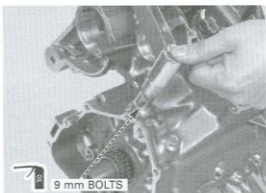


Install the dowel pins and oil orifices.
Carefully install the lower crankcase on the upper crankcase.

Apply engine oil to the main journal 8 mm bolt threads and seating surfaces and install them.

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

TORQUE: 27 N·m (2.8 kgf·m, 20 lbf·ft)



Remove the 8 mm bolts and lower crankcase.
Measure the compressed plastigauge at its widest point on each main journal to determine the oil clearance.

SERVICE LIMITS: 0.04 mm (0.002 in)

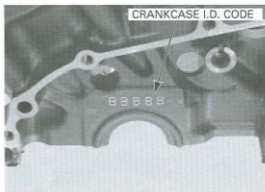
If main bearing clearance exceeds the service limit, select the correct replacement bearings.



Letters (A, B or C) on the left side of upper crankcase are the codes for the bearing support I.D.s from left to right.

BEARING SELECTION

Record the crankcase bearing support I.D. code letters from the pad on the left side of the upper crankcase as shown.



Numbers (1, 2 or 3) on the crank weight are the codes for the main journal O.D.s from left to right.

Record the corresponding main journal O.D. code numbers from the crank weight.

Cross reference the main journal and bearing support codes to determine the replacement bearing color code.

