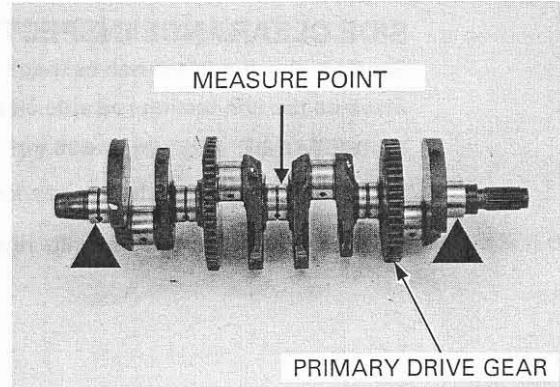


INSPECTION

Support the crankshaft on both end journals.
Set a dial gauge on the center main journal of the crankshaft.
Rotate the crankshaft two revolutions and read the runout.

SERVICE LIMIT: 0.05 mm (0.002 in)

Check the primary drive gear teeth for abnormal wear or damage.

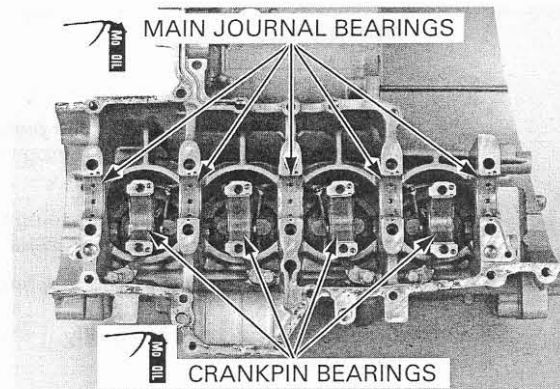


INSTALLATION

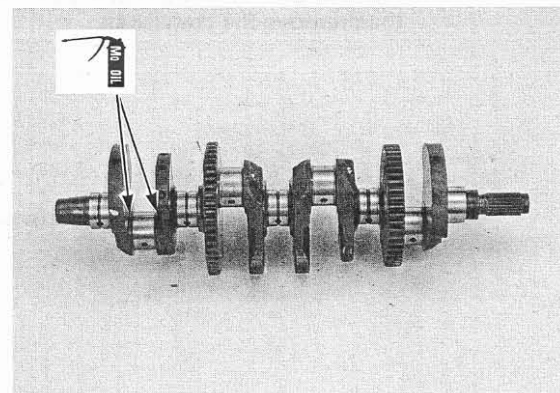
Apply molybdenum oil solution to the main journal bearing sliding surfaces on the upper crankcase and the crankpin bearing sliding surfaces on the connecting rods.

The bearing tabs should be aligned with the grooves in the crankcase.

Install the main journal bearings into the upper crankcase.



Apply molybdenum oil solution to the thrust surfaces of the crankshaft as shown.



NOTICE

Position all the pistons at TDC (Top Dead Center) to prevent damaging the crankpin with the connecting rod.

Install the crankshaft onto the upper crankcase.
Set the connecting rods onto the crankpins.

Apply molybdenum oil solution to the crankpin bearing sliding surfaces on the connecting rod bearing caps.

Install the connecting rod bearing caps, aligning the dowel pins with the holes in the connecting rods.
Be sure each part is installed in its original position, as noted during removal.

