

# 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

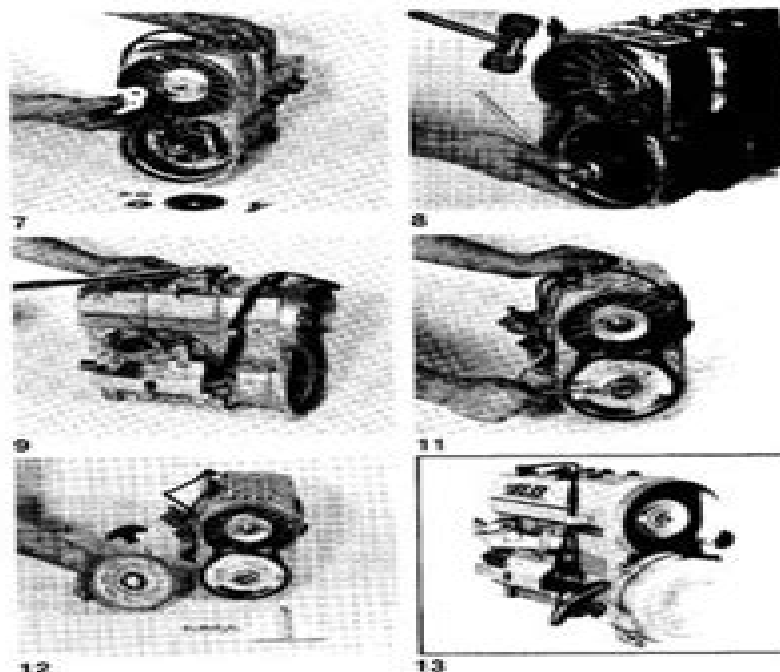
Install and tighten spark plugs. Complete tightening of flywheel nut (25/29 ft. lbs.).

#### 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

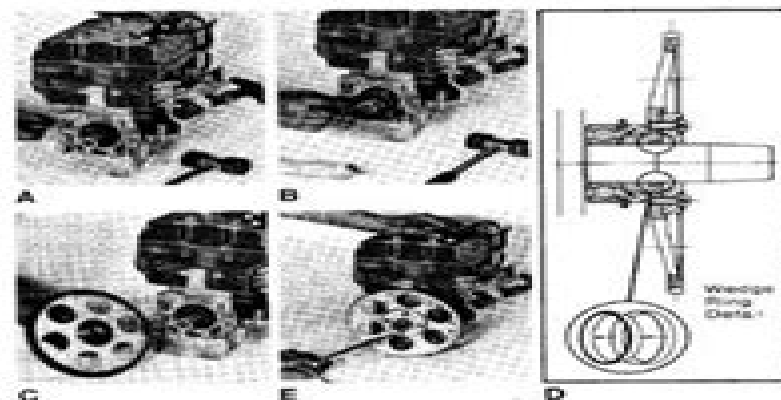
A. With screwdriver, pry out oil seal from P.T.O. end.

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.



# Jlo Rockwell Lr 340 2 Service Manual

**Jin-Ying Zhang**



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