



Turn the crankcase upside down and tighten the remaining case bolts.

**TORQUES:**

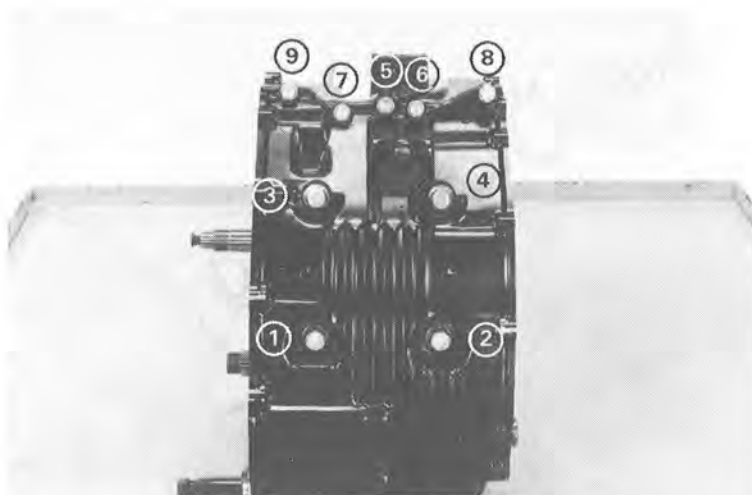
6 mm bolt: 10–14 N·m  
(1.0–1.4 kg·m, 7–10 ft·lb)

9 mm bolt: 27–32 N·m  
(2.7–3.2 kg·m, 20–23 ft·lb)

10 mm bolt: 33–37 N·m  
(3.3–3.7 kg·m, 24–27 ft·lb)

**NOTE**

Tighten the bolts in two or more steps in the sequence shown.



Install the cam chain and oil pipe.



Install the chain tensioner and tighten the bolt.

**TORQUE:** 10–14 N·m (1.0–1.4 kg·m, 7–10 ft·lb)

**NOTE**

Note the direction of the collar.

Install the balance spring and tighten the balancer holder lock bolt.

**TORQUE:** 22–28 N·m  
(2.2–2.8 kg·m, 16–20 ft·lb)

Install the AC generator (Section 9).  
Install the clutch/oil pump (Section 8).

Install the cylinder/piston (Section 7).  
Install the cylinder head (Section 6).  
Install the engine into the frame.

