

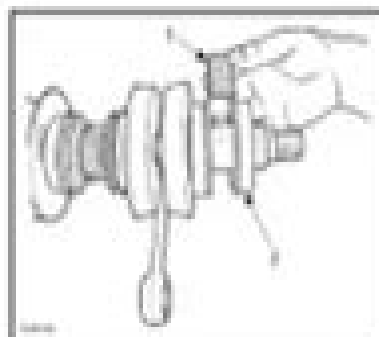


FIGURE 1  
Distance Ring

### 15. Distance Ring

When installing the distance ring on the crankshaft, make sure to position it with its chamfer to ward the counterweight of the crankshaft.

### 1. Seal

At seal assembly, apply a light coat of lithium grease on seal lips.

### 6. Drive Pin

Make sure that pins of bearings where applicable are properly installed in crankcase recesses of assembly.

### 13,14. Counterbalance Shaft and Crankshaft

#### 117 Engine

Install crankshaft first in crankcase.

After crankshaft installation, install counterbalance shaft. Make sure to properly align crank shaft and counterbalance shaft by aligning marks of pins.

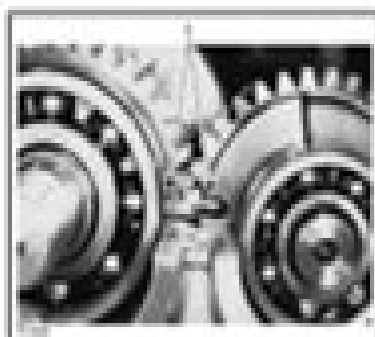


FIGURE 2

### 3. Crankcase

Crankcase halves are factory matched and therefore are not interchangeable or problem in range halves.

Prior to joining crankcase halves, apply a light coat of Loctite 115 on mating surfaces. Do not apply to screws as it will spread out inside crankcase.

**NOTE:** On maximum material it is recommended to use Loctite Primer 99 to reduce curing time and increase gap filling capability. See Loctite Corporation's instructions.

**CAUTION:** Safety valve shaft must be installed in crankcase before closing halves. Before joining crankcase halves, make sure that crankshaft gear is well engaged with rotary valve shaft gear.

Position crankcase halves together and hand tighten screws.

**CAUTION:** Temporarily install alignment plate to align crankcase halves with each other (except the 117 engine).

### 11. Fitting

If pins and roller of fittings of rotary valve shaft have been removed from crankcase, reinstall them with their ends pointing toward spring housing. Apply Loctite 115 on threads of fittings.

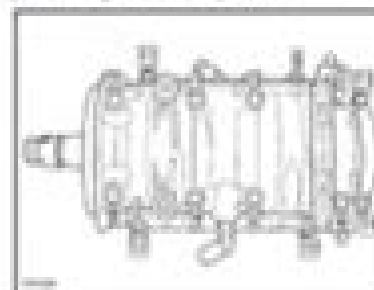
### 7.8. Crankcase Screw

Apply Loctite 115 on screw threads and synthetic grease before final screws.

#### 117 and 119 Engines

##### 7.8.8. Crankcase Screw

Torque crankcase screws to 24 ft-lbs (32 Nm) as per following Australian sequence.



##### 8. Crankcase Screw

Torque 7 M10 crankcase screws to 40 ft-lbs (54 Nm).

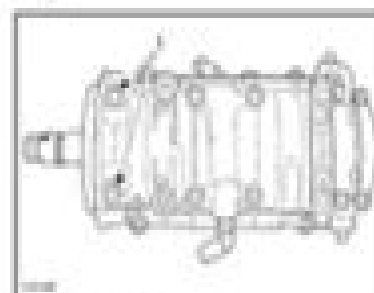


FIGURE 3 TORQUE SEQUENCE

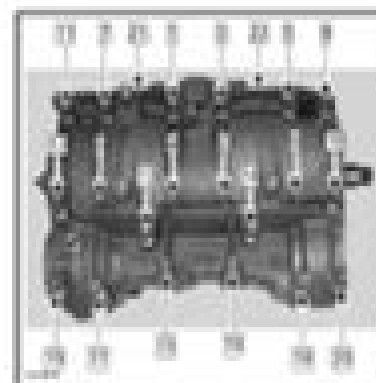
### 10. Stud

At assembly in crankcase, apply Loctite 115 on stud threads. Torque to 10 ft-lbs (14 Nm).

#### 117 Engine

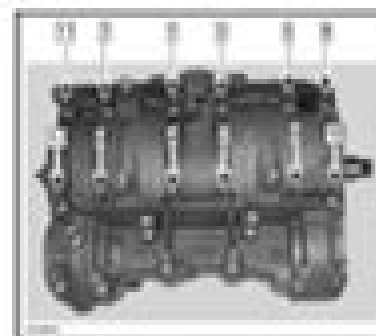
##### 7.8. Crankcase Screw

Torque crankcase screws to 12 ft-lbs (16 Nm) as per following sequence. Repeat procedure on tightening of screws to 24 ft-lbs (32 Nm).



##### 8. Crankcase Screw

As a final step, torque only M10 screws of crankcase to 40 ft-lbs (54 Nm) as per following sequence.



### Final Assembly

For rotary valve timing and assembly procedures, refer to (EXHAUST) 04-04.

#### 117 and 119 Engines

If engine support is installed on crankcase before spring housing, engine marker must be installed before engine support.

# Yamaha Jetski Service Manual

**Editors of Haynes Manuals**



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