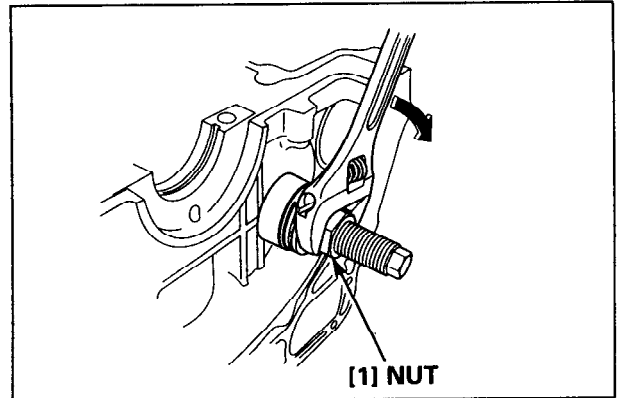


- 8) Install the bearing by tightening the nut.

CAUTION:

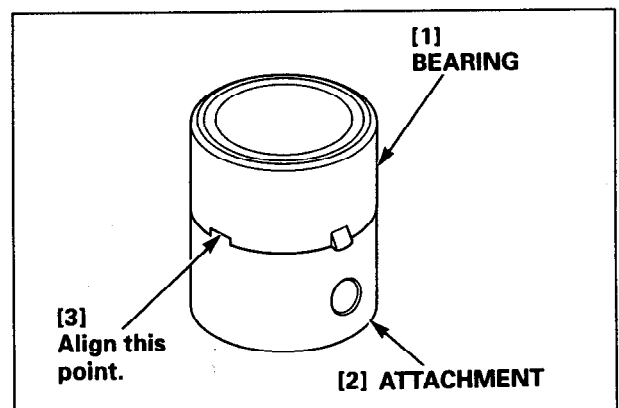
Be sure that the bearing tab aligns with the groove in the cylinder block, and tighten the nut slowly.



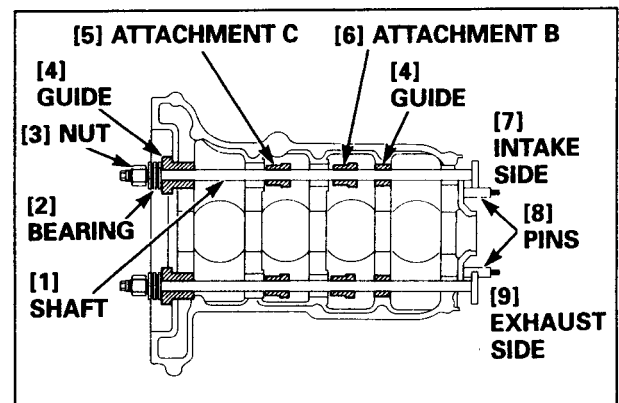
<No.2/No.3 bearing installation>

- Do not perform the bearing installation at several places simultaneously. Complete installation one by one securely.

- 1) Set the bearing by aligning the notch in the bearing with the projection on the attachment.



- 2) Install the special tools at the positions shown.

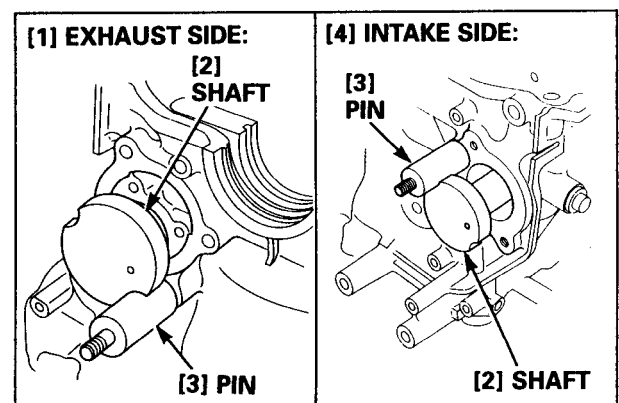


- 3) Align the pin of the special tool with the cutout in the shaft as shown, and tighten the pin against the cylinder block.

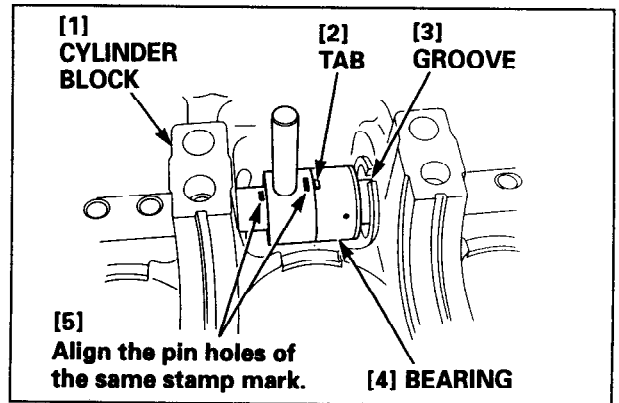
- Tighten the pin noting the installation direction as shown.

Exhaust side: Tighten with the finer threads toward the cylinder block.

