

d. Installing the cylinder

Align both ends of the piston ring with the knock pin in each ring groove, and oil each ring. Then install the cylinder by tapping it with a plastic-head hammer.

e. Install the crankcase, valve seat packing, and reed valve assembly, in this order.

**Note:**

- 1) Apply THREE BOND NO. 5 to the sealing surface between the cylinder and the crankcase.
  - 2) Make sure that the oil seal is not interfering with the crankshaft, and that the oil seal outer surface is on a level with the crankcase surface.
  - 3) Tighten all bolts in the sequence as shown in the figure to the left.
- Tightening torque is as follows:  
1st tightening : 0.5 m·kg (3.61 ft·lb)  
2nd tightening : 1.0 m·kg (7.23 ft·lb)

f. Insert the exhaust manifold gasket between the cylinder and the exhaust manifold, and temporarily tighten the bolts with spring washers. After installing the power unit, fully tighten the bolts.

**Note:**

Apply LOCKTIGHT to the threaded portion of each bolt, and fully tighten it with a torque of 5.79 ~ 7.23 ft·lb (0.8 ~ 1.0 m·kg).



Fig. 2-3-4

d. Montage du cylindre

Aligner l'ouverture de chaque segment avec le MKN prévu dans chaque rainure, et graisser les segments. Ensuite, monter le cylindre en place en le tapotant avec un maillet en plastique.

e. Remonter dans l'ordre le carter moteur, le joint de carter d'admission et le carter d'admission.

**N.B.:**

- 1) Appliquer THREE BOND NO. 5 sur les plans de joint entre le cylindre et le carter moteur.
  - 2) Assurer que que les joints ne se valent pas sur le vilebrequin et que l'installation des joints se fait aligné sur le bord du carter.
  - 3) Serrer tous les boulons dans l'ordre indiqué sur la figure.
- Couple de serrage :  
1<sup>er</sup> serrage : 0,5 kg  
2<sup>nd</sup> serrage : 1 kg

f. Insérer le joint de carter, le joint d'échappement entre le cylindre et le carter d'échappement, et serrer temporairement les boulons, sans oublier les rondelles d'acier. Après les boulons à fond quand la moto est montée en place.

**N.B.:**

Appliquer du LOCKTIGHT au filetage de chaque boulon, et serrer ensuite avec un couple de 0,8 à 1 kg.

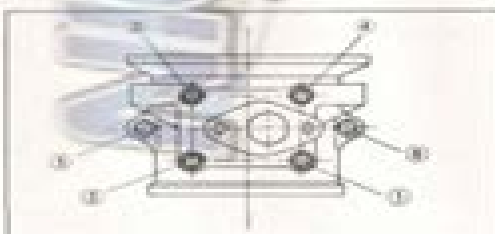


Fig. 2-3-5

d. Einbau des Zylinders

Die beiden Enden des Kolbenringes mit dem Stift in der betreffenden Ringnut ausrichten und beide Ringe ölen. Den Zylinder mit Hilfe eines Hammers mit kunststoffbeschichtetem Kopf einsetzen.

e. Das Kurbelgehäuse, die Ventil Sitzpackung und die Zungenventilgruppe in dieser Reihenfolge einbauen.

**Anmerkung:**

- 1) THREE BOND Nr. 5 auf die Dichtfläche zwischen dem Zylinder und dem Kurbelgehäuse auftragen.
  - 2) Sicherstellen, daß die O-Richtung die Kurbelwelle nicht behindert und daß die Außenfläche der O-Richtung mit der Oberfläche des Kurbelgehäuses fluchtet.
  - 3) Alle Schrauben in der in der Skizze dargestellten Reihenfolge anziehen.
- Anzugsdrehmomente:  
Erstes Anziehen: 0,5 m·kg  
Zweites Anziehen: 1,0 m·kg

f. Die Dichtung der Abgasleitung zwischen dem Zylinder und die Abgasleitung einführen und die mit Federringen ausgestatteten Schrauben vorübergehend anziehen. Sobald die Kraftseinheit angeordnet ist, sind die Schrauben ganz anzuziehen.

**Anmerkung:**

Den Gewindeteil jeder Schraube mit LOCKTIGHT bestreichen und sie mit einem Drehmoment von 0,8 ~ 1,0 m·kg anziehen.



Fig. 2-3-6

# Yamaha P65 Outboard Engine Manual

**Kalton C. Lahue**



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