

JLO Twin Cylinder Engines

Disassembly and Assembly Procedure -

Models LR-340/2 (2F-340-1), LR-399/2 (2F-400-1) and LR-440/2 (2F-440-2).

Assembly

7. Upper Fan Belt Pulley Assembly

Insert Nilos ring, first tapered spacer (dished side towards fan), first pulley half, four adjustment shims, second pulley half, second tapered spacer (dished side facing outward), washer and nut. Note: block impeller with a punch when tightening nut.

8. Flywheel Magneto; Ignition Timing

Align magnetic flywheel with keyway, insert and tap key into position. Lightly tighten flywheel nut. For timing, refer to Timing Procedure.

9. Cylinder Heads

Install cylinder head gaskets with the wide side of the metal ring facing up. Assemble cylinder heads with corresponding cylinders and install washers and nuts. Tighten to 28/32 ft. lbs.

10. Spark Plugs

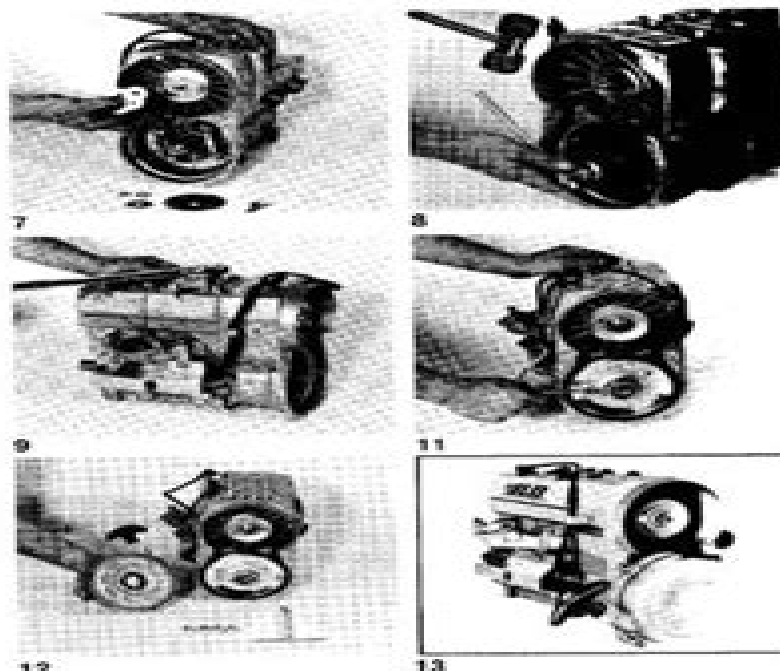
Install and tighten spark plugs. Complete tightening of flywheel nut (25/29 ft. lbs.).

11. Lower Fan Belt Pulley Assembly

Install the first pulley half with dished side facing the housing, the fan belt, the second pulley half with the dished side facing out and the carrier assembly. Tighten carrier screws while slowly rotating the crankshaft with your hand to prevent squeezing the fan belt. Install dust seal.

12. Recoil Starter

Install recoil starter assembly using the four hexhead screws, clamps and lockwashers. For detailed service instructions, refer to Recoil Starter, Disassembly and Assembly.



Electric Starter Mounting Instructions

Models LR-340/2 (2F-340-1), LR-399/2 (2F-400-1) and LR-440/2 (2F-440-2).

Ring Gear Kit

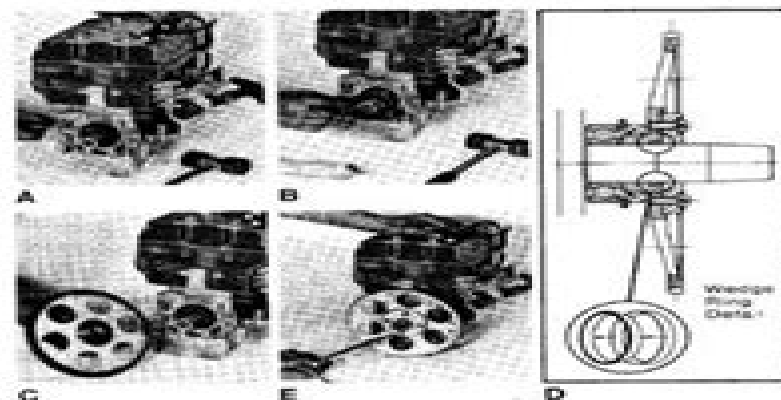
A. With screwdriver, pry out oil seal from P.T.O. end.

B. Remove rubber protective band from ring gear hub. Insert new, larger seal flush with the crankcase.

C. Lightly grease ring gear hub and slide ring gear onto crankshaft.

D. Install the two ring gear wedge rings as follows: first, insert the smaller of the two rings into the ring gear opening with the tapered end facing you; then the larger ring with the tapered end facing the engine.

E. Insert pressure flange and tighten.



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Table of Contents Jlo Rockwell Lr 340 2 Service Manual

1. Understanding the eBook Jlo Rockwell Lr 340 2 Service Manual
 - The Rise of Digital Reading Jlo Rockwell Lr 340 2 Service Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying Jlo Rockwell Lr 340 2 Service Manual
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Jlo Rockwell Lr 340 2 Service Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from Jlo Rockwell Lr 340 2 Service Manual
 - Personalized Recommendations
 - Jlo Rockwell Lr 340 2 Service Manual User Reviews and Ratings
 - Jlo Rockwell Lr 340 2 Service Manual and Bestseller Lists
5. Accessing Jlo Rockwell Lr 340 2 Service Manual Free and Paid eBooks
 - Jlo Rockwell Lr 340 2 Service Manual Public Domain eBooks
 - Jlo Rockwell Lr 340 2 Service Manual eBook Subscription Services
 - Jlo Rockwell Lr 340 2 Service Manual Budget-Friendly Options

6. Navigating Jlo Rockwell Lr 340 2 Service Manual eBook Formats
 - ePub, PDF, MOBI, and More
 - Jlo Rockwell Lr 340 2 Service Manual Compatibility with Devices
 - Jlo Rockwell Lr 340 2 Service Manual Enhanced eBook Features
7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Jlo Rockwell Lr 340 2 Service Manual
 - Highlighting and Note-Taking Jlo Rockwell Lr 340 2 Service Manual
 - Interactive Elements Jlo Rockwell Lr 340 2 Service Manual
8. Staying Engaged with Jlo Rockwell Lr 340 2 Service Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Jlo Rockwell Lr 340 2 Service Manual
9. Balancing eBooks and Physical Books Jlo Rockwell Lr 340 2 Service Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Jlo Rockwell Lr 340 2 Service Manual
10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
11. Cultivating a Reading Routine Jlo Rockwell Lr 340 2 Service Manual
 - Setting Reading Goals Jlo Rockwell Lr 340 2 Service Manual
 - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of Jlo Rockwell Lr 340 2 Service Manual
 - Fact-Checking eBook Content of Jlo Rockwell Lr 340 2 Service Manual
 - Distinguishing Credible Sources
13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
14. Embracing eBook Trends
 - Integration of Multimedia Elements

- Interactive and Gamified eBooks

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