

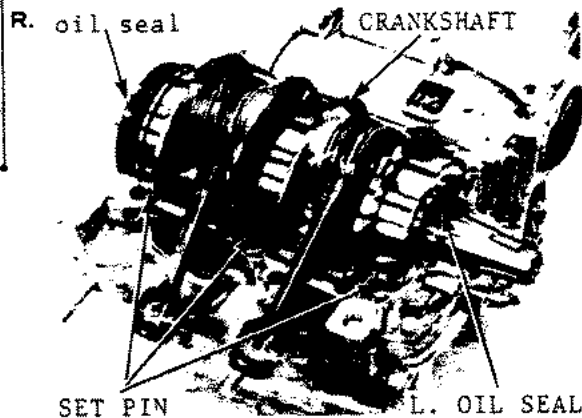
Apply recommended engine oil to journal bearing and conrod big end.

Install oil seal to crankshaft end

\*Take care not to damage oil seal lip

Apply sealing agent to R-L oil seal outside  
Align crankshaft journal bearing set pin with lower crankcase groove and install bearing set pin to crankshaft assembly

\* Set crankshaft into crankcase and lightly tap journal bearing into crankcase with plastic hammer  
\* Check that the respective oil seals are set into the case grooves  
\* Check that the respective bearing set pins are entered into the crankcase groove



#### CRANKCASE ASSEMBLY

Check that the crankshaft journal bearings set pin is set into the case groove.

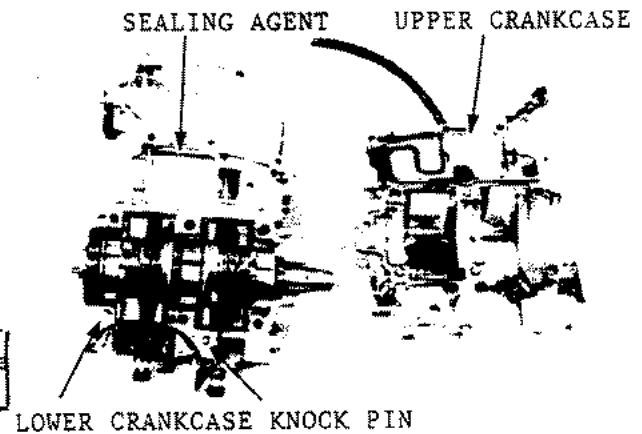
\* Clean crankcase aligning face of all packing

Apply packing to crankcase aligning face

\* Do not apply to knock pin hole

Install upper crankcase to lower crankcase

\* Inspect aligning mark clearance & assemble so there is no clearance



Tighten lower crankcase bolt

Torque: 2.1-2.5 Kg-m

\* Tighten bolts 2-3 turns at a time from the inside to the outside

