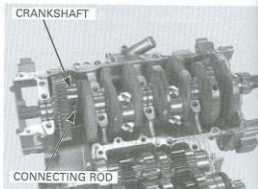


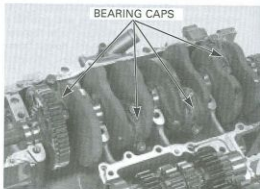
Lower all pistons to the top dead center to avoid damaging the crankpin by the connecting rod bolts. Carefully install the crankshaft onto the upper crankcase. Set the connecting rods onto the crankpins.



INSPECTION

Hold both ends of the crankshaft. Set a dial gauge on the center main journal of the crankshaft. Rotate the crankshaft two revolutions and read the runout.

SERVICE LIMIT: 0.30 mm (0.012 in)



MAIN JOURNAL BEARING

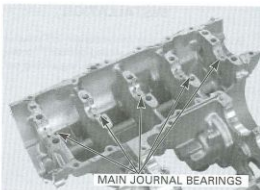
NOTICE

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 12-3).

BEARING INSPECTION

Inspect the main journal bearing inserts on the upper and lower crankcase for unusual wear or peeling. Check the bearing tabs for damage.



OIL CLEARANCE INSPECTION

Do not rotate the crankshaft during inspection.

Clean off any oil from the bearing inserts and main journals. Install the crankshaft onto the upper crankcase. Put a strip of plastigauge lengthwise on each main journal avoiding the oil hole.