Intake side: Tighten with the wider threads toward the cylinder block.



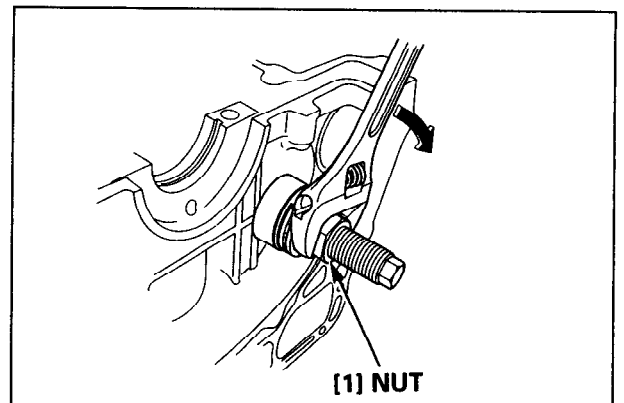
- 4) Align the stopper pin hole in the attachment and the stopper pin hole in the shaft, and insert the stopper pin into the holes to fix the attachment.
- 5) Align the bearing tab with the groove in the cylinder block.



- 6) Install the bearing by tightening the nut.

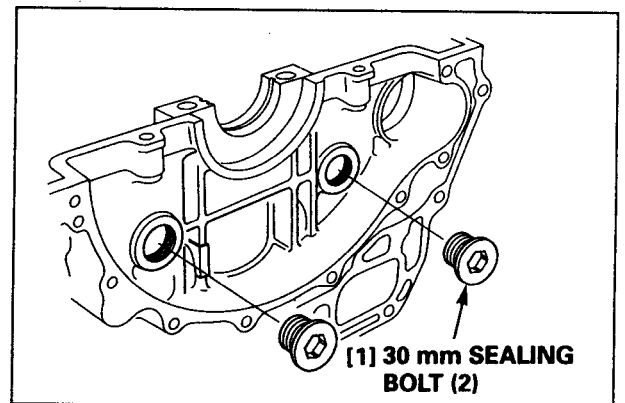
CAUTION:

Be sure that the bearing tab aligns with the groove in the cylinder block, and tighten the nut slowly.



- 7) Remove the special tools after tightening all bearings.
- 8) Apply an adhesive agent (Three Bond #1386B or equivalent) to the threaded part of the 30 mm sealing bolts, and tighten the bolts to the specified torque.

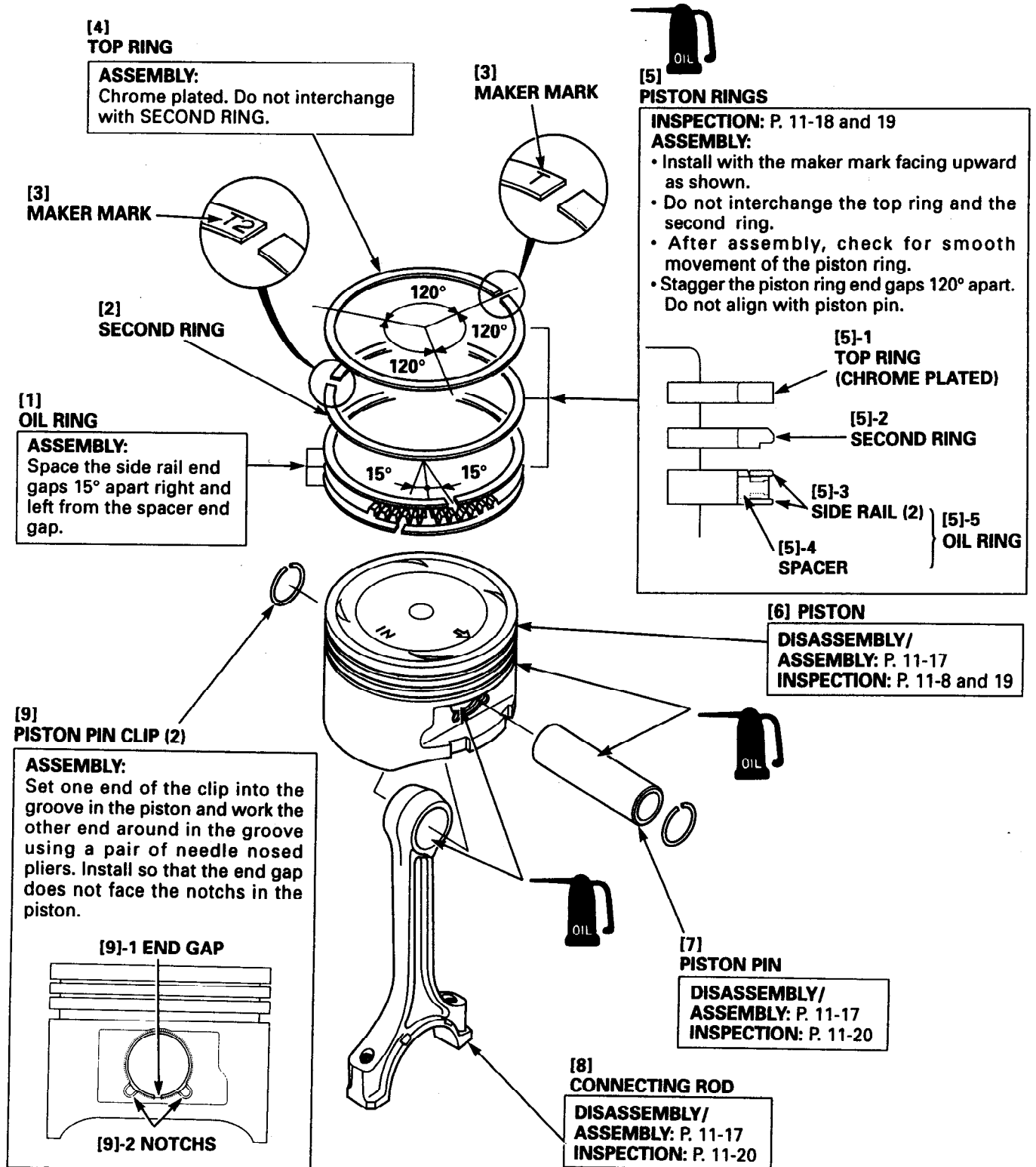
TORQUE: 78 N·m (8.0 kgf·m, 58 lbf·ft)



