

5. Remove sharp edges from main bearing bores if necessary.

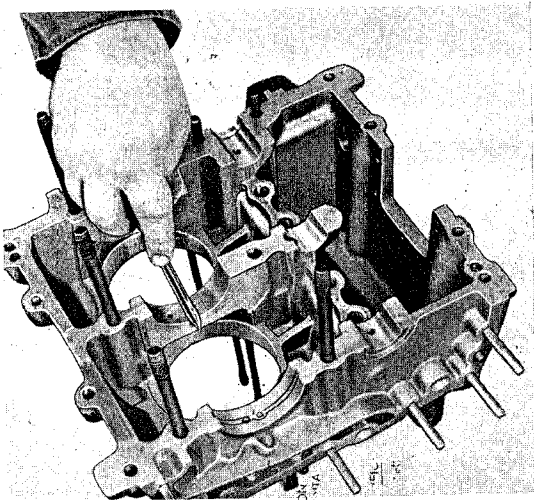


Fig. 191

6. Flush oil passages with solvent and compressed air.
7. Check oil suction pipe for firm leak free seat. If necessary tighten pipe using punch P 50.
8. Check tappets and tappet bores.
9. Check tightness of the dowel pins of the timing case cover.
10. Install main bearing dowel pins.

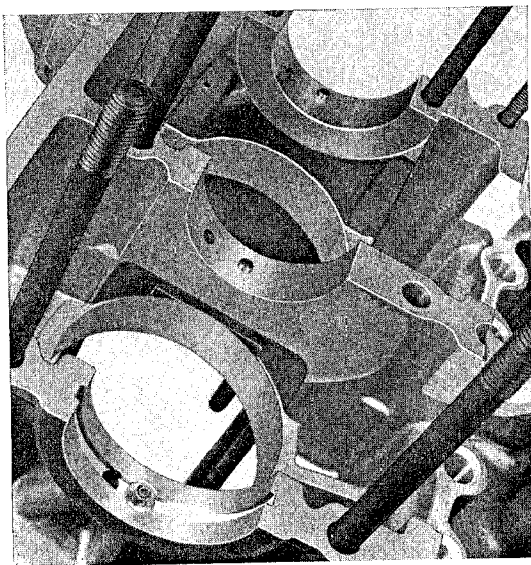


Fig. 192

11. Main bearing No. 2 inserts: Place one half in the left crankcase section so that the oil hole is in line with the oil passage. Place the other half in the right crankcase section so that when assembled their two oil pockets meet.

12. Install crankshaft and camshaft and check free rotation.

13. Install main bearing No. 1 oil seal and thrust washer.

14. Note correct position of timing gears.

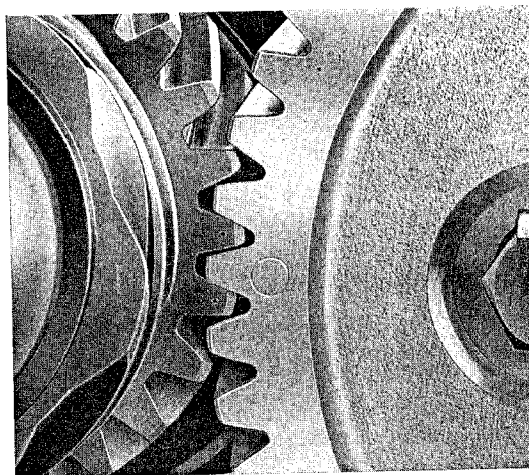


Fig. 193

15. Install camshaft end plug.

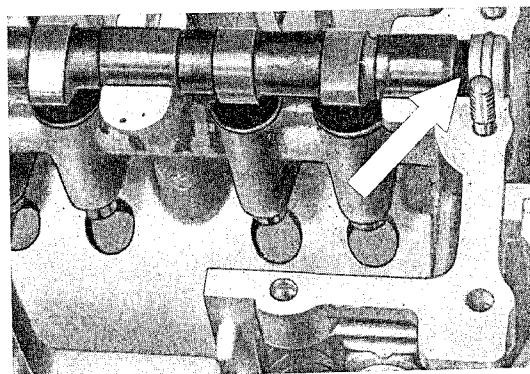


Fig. 194

16. Secure tappets in right crankcase section using springs P 49.

17. Apply a uniform thin coat of sealing compound to joining surfaces.

18. Under no circumstances may sealing compound enter oil passages of the crankshaft and camshaft bearings.