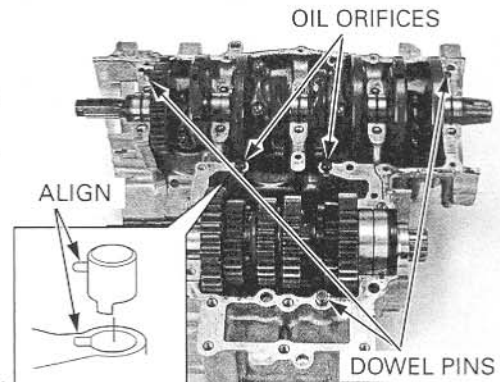


CRANKCASE/TRANSMISSION

Install the three dowel pins.
Install the oil orifices in the upper crankcase.

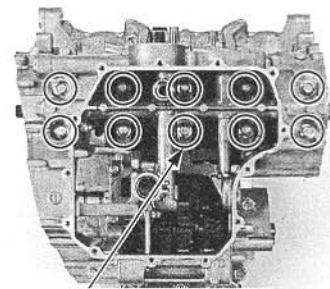
NOTE:

- Right oil orifice: Align its pin with the crankcase groove as shown.
- Left oil orifice: Align its cut-out with the crankcase.



- Tighten the crankcase 8 mm bolts (main journal bolts) using the Plastic Region Tightening Method described below.
- Do not reuse the crankcase 8 mm bolts (main journal bolts), because the correct axial tension will not be obtained.
- The crankcase 8 mm bolts (main journal bolts) are pre-coated with an oil additive for axial tension stability. Do not remove the oil additive from the new 8 mm bolts (main journal bolts) surface.

Install the lower crankcase onto the upper crankcase.



CRANKCASE 8 mm BOLTS
(MAIN JOURNAL BOLTS)

PLASTIC REGION TIGHTENING METHOD:

Install new crankcase 8 mm bolts (main journal 8 mm bolts).

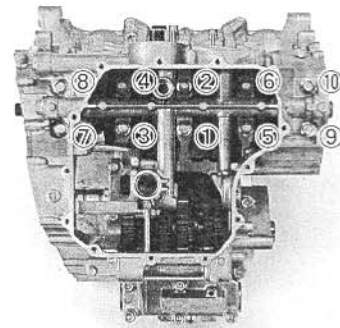
Loosely install all the crankcase bolts.

Make sure the upper and lower crankcase are seated securely.

Tighten the crankcase 8 mm bolts (main journal bolts) as follow:

Tighten the crankcase 8 mm bolts (main journal bolts) in numerical order in the illustration in two to three steps to the specified torque.

Further tighten the crankcase 8 mm bolts (main journal bolts) 120-degrees.



TORQUE: 15 N·m (1.5 kgf·m, 10 lbf·ft) + 120°