

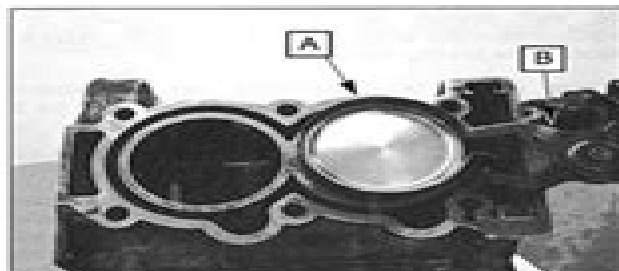
ENGINE

3. Apply engine oil to ring compressor band and install band (A) over piston rings.

CAUTION

Be sure compressor band end gap does not align with any ring end gap when compressing the rings.

4. Fully compress piston rings using compressor pliers (B) on band.
Piston Ring Compressor Band, 87 mm: PV-43570-3
Piston Ring Compressor Pliers: PV-43570-1
5. Apply tape to the sides of connecting rods to protect cylinder from damage.
6. Align piston with bore and push into cylinder until all rings are captive. Remove ring compressor.



Crankshaft Installation

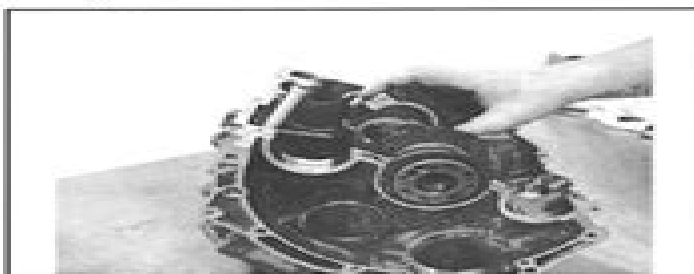
Refer to Crankcase Assembly (Upper) .

1. Clean the bearing bore surfaces of upper crankcase (main bearings), connecting rods and connecting rod caps.

2. Align tab of a new main bearing with the slot in main bearing bore of crankcase. Press bearing insert firmly into place. Repeat for all main bearings, connecting rods, and connecting rod caps.



3. Apply Premium Starter Grease (2871460) to each main and rod bearing journal of crankshaft.
4. Loop cam chain over crankshaft sprocket.
5. Apply engine oil to new crankshaft seals and install seals on both ends of crankshaft with spring side of seal facing IN (toward crankshaft).
6. Carefully lower crankshaft into upper crankcase. Guide connecting rods onto rod journals of crankshaft as necessary.
7. Adjust crankshaft seals so each is flush with end of crankcase.
8. Install rod caps on connecting rods with marks aligned.



9. Install new connecting rod bolts (apply clean engine oil to threads) and tighten evenly until snug.

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A Gutmann



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