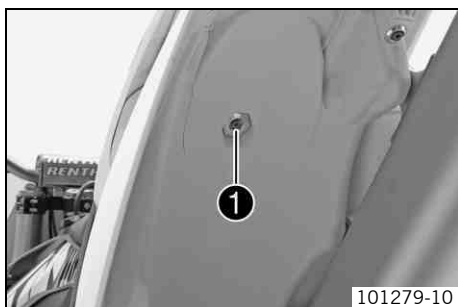


Info

Make sure that the holding lugs engage in the fender.

- Position the brake line and clamp. Mount and tighten screw ❷.

Removing the seat



- Remove screw ❶.
- Lift up the seat at the rear, pull it back and then remove it from above.

Mounting the seat

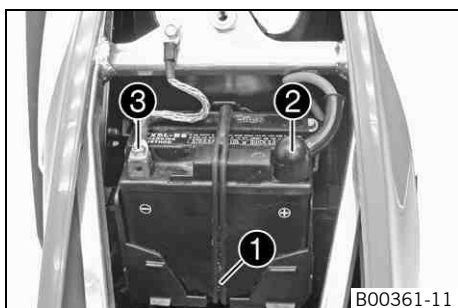


- Hook in the front of the seat at the collar bushing of the fuel tank, lower it at the rear and simultaneously it push forward.
- Make sure that the seat is correctly locked in.
- Mount and tighten the screw of the seat fixing.

Guideline

Remaining screws, chassis	M6	10 Nm (7.4 lbf ft)
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Installing the battery



Main work

- Place the battery in the battery holder.

(All SX-F models)

Battery (YTX4L-BS)

(350 XC-F USA)

Battery (YTX5L-BS)

- Reconnect rubber band ❶.
- Attach the positive cable and replace the positive terminal cover ❷.
- Attach negative cable ❸.

Subsequent work

- Mount the seat. (🔧 p. 7)

Charging the battery



Warning

Risk of injury Battery acid and battery gases cause serious chemical burns.

- Keep batteries out of the reach of children.
- Wear suitable protective clothing and goggles.
- Avoid contact with battery acid and battery gases.
- Keep the battery away from sparks or open flames. Charge only in well-ventilated areas.
- In the event of skin contact, rinse with large amounts of water. If battery acid gets in the eyes, rinse with water for at least 15 minutes and contact a physician.

- **Warning**
Environmental hazard The battery contains elements that are harmful to the environment.
- Do not discard batteries with the household trash. Dispose of a defective battery in an environmentally compatible manner. Give the battery to your KTM dealer or to a recycling center that accepts used batteries.
- **Warning**
Environmental hazard Hazardous substances cause environmental damage.
- Oil, grease, filters, fuel, cleaners, brake fluid, etc., should be disposed of as stipulated in applicable regulations.

**Info**

Even when there is no load on the battery, it still loses power steadily.
The charge state and the type of charge are very important for the service life of the battery.
Rapid recharging with a high charging current shortens the battery's service life.
If the charging current, charging voltage and charging time are exceeded, electrolyte escapes through the safety valves. This reduces the battery capacity.
If the battery is depleted from starting the vehicle repeatedly, the battery must be charged immediately.
If the battery is left in a discharged state for an extended period, it will become over-discharged and sulfate, destroying the battery.
The battery is maintenance-free, which means that the acid level does not need to be checked.



Preliminary work

- Switch off all power consumers and switch off the engine.
- Remove the seat. (🔧 p. 7)
- Disconnect the negative cable of the battery to avoid damage to the onboard electronics.

Main work

- Connect the battery charger to the battery. Switch on the battery charger.

Battery charger (58429074000)

You can also use the battery charger to test the open-circuit voltage and starting voltage of the battery, and to test the alternator. With this device, you cannot over-charge the battery.

**Info**

Never remove lid ❶.
Charge the battery with a maximum of 10% of the capacity specified on the battery housing ❷.

- Switch off the battery charger after charging. Disconnect the battery.

