

Apply oil to the main journal bolt threads and seating surfaces.

Install the main journal 8 mm bolts.

Loosely install all the lower crankcase bolts.

Make sure the upper and lower crankcase are seated securely.

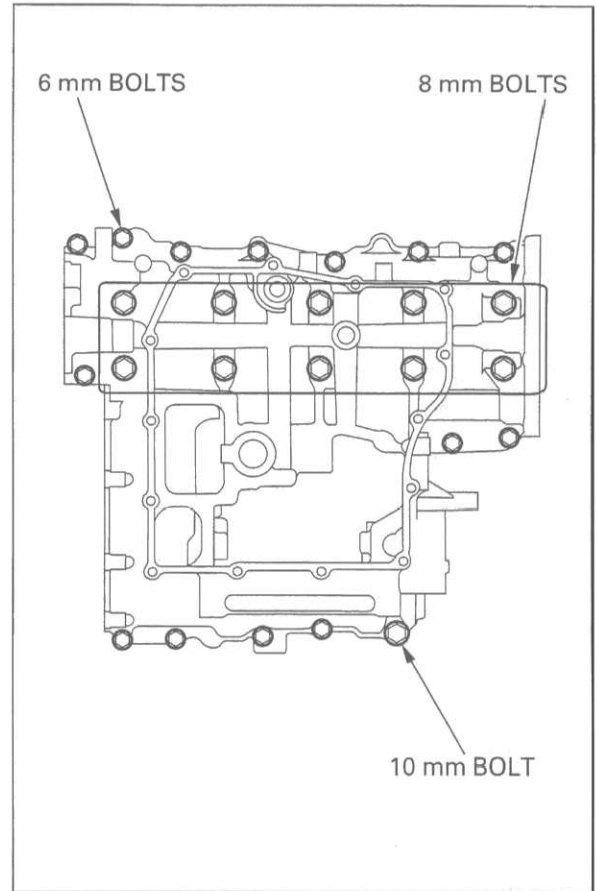
Tighten the main journal 8 mm bolts in numerical order casted on the lower crankcase in several steps, then tighten them to the specified torque.

**TORQUE:** 25 N·m (2.6 kgf·m , 19 lbf·ft)

Tighten the lower crankcase 10 mm bolt.

**TORQUE:** 39 N·m (4.0 kgf·m , 29 lbf·ft)

Tighten the 6 mm bolts.



Install a new sealing washer and upper crankcase 8 mm bolt.

Install a new sealing washer and 6 mm bolts.

**NOTE:**

The sealing washer location is indicated on the upper crankcase using the "△" mark.

Tighten the 6 mm bolts in a crisscross pattern in 2 or 3 steps.

Tighten the 8 mm bolt to the specified torque.

**TORQUE:** 24 N·m (2.4 kgf·m , 17 lbf·ft)

