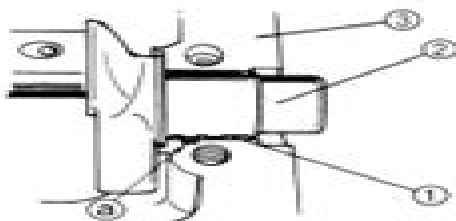




3. Install half of the main bearings ① and the crankshaft ② into the cylinder block ③.

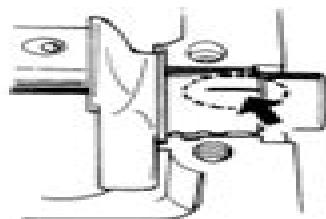


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**NOTE:**

- Install the main bearings in their original positions.
- Insert the projection (a) of each bearing into the slots in the cylinder block.

4. Put a piece of Plastigauge (PG-1) on each crankshaft journal parallel to the crankshaft.



56D55870

**NOTE:**

Be sure not to put the Plastigauge (PG-1) over the oil hole in each main journal of the crankshaft.

5. Install the remaining half of the main bearings into the crankcase.

**NOTE:**

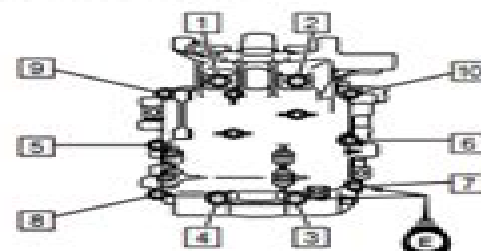
- Install the main bearings in their original positions.
- Insert the projection of each bearing into the slots in the crankcase.

6. Install the crankcase onto the cylinder block.

**NOTE:**

Apply engine oil to the threads of the crankcase bolts.

7. Tighten the crankcase bolts to the specified torques in 2 stages and in the sequence shown.



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**NOTE:**

Do not turn the crankshaft until the crankshaft journal oil clearance measurement has been completed.



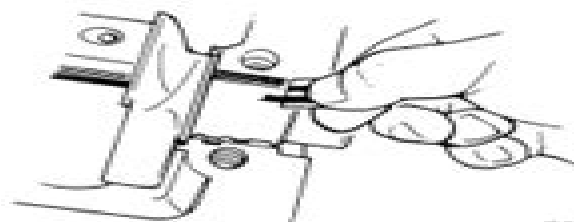
Crankcase bolt ①-④ (M8):

- 1st: 14 N·m (1.4 kgf·m, 10.3 ft·lb)
- 2nd: 27 N·m (2.7 kgf·m, 19.9 ft·lb)

Crankcase bolt ⑤-⑩ (M6):

- 1st: 6 N·m (0.6 kgf·m, 4.4 ft·lb)
- 2nd: 12 N·m (1.2 kgf·m, 8.9 ft·lb)

8. Gently remove the crankcase, and then measure the width of the compressed Plastigauge (PG-1) on each crankshaft journal. Replace the main bearings if out of specification.



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