5. PISTON

a. DISASSEMBLY/ASSEMBLY

After installing the pistons and connecting rods in the cylinder block, secure the rods to the crankshaft.



● PISTON/PISTON PIN/CONNECTING ROD

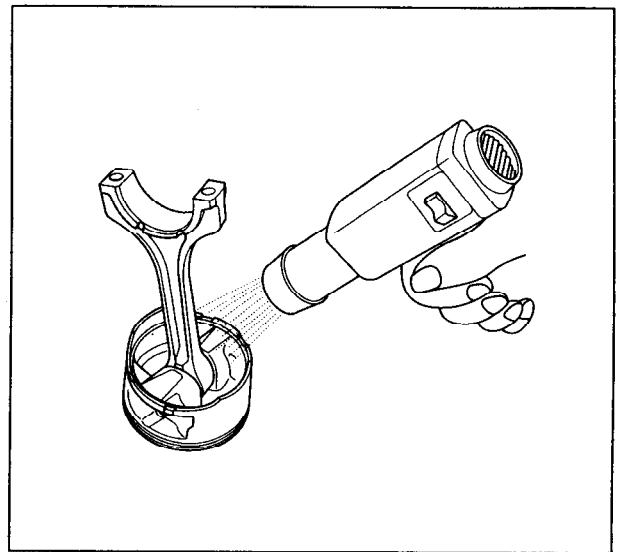
DISASSEMBLY:

- 1) Remove the piston ring and the piston pin clip (P. 11-16).
- 2) Warm up the piston/connecting rod assembly to approximately 50°C - 80°C (122°F - 176°F), and remove the piston pin.

⚠ WARNING

Take care not to get your hand, etc. burned during disassembly.

Note that the check of the piston, piston pin and the connecting rod must be made after the parts return to the normal room temperature.

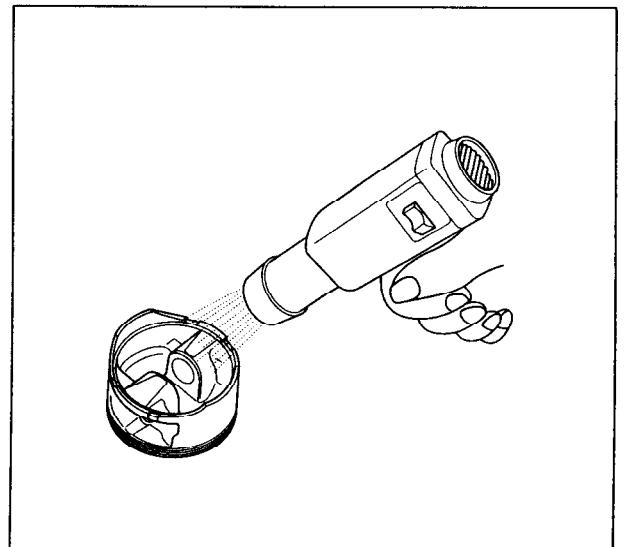


ASSEMBLY:

- 1) Install the piston pin clip on one side only (P. 11-16).
- 2) Warm up the piston to approximately 50°C - 80°C (122°F - 176°F)

⚠ WARNING

Take care not to get your hand, etc. burned during disassembly.



- 3) Apply engine oil to the pin holes in the piston pin and the piston and to the connecting rod small end.
- 4) Install the piston pin so that the "↑" mark on the piston head points to the opposite side from the model mark (PAA mark) on the connecting rod.
- 5) Install another piston pin clip on the opposite side from where the piston pin clip was installed in step 1 (P. 11-16).
- 6) After assembly, check whether the piston moves freely with the dead weight.

