

To insure proper bearing fit, insert bearings No. 1, No. 3, and No. 4 in the left crankcase section so that the dowel pins and oil passages are in line with their respective holes in the bearing shells. The oil hole of bearing No. 3 which is farthest from the dowel pin fits nearest the camshaft.

2. To simplify installation, mark bearing inserts with a pencil at the crankcase joint so that the dowel pins fit easily.

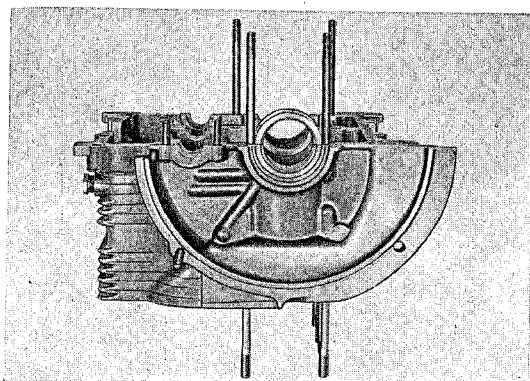


Fig. 238

3. Install bearing No. 3, and woodruff key for timing gear and distributor pinion on crankshaft.
4. Inspect timing gear for wear and tooth contact. Heat to 80° C (175° F) in an oil bath and press onto the crankshaft using sleeve VW 427. Install spacer.

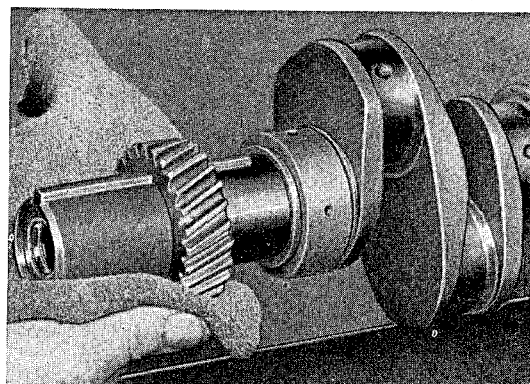


Fig. 239

5. Inspect distributor pinion for wear and replace if necessary. Heat to 80° C (175° F) and press onto crankshaft using sleeve VW 427.

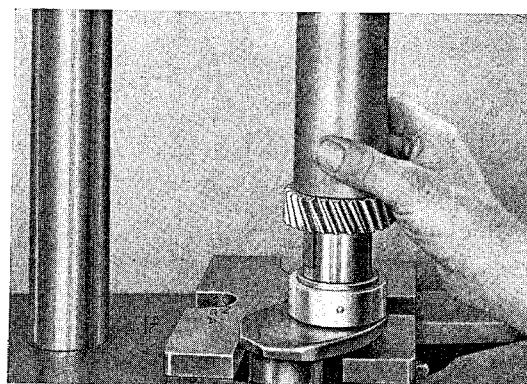


Fig. 240

6. Install the lock ring using sleeve VW 428. When the timing pinion cools on the crankshaft check whether it seats firmly.
7. Clean oil passages in crankshaft using compressed air and flush with oil.
8. Install connecting rods.