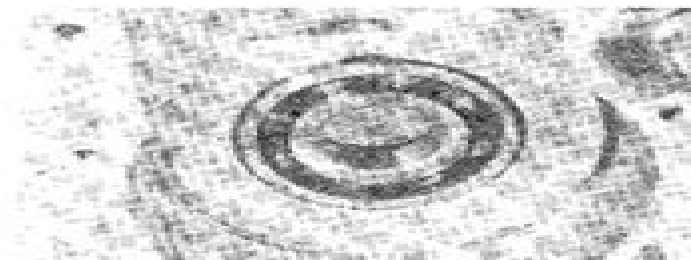


1. Thoroughly remove the gasket on the crankcase sealing surface and drive the bearings into the left and right crankcase.

NOTE:

Be sure that the bearings are fit squarely in the crankcase.

2. Install the oil seals into the left and right crankcase.



3. Install the bearing holder onto the left and right crankcase.
4. Using the crankshaft installing tool, install the crankshaft assembly into the right-side crankcase.

NOTE:

Note the position of the connecting rod. It must be in the cylinder sleeve hole as shown in the photograph.

5. Install the two dowel pins and spacer into the right-side crankcase, and install the left-side crankcase onto the right-side crankcase.

NOTE:

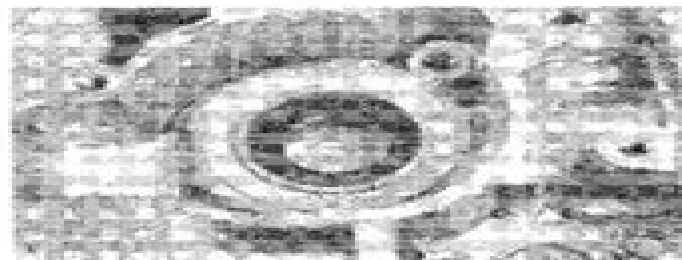
Apply Yamaha Bond No. 4 to the mating surfaces of both case halves.

1. Éliminer soigneusement les restes de joint des plans de joint de carter puis insérer les roulements dans les carters gauche et droit.

N.B.:

S'assurer que les roulements sont bien ajustés de niveau dans le carter.

2. Monter les bagues d'étanchéité dans les carters gauche et droit.



3. Monter le support de roulement sur les carters gauche et droit.
4. A l'aide de l'outil de montage de vilebrequin, monter l'ensemble vilebrequin dans le carter droit.

N.B.:

Noter la position de la bielle. Elle doit être dans le cylindre comme montré sur la photo.

5. Monter les deux goujons d'assemblage et l'entretoise dans le carter droit puis monter le carter gauche sur le carter droit.

N.B.:

Appliquer du YAMAHA BOND No. 4 sur les plans de joint des deux demi-carters.

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