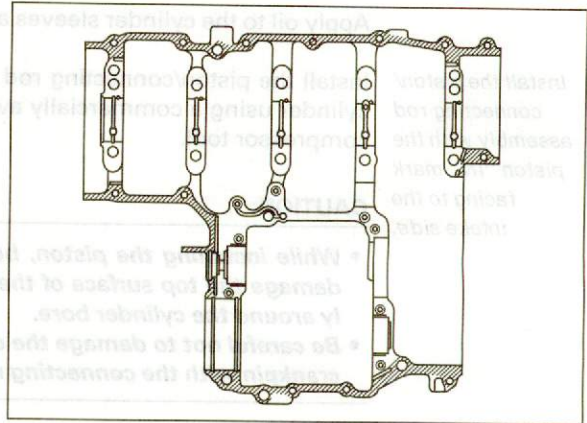
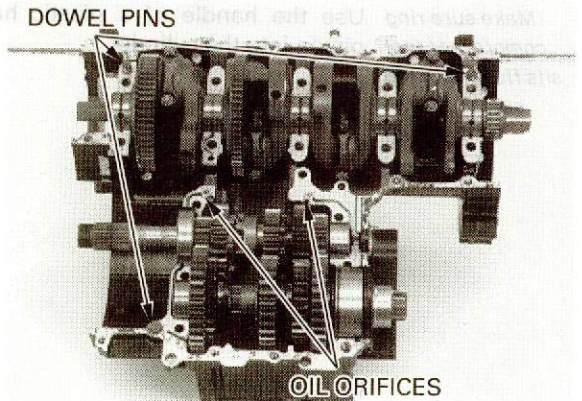


CRANKCASE COMBINATION

Apply a light, but thorough, coating of liquid sealant to the crankcase mating surface except to the main bearing journal bolt (lower crankcase bolt, 9 mm) area and the oil passage area as shown.



Install the three dowel pins.
Install oil orifices aligning their cut-out with the groove in the upper crankcase.



Install the lower crankcase onto the upper crankcase.

Clean the crankcase 9 mm bolts thoroughly with solvent and blow them dry.

Apply clean engine oil to the 9 mm bolt threads and seating surface and install them.

Loosely install all the lower crankcase bolts.
Make sure the upper and lower crankcase are seated securely.

From the inside to outside, tighten the lower crankcase 9 mm bolts in a crisscross pattern in 2-3 steps.

NOTE:

Tighten the 9 mm bolts in numerical order as shown in the illustration.

TORQUE: 37 N·m (3.8 kgf·m , 27 lbf·ft)

Tighten the 10 mm bolt, and then the 6 mm bolts and 7 mm bolts.

TORQUE: 10 mm bolt: 39 N·m (4.0 kgf·m , 29 lbf·ft)
7 mm bolt: 18 N·m (1.8 kgf·m , 13 lbf·ft)
6 mm bolt: 12 N·m (1.2 kgf·m , 9 lbf·ft)

