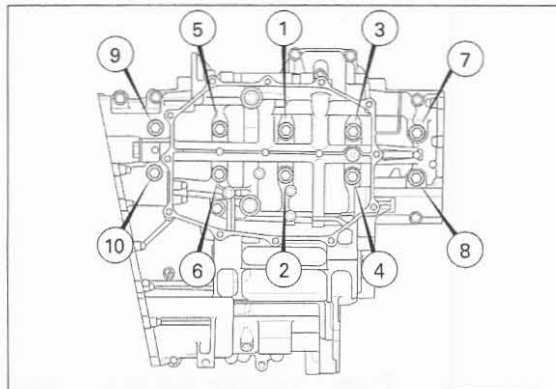


CRANKCASE/CRANKSHAFT/BALANCER/PISTON/CYLINDER

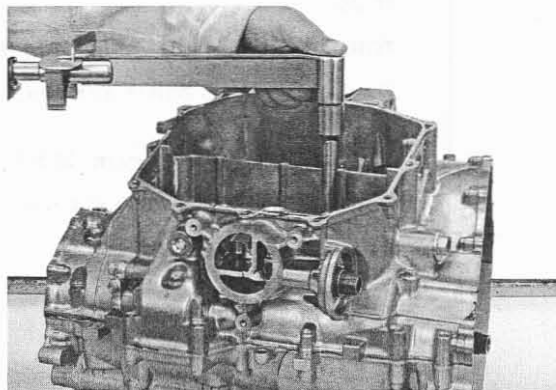
PLASTIC REGION TIGHTENING METHOD:

Tighten the crankcase 9 mm bolts (main journal bolts) in numerical order in the illustration in two to three steps to the specified torque.

TORQUE: 20 N·m (2.0 kgf·m, 14 lbf·ft)



Further tighten the crankcase 9 mm bolts (main journal bolts) 150 degrees.

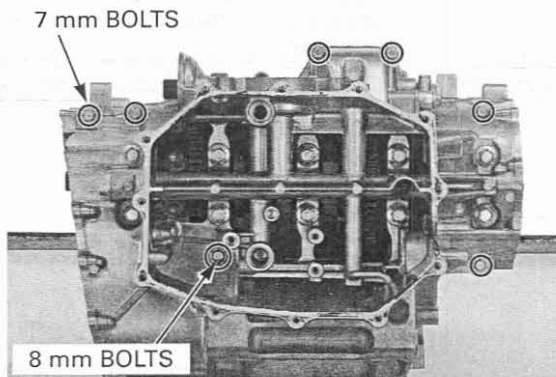


Tighten the 8 mm bolt to the specified torque.

TORQUE: 24 N·m (2.4 kgf·m, 17 lbf·ft)

From the inside to outside, tighten the 7 mm bolts to the specified torque.

TORQUE: 18 N·m (1.8 kgf·m, 13 lbf·ft)



Place the engine with the lower side down.

Install the upper crankcase 8 mm bolts, sealing washer and 7 mm bolts.

