

Apply enough oil to bearing portions of crankcase. For easy installation, put crankcase on box or wood blocks.

## 2) PISTON and CONNECTING ROD

- (1) Install piston and connecting rod assembly into cylinder by using a piston ring compressor to hold piston rings.

### Note:

- The "1" mark of the connecting rod for #1 cylinder and "2" mark for #2 cylinder should be faced to the flywheel side when assembled.
- Apply enough oil to piston rings, connecting rod bearings (large end) and cylinder bore before assembly.
- Set gaps of piston rings as shown in the illustration.

- (2) Temporary fit key and flywheel and turn crankshaft to BTDC (bottom dead center). Lightly tap the top of piston until large end of the rod meet the pin portion of crankshaft.
- (3) Set connecting rod cap to connecting rod with the alignment marks mated and the clinching portion clinched. Tighten bolts to the specified torque.

**Tightening Torque : 22.1 - 27.0 N·m**  
(225 - 275 kg·cm)  
(16.3 - 19.9 ft·lb.)

- (4) Check for free movement of piston and connecting rod by turning crankshaft slowly.



Fig. 5-31

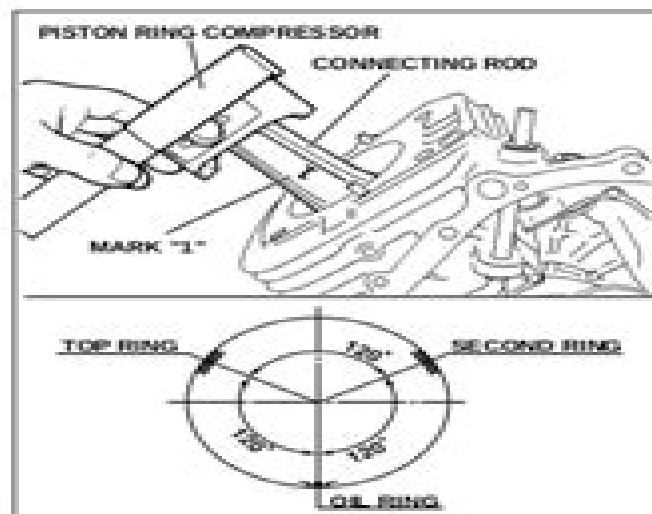


Fig. 5-32

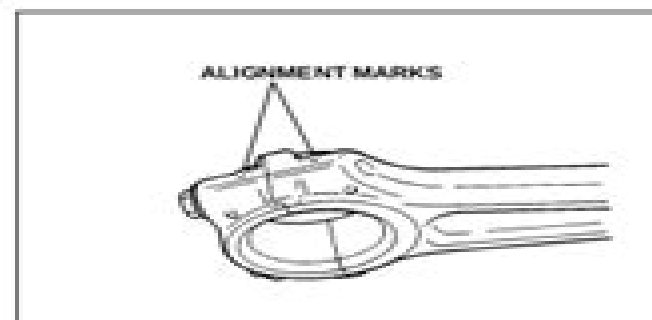


Fig. 5-33

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