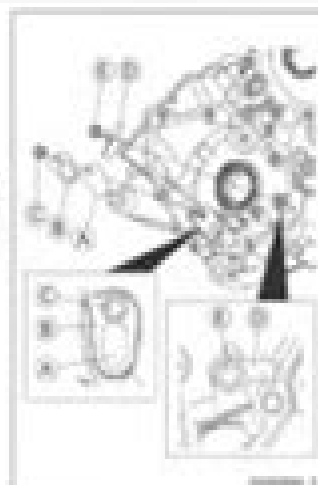


Crankcase

- **Install:**
 - Rock Valve (A)
 - Rock Valve Holder Bolt (B)
 - Rock Valve Holder Bolt (C)
 - Oil Separator Plate (D)
 - Oil Separator Plate Bolt (E)
- **Tighten:**
 - Torque - Rock Valve Holder Bolt: 10 Nm (7.5 kg-m, 55 in-lb)
 - Oil Separator Plate Bolt: 10 Nm (7.5 kg-m, 55 in-lb)



Right Crankcase

- Press the new crankshaft bearing (A) and new drive shaft bearing (B) until they bottom out.
- Press the new output shaft bearing (C) until it bottoms out so that the outer side (D) faces outside of the engine.

Special Tool - Bearing Driver Set: 97001-1120



- Press the new shaft drum ball bearing (A) until it bottoms out.
- Press the new shaft shaft needle bearing (B) so that the bearing surface is flush with the crankcase surface.

Special Tool - Bearing Driver Set: 97001-1120



- **Install the right crankcase bearing retainers.**
(The right crankcase bearing retainers are larger than left ones.)
- Apply a non-permanent locking agent to the crankcase bearing retainer screws (A).
- **Tighten:**

Torque - Crankcase Bearing Retainer Screws: 10 Nm (7.5 kg-m, 55 in-lb)

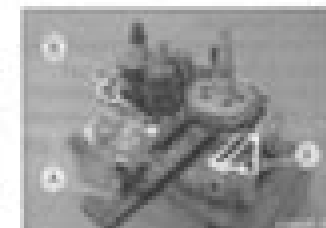


Crankcase

- **Install:**
 - Plunger (A)
 - Spring (B)
- Press the collar (C) so that the collar surface is flush with the crankcase surface.
- **Special Tool - Bearing Driver Set: 97001-1120**
- **Install the nut (D)**
 - Outside of the Engine (E)
- **Tighten:**
 - Torque - Nut: 1.0 Nm (0.10 kg-m, 10 in-lb)
- **Install the piston of nozzle (F)**
- **Tighten:**
 - Torque - Piston Oil Nozzle: 3.0 Nm (0.31 kg-m, 27 in-lb)



- **Install:**
 - Crankshaft (see Crankshaft Installation: 112)
 - Transmission Shafts (see Transmission Shaft Installation: 113)
 - Shift Drum (see Transmission Shaft Installation: 113)
 - Shift Fork (see Transmission Shaft Installation: 113)
 - Shift Rod (see Transmission Shaft Installation: 113)
 - Oil Screen (Pump) (see Oil Screen Cleaning and Mount: 1017: 82)
- Position the connecting rod in SOC.
- Install the crankshaft pg (A) between the crankshaft flywheels.
- **Special Tool - Crankshaft pg: 97001-1119**
- Check to see that the dowel pins (B) are in place in the mating surfaces of the crankcase halves.



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