

4. Remove oil seal washer.
5. Loosen set screw.

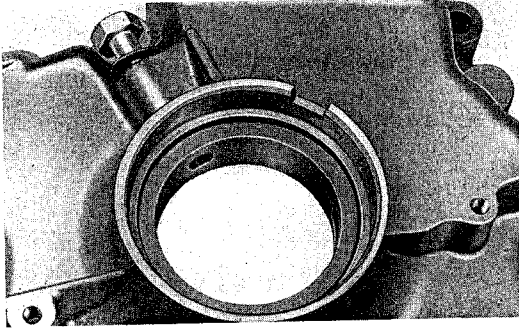


Fig. 204

6. If necessary remove burrs from oil seal housing.

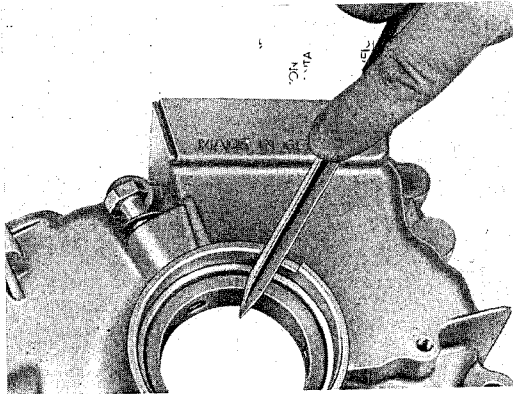


Fig. 205

7. Heat timing case cover to approx 60° C (140° F) and press out bearing No. 4 using tool P 27.

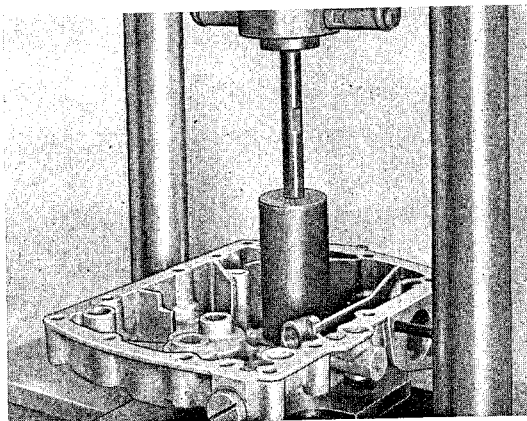


Fig. 206

#### Installation

1. Inspect timing case cover for damage.

2. Inspect main bearing bore.

3. Advance the set screw until it protrudes approx. 1 mm ( $1/32$  in.) into the bearing bore.

4. Heat timing case cover to approx. 160° C (320° F) and set on assembly plate P 27 so that the dowels fit the recesses in the timing case cover.

5. Place bearing insert on the bearing guide of tool P 27 so that the oil hole and set screw groove are in line with the set screw.

6. Press in bearing using drift P 27.

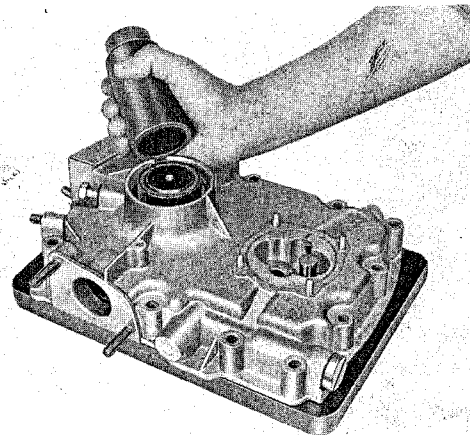


Fig. 207

7. Tighten set screw being sure that it does not press against or deform the bearing.

8. Remove sleeve from bearing guide and install oil seal washer.

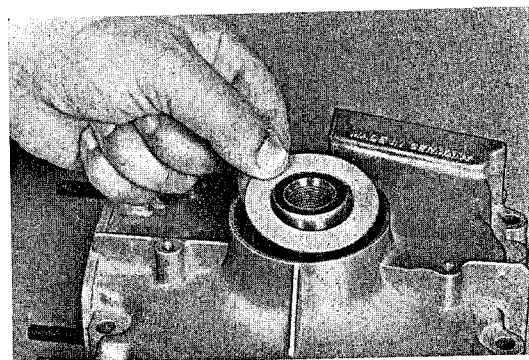


Fig. 208