

**Crankcase Assembly**

Apply liquid sealant to the crankcase mating surfaces and install the dowel pins.

Install the right crankcase over the left crankcase.

Place the crankcase assembly collar against the bearing inner race in the right crankcase. Thread the assembly shaft onto the crankshaft.

Hold the assembly shaft and turn the nut counterclockwise to draw the crankcase halves together.

**S TOOL**

Crankcase assembly collar **07965-GM00100**  
 Crankcase assembly shaft **07965-GM00300**

Install a new right crankcase oil seal using the crankcase assembly collar and shaft until it is  $5.0 \pm 0.5$  mm ( $0.20 \pm 0.02$  in) below the surface of the right crankcase as shown.

**S TOOL**

Crankcase assembly collar **07965-GM00100**  
 Crankcase assembly shaft **07965-GM00300**

