

Disassemble cylinder and clean contact on crankcase junction surface. Wipe with clean dry cloth.

3.3 Crankshaft Connecting Rod and Balance Shaft

Apply engine oil on both crankcase pin bearings, crankshaft and balance shaft. Install crankshaft axis (1) and balance shaft axis (2) together into the holes on both crankcase. Align the marks on balance shaft and crankshaft as picture shows.

NOTE: Make sure the marks on balance shaft and crankshaft are aligned after installation. Do not damage gear teeth and pin bearings during installation.



Install piston pin (1).
Put a seal ring (2) on piston pin.
Install piston pin (3).



3.4 Crankcase Assembly

Put special tool Crankshaft Pin Bearing Pushing Jaws (1) on crankcase. Press down (2) and PTV crankcase with clean dry paper. Push the crankcase on crankcase junction surface evenly.

Install PTV crankcase.

NOTE: Make sure the shaft chain is at low gear position during installation. Realign shaft chain position if not. Wipe the overflow sealant after assembly. Make sure the surface is clean.



Install 160 bolts (1) (some of them has a wire clip (2)).

Tighten torque: 10-12N·m

Install 160 bolts (3).

Tighten torque: 23-25N·m

Tighten the bolts in cross-cross way. After tightening, use torque wrench to tighten bolts for second time in cross-cross way.



Install 160 bolts (1).

Tighten torque: 10-12N·m

Install 160 bolts (3).

Tighten torque: 23-25N·m

Tighten the bolts in cross-cross way. After tightening, use torque wrench to tighten bolts for second time in cross-cross way.



3.5 Piston

Install oiler needle (1).

Apply full sealant on crankcase junction surface evenly.

Install piston (2).



Install piston (1).

Apply engine oil on piston pin and insert the pin into piston pin hole and connecting the small end hole.

Install piston pin circlip (2).



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