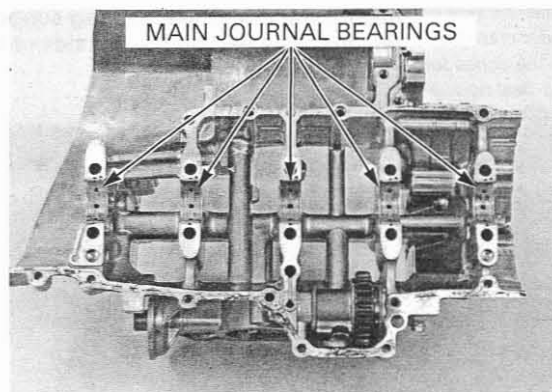


BEARING INSTALLATION

Clean the bearing outer surfaces and crankcase bearing supports.

Apply molybdenum oil solution to the main journal bearing sliding surfaces on the upper crankcase.

Install the main journal bearing inserts onto the crankcase bearing supports, aligning each tab with each groove.



CRANKPIN BEARING

NOTICE

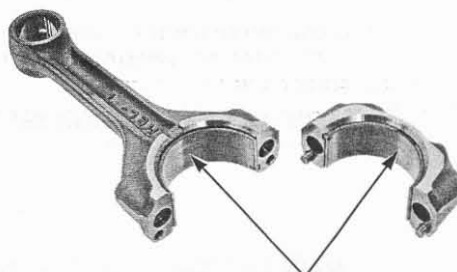
Do not interchange the bearing inserts. They must be installed in their original locations or the correct bearing oil clearance may not be obtained, resulting in engine damage.

Remove the crankshaft (page 13-7).

BEARING INSPECTION

Check the bearing inserts for unusual wear or peeling.

Check the bearing tabs for damage.



CRANKPIN BEARING INSERTS

OIL CLEARANCE INSPECTION

Clean off any oil from the bearing inserts and crankpins.

Carefully install the crankshaft onto the upper crankcase.

Set the connecting rods onto the crankpins.

Put a strip of plastigauge lengthwise on each crankpin avoiding the oil hole.

- Do not rotate the crankshaft during inspection.

