

e. Move pistons up so that connecting rod bearings are against crankpins. Using OMC Needle Bearing Grease, place 16 needles on each crankpin and attach connecting rod caps. Be sure the connecting rod dowel pins are in place before attaching connecting rod caps, and the lock plates are on the connecting rod screws. Tighten screws to torque specified in Section 2. See Figure 5-23.

f. Check whether all the needles are in place in the assembled connecting rod bearing by inserting a small rod or wire through the oil hole in the cap. It will not be possible to touch the crankpin with the wire if the correct number of needles has been used. See insert, Figure 5-24.

g. Check for binding of the connecting rod. The rod should be free to move easily over the full length of the crankpin. If rod binds, check alignment. See Figure 5-25.

h. Bend lock plates up to prevent connecting rod cap screws from loosening and backing out.



Figure 5-24. Checking Connecting Rod Cap Alignment

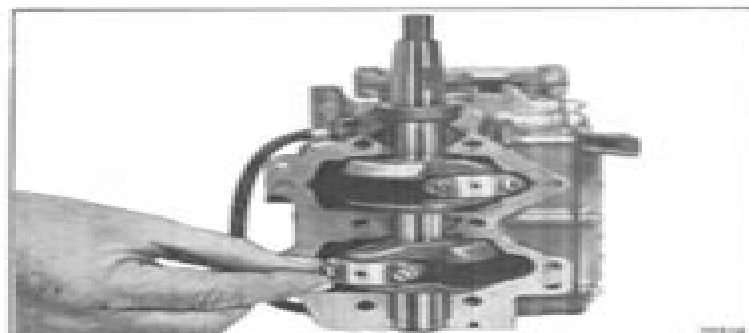


Figure 5-25. Checking for Binding

CAUTION

DO NOT adjust position of screw if tab does not fit against flat on screw. Lock plate tab must be made to conform to screw.

CRANKCASE AND CYLINDERS

a. Apply a thin line of Sealer 1000 to crankcase face. DO NOT over-cement; excess will squeeze over to foul oil channels, etc.

b. Position crankcase and replace crankcase taper pins, driving in carefully with a hammer. Install attaching screws finger tight.

c. Tighten all crankcase screws to torque specified in Section 2.

d. Check for binding between the crankshaft and the bearings or connecting rods by rotating the crankshaft with the flywheel.

e. Install cylinder head using a new gasket. Tighten cylinder head screws to torque specified in Section 2.

f. Replace inner and outer exhaust covers, using new gaskets. Install all screws finger tight before tightening to specified torque.

g. Install oil return hose on crankcase, and tighten clamps with pliers.

NOTE

Re-torque cylinder head screws after running motor at normal operating temperature, and motor has cooled.

OIL DRAIN VALVE

a. The oil drain valve ordinarily requires little or no attention; however, when the motor is being serviced, remove and clean the oil drain valve plate assembly.

b. If gum or varnish is found in the crankcase during servicing, clean the leaf valve in OMC Accessory Engine Cleaner, as it is likely that gum and varnish have also been deposited there.

c. Make sure that the leaf valve seats against the leaf plate. Reassemble and install. See Figures 5-1 and 5-6. Leaf stop clearance should be .045".

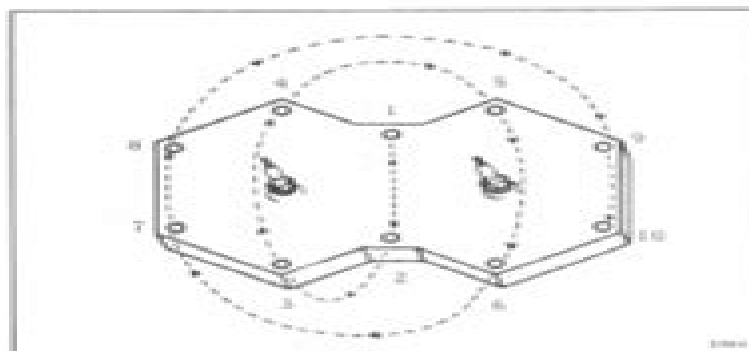


Figure 5-26. Cylinder Head Torquing Sequence

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Tao Wei



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