Guideline

The charge current, charge voltage and charge time must not be exceeded.	
Charge the battery regularly when the motorcycle is not in use	3 months

Subsequent work

- Mount the seat. (🔧 p. 7)

Opening the filler cap

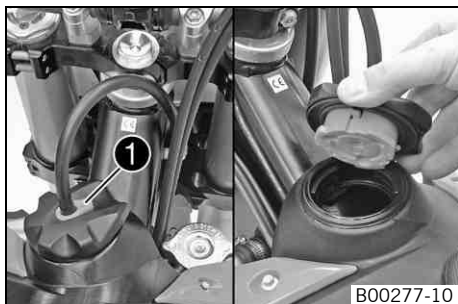
- **Danger**
Fire hazard Fuel is highly flammable.
- Never refuel the vehicle near open flames or burning cigarettes, and always switch off the engine first. Be careful that no fuel is spilt, especially on hot vehicle components. Clean up spilt fuel immediately.
 - Fuel in the fuel tank expands when warm and can escape if the tank is overfilled. See the notes on refueling.
- **Warning**
Danger of poisoning Fuel is poisonous and a health hazard.
- Avoid contact between fuel and skin, eyes and clothing. Do not inhale fuel vapors. If fuel gets into your eyes, rinse immediately with water and contact a doctor. Wash affected skin areas immediately with soap and water. If fuel is swallowed, contact a doctor immediately. Change clothing that has come into contact with fuel. Store fuel in a suitable canister according to regulations and keep it out of the reach of children.



Warning

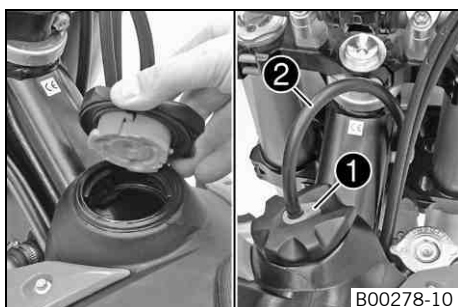
Environmental hazard Improper handling of fuel is a danger to the environment.

- Do not allow fuel to get into the ground water, the ground, or the sewage system.



- Press release button ❶, turn the filler cap counterclockwise and lift it free.

Closing the filler cap



- Replace the filler cap and turn clockwise until the release button ❶ locks in place.



Info

Run the fuel tank breather hose ❷ without kinks.

Refueling



Danger

Fire hazard Fuel is highly flammable.

- Never refuel the vehicle near open flames or burning cigarettes, and always switch off the engine first. Be careful that no fuel is spilt, especially on hot vehicle components. Clean up spilt fuel immediately.
- Fuel in the fuel tank expands when warm and can escape if the tank is overfilled. See the notes on refueling.



Warning

Danger of poisoning Fuel is poisonous and a health hazard.

- Avoid contact of the fuel with skin, eyes and clothing. Do not inhale fuel vapors. If fuel gets into your eyes, rinse immediately with water and contact a doctor. Wash affected skin areas immediately with soap and water. If fuel is swallowed, contact a doctor immediately. Change clothing that has come into contact with fuel.

Note

Material damage Premature clogging of the fuel filter.

- In some countries and regions, the available fuel quality and cleanliness may not be sufficient. This will result in problems with the fuel system.
- Only refuel with clean fuel that meets the specified standards.

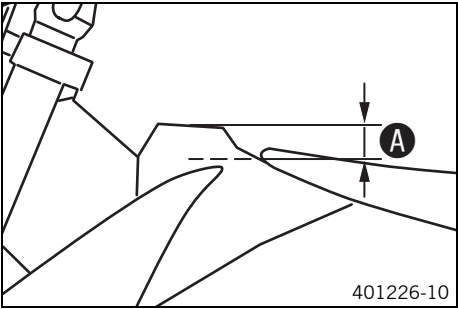


Warning

Environmental hazard Improper handling of fuel is a danger to the environment.

- Do not allow fuel to get into the ground water, the ground, or the sewage system.

- Switch off the engine.
- Open the filler cap. (🔧 p. 8)



- Fill the fuel tank with fuel up to measurement **A**.

