

### PLASTIC REGION TIGHTENING METHOD:

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

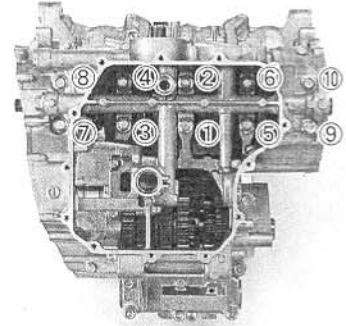
Loosely install all the crankcase bolts.

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.

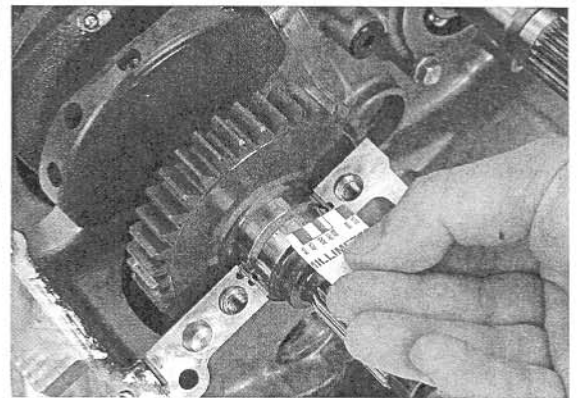


### TORQUE: 15 N·m (1.5 kgf·m, 10 lbf·ft) +120°

Remove the crankcase 8 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)

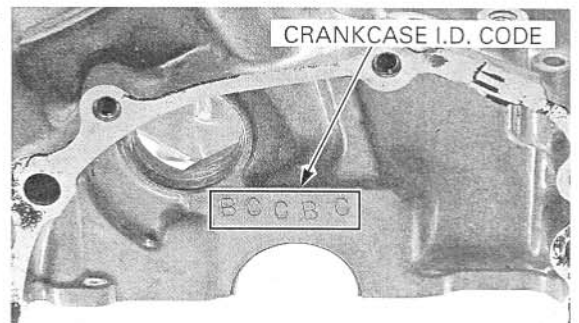
If the oil clearance exceeds the service limit, select a replacement bearing.



### BEARING SELECTION

Record the crankcase bearing support I.D. code letters from the pad on the left side of the upper crankcase as shown.

*Letters (A, B or C) on the left side of upper crankcase are the codes for the bearing support I.D.s from left to right.*



Record the corresponding main journal O.D. code numbers from the crank weight.

*Numbers (1, 2 or 3) on the crank weight are the codes for the main journal O.D.s from left to right.*

