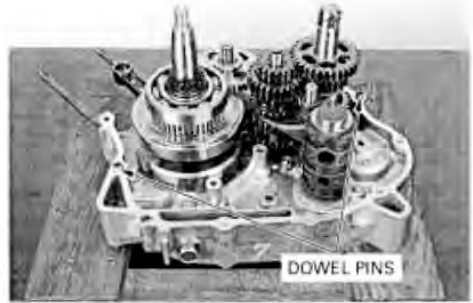


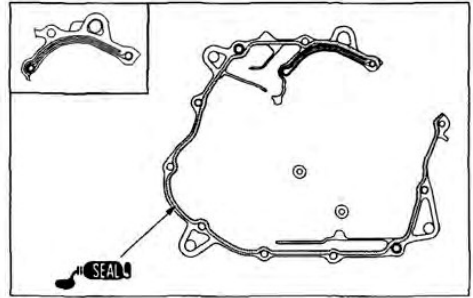
## CRANKCASE ASSEMBLY

Clean the left and right crankcase mating surfaces thoroughly, being careful not to damage them and check for damage.

Install the dowel pins onto the right crankcase.



Apply a light but thorough coating of sealant to left crankcase mating surface except the oil passage area.



Make sure all the parts are installed in the left and right crankcases.

**CAUTION:**

*Do not force the crankcase halves together, if there is excessive force required, something is wrong. Remove the right crankcase and check for misaligned parts.*

Install the left crankcase over the right crankcase.



Install the right crankcase bolts and washer, and tighten the bolts in a crisscross pattern in 2 or 3 steps.