Guideline

Measurement of A		35 mm (1.38 in)
Total fuel tank capacity, approx. (All SX-F models)	7.5 l (1.98 US gal)	Super unleaded (ROZ 95/RON 95/PON 91) (🔧 p. 12)
Total fuel tank capacity, approx. (350 XC-F USA)	9.5 l (2.51 US gal)	Super unleaded (ROZ 95/RON 95/PON 91) (🔧 p. 12)

- Close the filler cap. (🔧 p. 9)

Spoke nipple, front wheel	M4.5	5... 6 Nm (3.7... 4.4 lbf ft)	–
Spoke nipple, rear wheel	M4.5	5... 6 Nm (3.7... 4.4 lbf ft)	–
Remaining nuts, chassis	M6	10 Nm (7.4 lbf ft)	–
Remaining screws, chassis	M6	10 Nm (7.4 lbf ft)	–
Screw, ball joint of push rod on foot brake cylinder	M6	10 Nm (7.4 lbf ft)	–
Screw, front brake disc	M6	14 Nm (10.3 lbf ft)	Loctite® 243™
Screw, rear brake disc	M6	14 Nm (10.3 lbf ft)	Loctite® 243™
Nut, foot brake lever stop	M8	20 Nm (14.8 lbf ft)	–
Nut, rear sprocket screw	M8	35 Nm (25.8 lbf ft)	Loctite® 2701
Nut, rim lock	M8	10 Nm (7.4 lbf ft)	–
Remaining nuts, chassis	M8	25 Nm (18.4 lbf ft)	–
Remaining screws, chassis	M8	25 Nm (18.4 lbf ft)	–
Screw, bottom triple clamp	M8	12 Nm (8.9 lbf ft)	–
Screw, engine brace	M8	33 Nm (24.3 lbf ft)	–
Screw, fork stub	M8	15 Nm (11.1 lbf ft)	–
Screw, front brake caliper	M8	25 Nm (18.4 lbf ft)	Loctite® 243™
Screw, handlebar clamp	M8	20 Nm (14.8 lbf ft)	–
Screw, subframe	M8	35 Nm (25.8 lbf ft)	Loctite® 2701
Screw, top steering stem	M8	17 Nm (12.5 lbf ft)	Loctite® 243™
Screw, top triple clamp	M8	17 Nm (12.5 lbf ft)	–
Engine carrying screw	M10	60 Nm (44.3 lbf ft)	–
Remaining nuts, chassis	M10	45 Nm (33.2 lbf ft)	–
Remaining screws, chassis	M10	45 Nm (33.2 lbf ft)	–
Screw, bottom shock absorber	M10	60 Nm (44.3 lbf ft)	Loctite® 2701
Screw, handlebar support	M10	40 Nm (29.5 lbf ft)	Loctite® 243™
Screw, top shock absorber	M10	60 Nm (44.3 lbf ft)	Loctite® 2701
Nut, seat fixing	M12x1	20 Nm (14.8 lbf ft)	–
Nut, linkage lever on swingarm	M14x1.5	80 Nm (59 lbf ft)	–
Nut, linkage lever to angle lever	M14x1.5	80 Nm (59 lbf ft)	–
Nut, swingarm pivot	M16x1.5	100 Nm (73.8 lbf ft)	–
Nut, rear wheel spindle	M20x1.5	80 Nm (59 lbf ft)	–
Screw, top steering head	M20x1.5	12 Nm (8.9 lbf ft)	–
Screw-in nozzles, cooling system	M20x1.5	12 Nm (8.9 lbf ft)	Loctite® 243™
Screw, front wheel spindle	M24x1.5	45 Nm (33.2 lbf ft)	–

Super unleaded (ROZ 95/RON 95/PON 91)

According to

- DIN EN 228 (ROZ 95/RON 95/PON 91)

Guideline

- Only use unleaded super fuel that matches or is equivalent to the specified fuel grade.
- Fuel with an ethanol content of up to 10 % (E10 fuel) is safe to use.



Info

Do **not** use fuel containing methanol (e. g. M15, M85, M100) or more than 10 % ethanol (e. g. E15, E25, E85, E100).

Long-life grease

Guideline

- KTM recommends **Motorex®** products.

Supplier

Motorex®

- **Bike Grease 2000**



3211817en



1/2011 Foto: Mitterbauer



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