

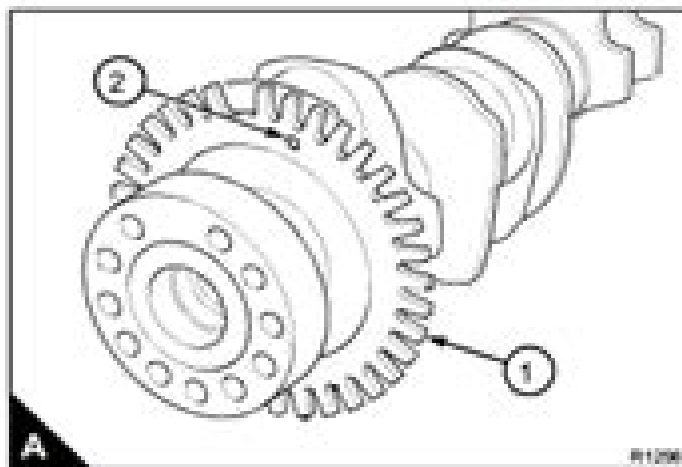
To fit

Operation 5-14

Warning! Ensure that suitable protective clothing is worn.

Cautions:

- Apply heat to the timing ring evenly to reduce the risk of damage and distortion to the timing ring (A1)
 - Carefully fit the timing ring, do not damage the crankshaft palm oil seal face.
- 1 Ensure that the timing ring bore, and the crankshaft timing ring location shoulder, are both clean and free from any rough metal edges.
 - 2 If the locating dowel (A2) was removed press a new locating dowel into the hole in the crankshaft web. Ensure that the locating dowel is at the bottom of the hole.
 - 3 Support the crankshaft in a vertical position with the crankshaft palm at the top.
 - 4 Heat the timing ring (A1) in an oven to a temperature of between 207°/250°C (405°/482° F). With the timing ring bore chamfer and relief groove towards the crankshaft web, and the dowel hole aligned with the dowel, immediately fit the timing ring. Ensure that the timing ring is fitted fully against the crankshaft web shoulder.
 - 5 Allow the timing ring to cool safely.
 - 6 Fit the crankshaft to the cylinder block, see Operation 5-11.



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