

Install the lower crankcase onto the upper crankcase. Clean the new crankcase 9 mm bolts thoroughly with solvent and blow them dry. Apply oil to the 9 mm bolt threads and seating surface and install them. Install the 10 mm bolt, 6 mm bolts.

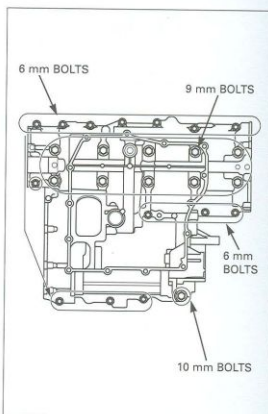
Make sure the upper and lower crankcase are seated securely.

From the inside to outside, tighten the lower crankcase 9 mm bolts (main journal bolts) in a criss-cross pattern in 2 or 3 steps.

**TORQUE: 27 N·m (2.8 kgf·m, 20 lbf·ft)**

Tighten the 10 mm bolt to the specified torque, and then tighten 6 mm.

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



*The sealing washer locations are indicated on the upper crankcase using the "Δ" mark.*

Install the upper crankcase 8 mm bolts and 6 mm bolts with new sealing washers.

Tighten the 8 mm bolts in a crisscross pattern in 2 or 3 steps.

**TORQUE: 24 N·m (2.4 kgf·m, 17 lbf·ft)**

Tighten the 6 mm bolts in a crisscross pattern in 2 or 3 steps securely.

Apply a locking agent to the set plate bolt threads. Install the mainshaft bearing set plate with its "OUT SIDE" mark facing out. Install and tighten the bolts to the specified torque.

**TORQUE: 12 N·m (1.2 kgf·m, 9 lbf·ft)**

