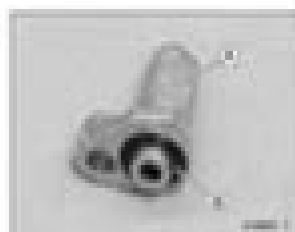


Crankcase

- When installing the piston at master [A], note the following:
 - Replace the O-ring [B] with a new one.
 - Install the O-ring in the piston at master.



- Apply a nonpermanent locking agent to the threads of the piston at master bolt [A].
 - Tighten:

Torque - Piston at Master Bolt: 1.8 Nm (0.17 kg-m, 13 in-lb)



- Install:
 - Crankshaft (see Crankshaft Installation)
 - Transmission Shaft (see Transmission Shaft Installation)
 - Oil Screen / Patch (see Oil Screen / Patch Installation in the Engine Lubrication System chapter)

- Replace the O-ring [A] with a new one, and apply grease.
- Install:
 - Cover Pin [B]
 - O-ring



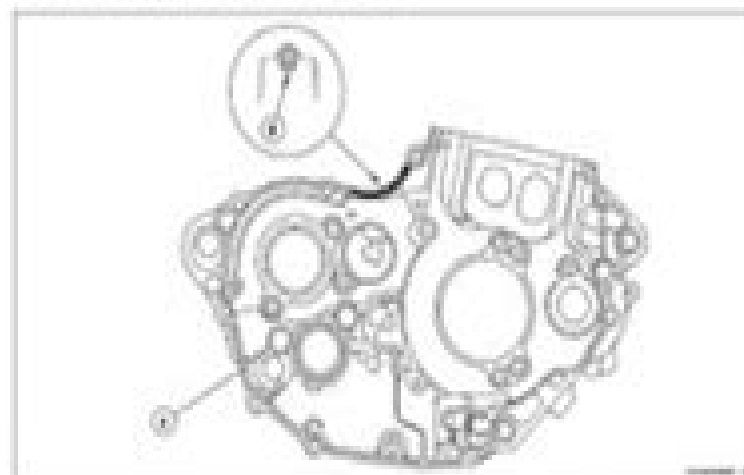
Crankcase

- Using a high flash-point solvent, clean off any oil or dirt that may be on the liquid gasket coating area. Dry them with a clean cloth.
- Apply liquid gasket to the mating surface [A] of the left crankcase half.

Sealer - Liquid Sealer, Teflon® 42744-1000

NOTE

- Excessively apply liquid gasket so that it will be filled up on the groove [B].
- Rotate the application from within 30 minutes when the liquid gasket to the mating surface of the left crankcase half is applied.
- Moreover fit the case and tighten the case bolts just after finishing the application of the liquid gasket.



- Using a plastic hammer, press the rear portion of the crankcase, and fix the area around the crankshaft of the left crankcase half. While maintaining the mating surfaces of the right and left crankcase halves constantly parallel, make the crankcase halves even.
- When the left crankcase half cannot install easily, position the connecting rod at the bottom dead center, and install the crankshaft [A] [A] between the crankshaft flywheel.

Special Tool - Crankshaft Jig: 51001-010

NOTE

- Constantly check the alignment of the two crankcase halves, and the position of the transmission shafts and shift drum. The front and rear of the crankcase must be pushed together evenly.



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