

7. Lubricate with graphite oil and install camshaft.

8. Install camshaft end plug.

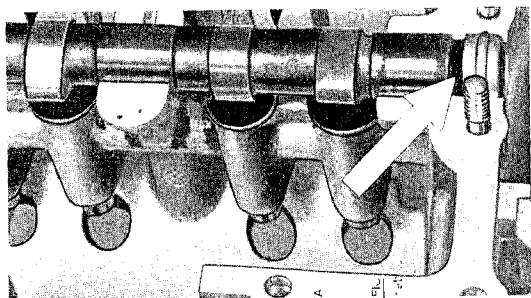


Fig. 222

9. When using a new crankcase, test camshaft rotation and bearing contact using engineer's blue. Remove sharp edges with a scraper.

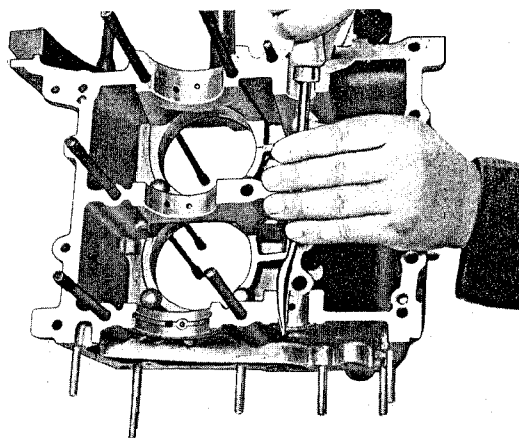


Fig. 223

Note:

If a new camshaft gear is installed, the timing mark, the nearest mounting bolt, and the oil pump drive slot on the camshaft must be in line.

Before drilling and tapering the 5.8 mm (.228 in.) dowel pin holes toward the camshaft, mount the gear and check for eccentricity. The three dowel pins are driven into the gear from the outside so that they fit snugly in the tapered holes and are secured by three punch marks. If necessary, oversize dowel pins can be locally fabricated from high quality steel. Tighten camshaft gear screws to 2.5 mkg (18 ft. lb.) torque.

Removing and Installing Crankshaft and Connecting Rods

45 EN

Removal

1. Disassemble crankcase (36 EN).
2. Remove camshaft.
3. Remove the crankshaft with connecting rods. Do not store a crankshaft without protecting it with preservative grease.
4. Mark both halves of No. 2 bearing insert.

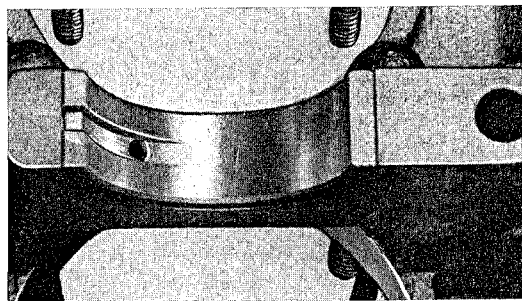


Fig. 224

Installation

The installation is accomplished in the reverse order of removal observing the following points:

1. Remove sharp edges from the main bearing seats at