



# S 1000 XR 2020-2025 & S 1000 XR TE 2024

## FITTING INSTRUCTIONS TO BE FITTED BY A QUALIFIED TECHNICIAN

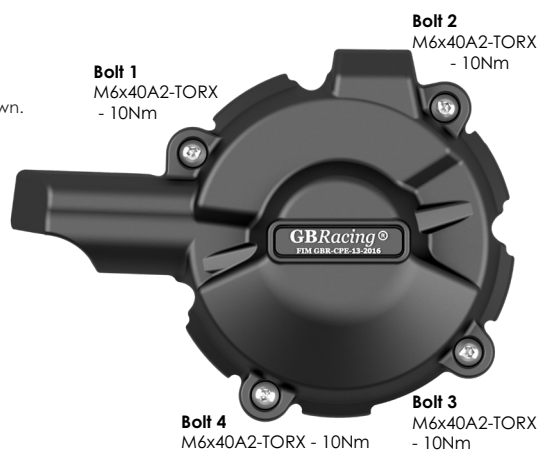
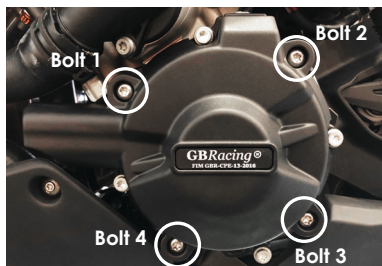
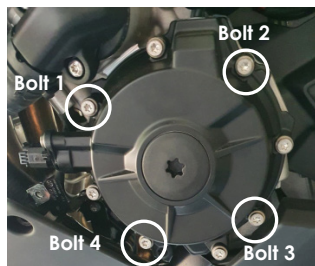


### THIS SHEET INCLUDES FITTING INSTRUCTIONS FOR THE FOLLOWING PARTS:

Secondary Alternator Cover Part No. EC-S1000XR-2020-1-GBR / Secondary Clutch Cover Part No. EC-S1000RR-2019-2-GBR /  
Secondary Pulse Cover Part No. EC-S1000RR-2019-3-GBR / Secondary Water Pump Cover Part No. EC-S1000RR-2019-5-GBR /

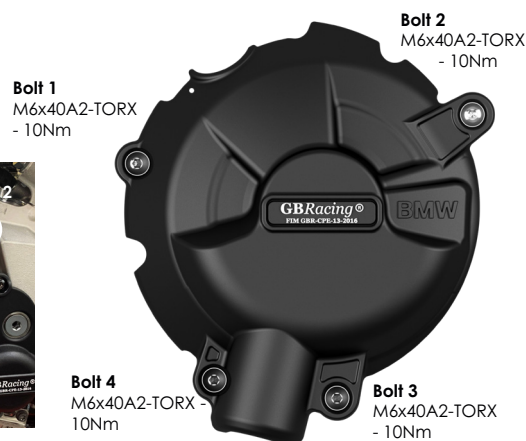
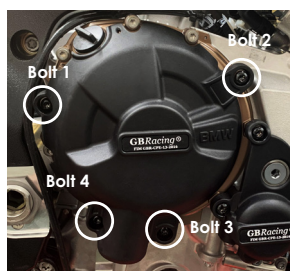
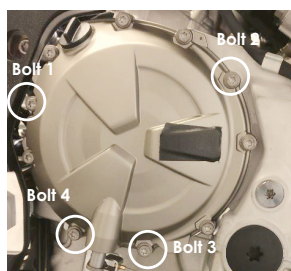
### SECONDARY ALTERNATOR COVER – PART NO. EC-S1000XR-2020-1-GBR

- 1 Remove 4 existing stretch bolts from the stock Alternator cover, shown as position Bolt 1, 2, 3 & 4.
- 2 Place the Secondary Alternator Cover over the stock cover.
- 3 Assemble 4 replacement stainless steel M6X40A2 TORX bolts loosely in the correct position as shown.
- 4 Tighten bolts to a Torque of 10Nm. DO NOT OVERTIGHTEN.



### SECONDARY CLUTCH COVER – PART NO. EC-S1000RR-2019-2-GBR

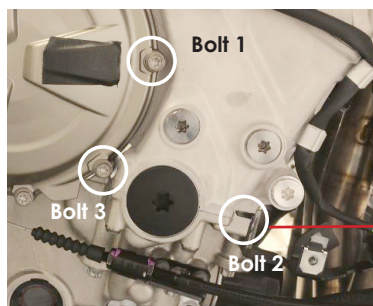
- 1 Remove 4 existing bolts from the stock clutch cover, shown as position Bolt 1, 2, 3 & 4.
- 2 Place the Secondary Clutch Cover over the stock cover.
- 3 Assemble 4 replacement M6X40A2 TORX bolts, loosely in the correct position as shown.
- 4 Tighten bolts to a Torque of 10Nm. DO NOT OVERTIGHTEN.



