

NOTE

- Determine the replacement bearing color code according to the main bearing selection table (page 10-6) or the connecting rod bearing selection table (page 10-7).
- Mark and store the bearing inserts to be sure of their correct locations for reassembly.
- At installation, apply molybdenum solution to the main journal bearing and connecting rod bearing surface.
- Refer to page 1-8 for crankshaft and rod specification.
- Refer to section 14 of the Common Service Manual for bearing inspection.

REQUISITE SERVICE

- Refer to Service Information (page 10-1)

PROCEDURE		Q'ty	REMARKS
REMOVAL ORDER			
(1)	Connecting rod bearing cap nut	8	Do not remove them without necessary. Wipe all oil from the bearing seating areas.
(2)	Bearing cap	4	
(3)	Connecting rod	4	
(4)	Connecting rod bolt	8	
(5)	Connecting rod bearing	8	
(6)	Crankshaft	1	
(7)	Crankshaft main journal bearing	12	
INSTALLATION ORDER			
(7)	Crankshaft main journal bearing	12	The bearing tabs should be aligned with the grooves in the crankcases.
(6)	Crankshaft	1	Install it onto the upper crankcase with the flywheel side facing to the clutch side.
(5)	Connecting rod bearing	8	NOTE: • The bearing oil hole should be aligned with the oil hole in the connecting rod.
(4)	Connecting rod bolt	8	NOTE: • Face the oil holes to the intake side. Install them with the code letters read properly. Apply oil to the nut threads and torque them in gradual, crisscross pattern.
(3)	Connecting rod	4	
(2)	Bearing cap	4	
(1)	Connecting rod bearing cap nut	8	