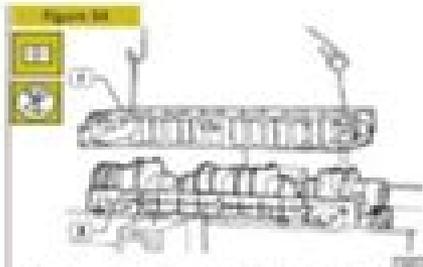
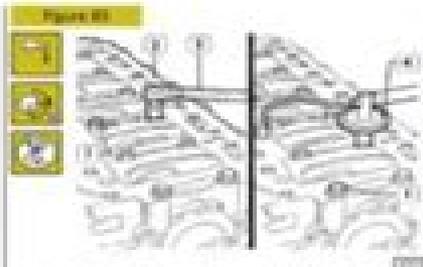


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Place a piece of oil-soaked wire on the journal of the crankshaft (1), cover to the longitudinal axis, until the lower shoulder (2) is fully and uniformly coated.



Lubricate both sides (1) and (2) with oil and tighten them to torque specified in T40 Torque Table, then with 60° angle closing, following the diagram in Figure 11.

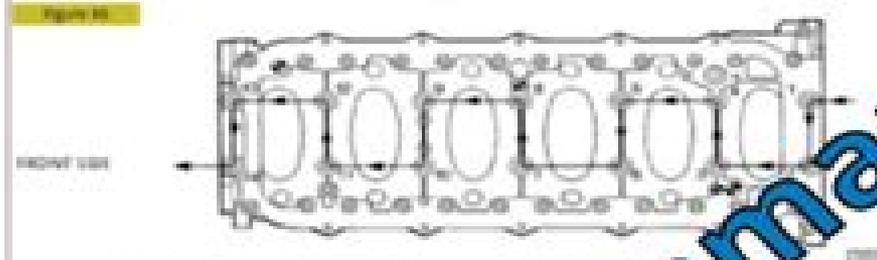


Diagram showing the tightening order of the main bearings for the lower crankshaft.



Remove the main bearings (1) from the crankshaft (2). The clearance between the main bearings and the crankshaft is obtained by comparing the bearing clearance (1) with the maximum clearance (2) specified in the T40 Torque Table on the bearing fit table. If the clearance is greater than the maximum clearance, the bearing is damaged and must be replaced. If the clearance is less than the maximum clearance, the bearing is not damaged and can be reused.



Feel that is checked by using a feeler feel gauge (1) or feeler gauge (2) as shown in the Figure 14. If the clearance is higher than specified, replace the new shaft-hull bearing and repeat the check.



Remove the flywheel (1) and the flywheel nut (2) and tighten the flywheel nut (3) to the torque specified in the T40 Torque Table.



Apply WD40 (1) and pull out the main bearing (2).



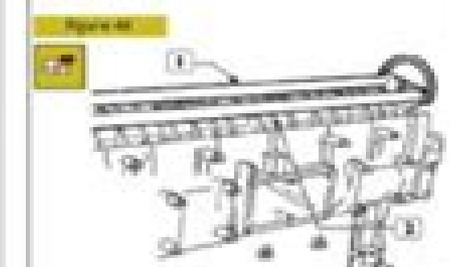
Tighten the main bearings (1) and take down the gear housing (2).



Remove the main bearings (1) and the main bearing nut (2). Remove the main bearing nut and the main bearing nut (3) and tighten the main bearing nut (4) to the torque specified in the T40 Torque Table.



Remove the check spring (1) of the exhaust valve cover. Tighten the flywheel nut (2) of the main bearing.



Apply WD40 (1) to the main bearing shaft (2) and remove the shaft (3) from the cylinder head.

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