

36. Remove main bearing dowel pins.

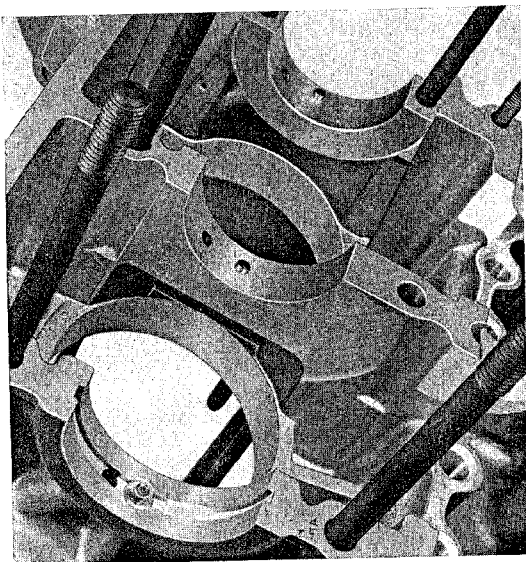


Fig. 45

37. Remove the oil seal, bearing No. 4, and pressure relief valve from the timing case cover.

Assembly

The engine is assembled in the reverse order of the disassembly observing the following points:

1. Thoroughly clean the crankcase sections flushing the oil passages with cleaning solvent and install drain plug.
2. Insert the bearing dowel pins making certain that they do not protrude farther than the recesses in the bearing shells (approx. 1.8 mm, .071 in.).
3. Install bearing inserts of No. 2 bearing into the crankcase halves.

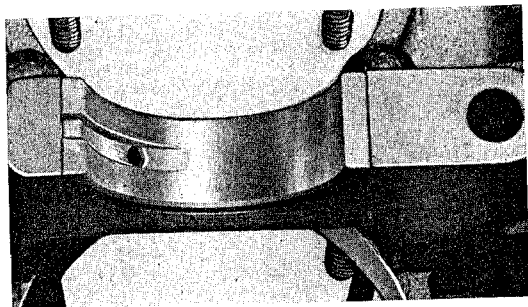


Fig. 46

4. Lubricate with graphite oil and install the tappets.

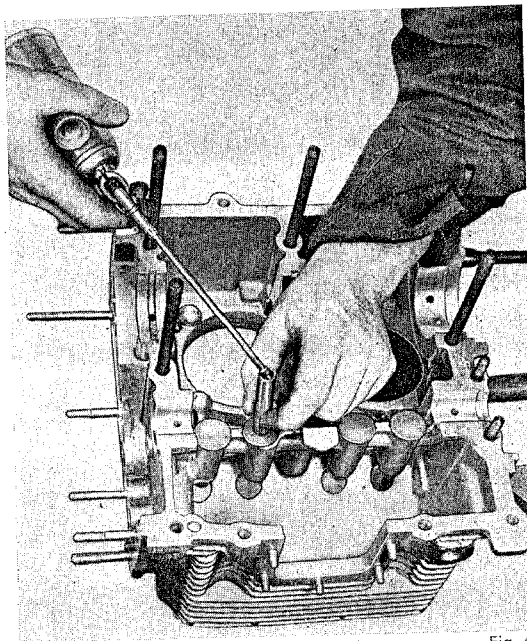


Fig. 47

5. Install complete crankcase assembly (45 EN).

6. Install camshaft observing timing marks (44 EN).

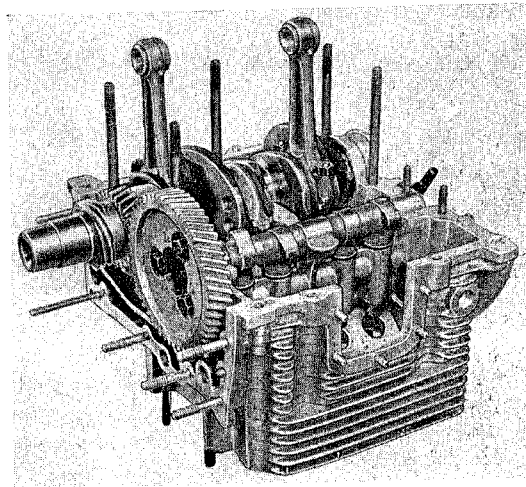


Fig. 48

7. Install thrust washer and oil seal.

8. Install camshaft end plug.

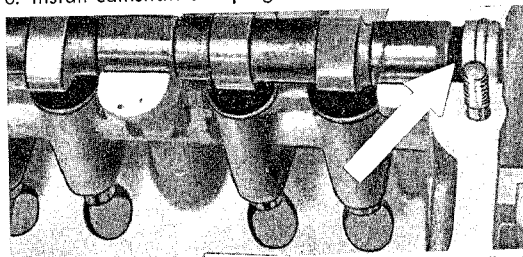


Fig. 49