### SECONDARY PULSE COVER – PART NO. EC-S1000RR-2019-3-GBR

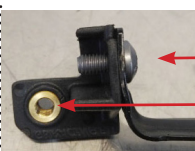
- 1 Remove 3 existing bolts indicated in **Fig 1**.
- 2 Fit GBRacing fixing bracket to existing bracket as shown in **Fig 2**.
- 3 Fixing bracket is fitted to engine using existing clutch cable mount.
- 4 Place the Secondary Pulse Cover over these bolt positions in **Fig 1**.
- 5 Assemble 2 replacement M6X40A2 TORX bolts, loosely in the correct position as shown at bolt positions 1 & 3.
- 6 Bolt 2 M6X30A2 TORX will secure to the fixing bracket as indicated in **Fig 2 & 3**.
- 7 Tighten bolts to a Torque of 10Nm. DO NOT OVERTIGHTEN.

**Fig 1.**



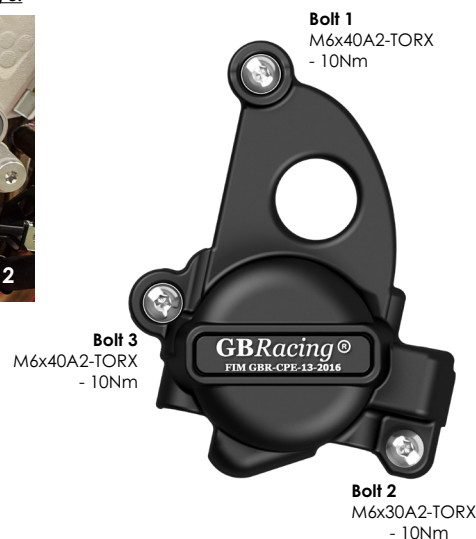
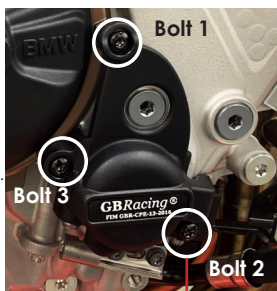
**Fig 2.**

Fixing Bracket (EC-S1000RR-2019-3-FB-GBR)  
for Bolt 2



Use OE mounting  
bolt here  
Bolt 2 M6X30A2  
mounting point

**Fig 3.**



### ENGINE COVER SET: EC-S1000XR-2020-SET-GBR:

EC-S1000XR-2020-1-GBR, EC-S1000RR-2019-2-GBR, EC-S1000RR-2019-3-GBR, EC-S1000RR-2019-3-FB-GBR, EC-S1000RR-2019-5-GBR



**S 1000 XR 2020-2025  
& S 1000 XR TE 2024**

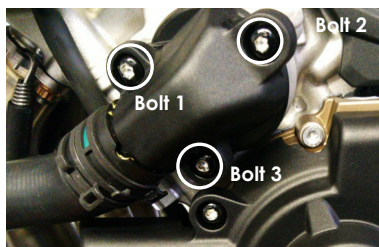
## FITTING INSTRUCTIONS

TO BE FITTED BY A QUALIFIED TECHNICIAN



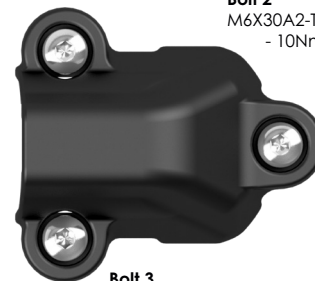
### SECONDARY WATER PUMP COVER PART NO. EC-S1000RR-2019-5-GBR

- 1 Fitting requires a COLD engine.
- 2 Decompress the system before loosening existing stock bolts.
- 3 Have all 3 Replacement Bolts to hand before removing existing stock bolts.
- 4 Loosen bottom fairing bolt to enable access to the Water Pump.
- 5 Remove 3 existing bolts from the stock water pump cover shown as bolt positions 1, 2 & 3
- 6 Place the Secondary Water Pump Cover over the stock cover.
- 7 Assemble 3 replacement bolts, loosely in the correct position as shown.
- 8 Tighten bolts to a Torque of 10Nm.  
DO NOT OVERTIGHTEN.
- 9 Tighten bottom fairing bolt.
- 10 Check coolant level & top up if necessary before starting engine.



**Bolt 1**  
M6X30A2-TORX  
- 10Nm

**Bolt 2**  
M6X30A2-TORX  
- 10Nm



**Bolt 3**  
M6X30A2-TORX  
- 10Nm