



Figure 2.1.1



Figure 2.1.2



Figure 2.1.3



Figure 2.1.4



Figure 2.1.5

## Sealing Case Cover and Crankshaft

### NOTE

Before disassembling, check the side clearance of crankshaft. Also check it during reassembly.

1. Remove the bearing case cover mounting screws.
2. Remove the bearing case cover (2).
3. Remove the bearing case cover (2) (3).
4. Turn the crankshaft (4) to set the crank pin (7) of the first cylinder to the bottom dead center. Then draw out the crankshaft and the crank pin of the adjacent cylinder comes to the center of the first cylinder.
5. Turn the crankshaft by 2-04 rad (120°) counterclockwise to set the crank pin (8) of the second cylinder to the bottom dead center. Draw out the crankshaft until the crank pin of the first cylinder comes to the center of the first cylinder.
6. Repeat the above steps to draw out all the crankshafts.

### Other reassembling

#### RECOMMEND

1. Install the crankshaft sub assembly, aligning the screw hole of main bearing case (2) (2) with the screw hole of cylinder block (7).
2. Apply engine oil to the seat and thread of bearing case screw (2) (2) and tightening it.
3. Fit the bearing case gasket and the bearing case cover gasket with correct direction (2).
4. Apply liquid-type gasket (Torque Seal 1215 or its equivalent) to both sides of a new bearing case cover gasket.
5. Install the bearing case cover (2) to position the casting mark "1" (2) on it upward.
6. Tighten the bearing case cover mounting screws with even force on the diagonal line.

Tightening torque	Bearing case cover mounting screws	10-12 N·m (0.1-1.2 kgf·m) 1.0-1.2 kgf·m (9.8-11.8 N·m)
	Bearing case cover (2)	10-12 N·m (0.1-1.2 kgf·m) 1.0-1.2 kgf·m (9.8-11.8 N·m)

- (1) Cylinder block  
(2) Main Bearing Case (2)  
(3) Bearing Case Cover  
(4) Fly Wheel (1)  
(5) Bearing Case Screw (2)

- (6) Crankshaft  
(7) Crank Pin  
(8) Crank Pin  
(9) Fly Wheel

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