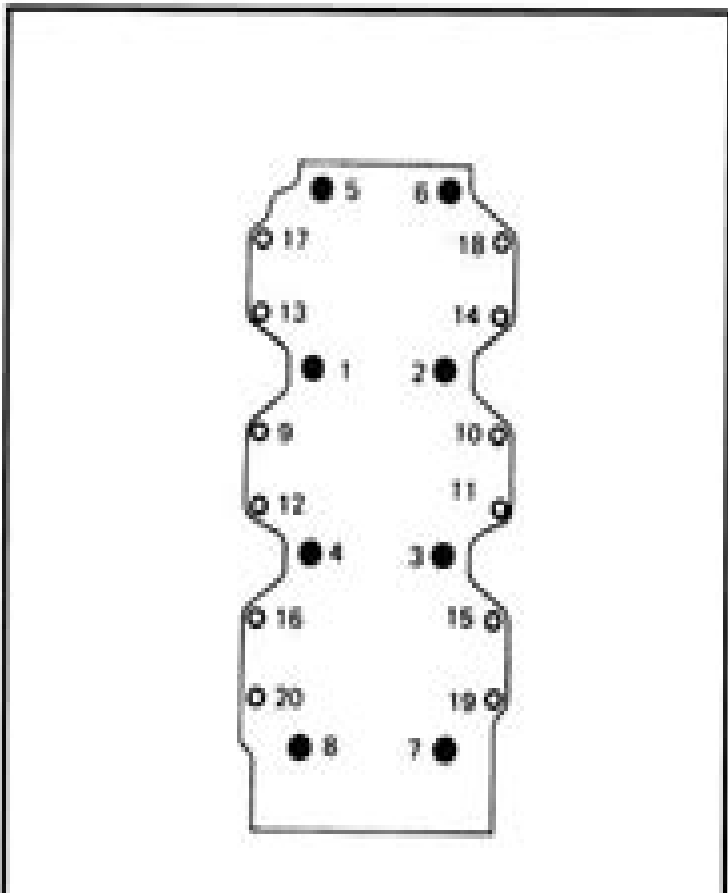
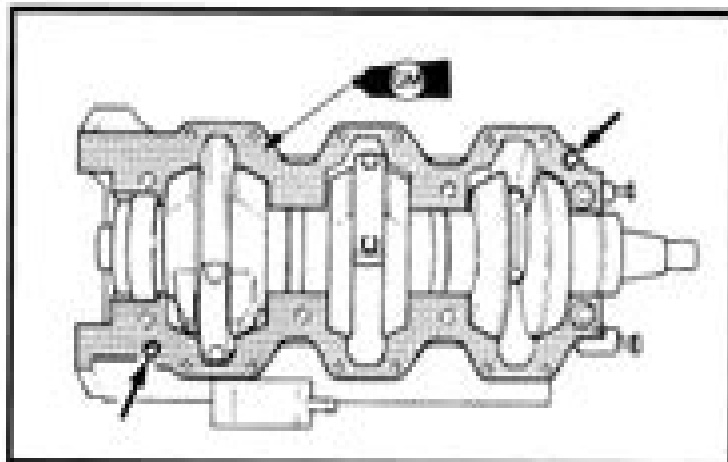




M10: 40 Nm (4.0 m • kg, 29 ft • lb)

6. Check that the crankshaft turns smoothly.

GP4002-01

CRANK CYLINDER ASSEMBLY (75, 80, 90 hp)

1. Align each locating-pin of the bearings and labyrinth-seals with each cut on the cylinder-block. Then, fit the crank assembly in place.
2. Film-coat the cylinder-block mating surface with Gasket Maker or equivalent.
3. Install the dowel-pins.
4. Match the cylinder-block and tighten the bolts to the specified torque in sequence and in two steps.



Crankcase bolt (75, 80, 90 hp)

1st step:

M6: 4 Nm (0.4 m • kg, 2.9 ft • lb)

M10: 20 Nm (2.0 m • kg, 14 ft • lb)

2nd step:

M6: 12 Nm (1.2 m • kg, 8.7 ft • lb)

M10: 40 Nm (4.0 m • kg, 29 ft • lb)

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Michael Hoelscher

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