

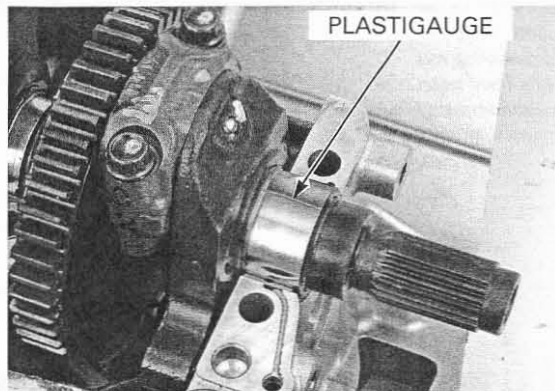
CRANKCASE/CRANKSHAFT/BALANCER/PISTON/CYLINDER

OIL CLEARANCE INSPECTION

Clean off any oil from the bearing inserts and main journals.

Install the crankshaft onto the upper crankcase. Put a strip of plastigauge lengthwise on each main journal avoiding the oil hole.

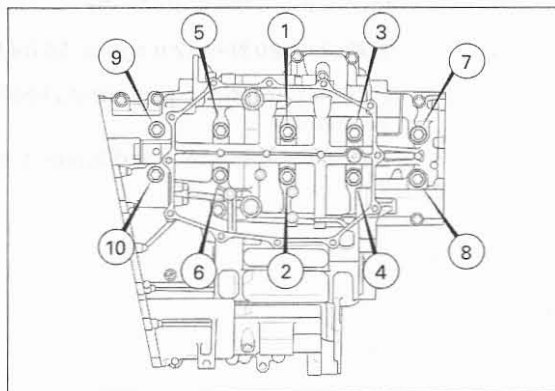
- Do not rotate the crankshaft during inspection.



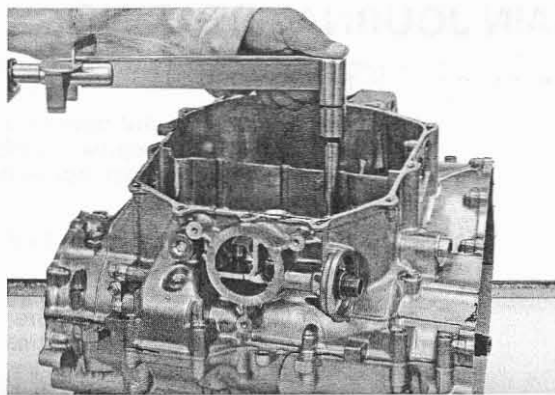
Install the lower crankcase onto the upper crankcase, then install the crankcase 9 mm bolts (main journal bolts).

Tighten the 9 mm bolts in numerical order to the specified torque.

TORQUE: 20 N·m (2.0 kgf·m, 14 lbf·ft)



Further tighten the 9 mm bolts 150 degrees.



Remove the crankcase 9 mm bolts (main journal bolts) and lower crankcase, measure the compressed plastigauge at its widest point on each main journal to determine the oil clearance.

SERVICE LIMIT: 0.05 mm (0.002 in)

If the oil clearance exceeds the service limit, select a replacement bearing.

