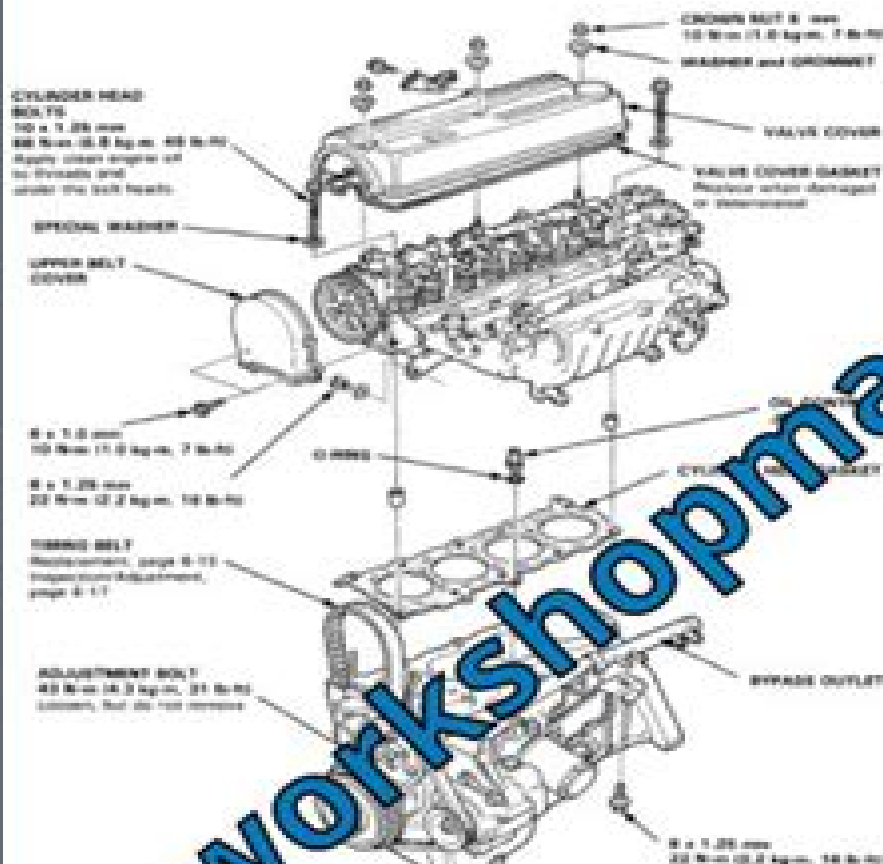


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CAUTION: To avoid damaging the cylinder head, wait until the coolant temperature drops below 38°C before removing it.

NOTE: Use new O-rings and gaskets whenever reassembling.



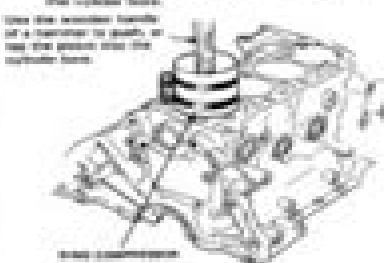
Piston

Installation

- Before installing the piston, apply a coat of engine oil to the ring grooves and cylinder bores. If the crankshaft is already installed:
 - Remove the connecting rod caps, then oil the portions of cylinder bores over the threaded ends of the connecting rod bolts.
 - Insert the ring compressor, check that the ring is seated in place, then position the piston in the cylinder and drive it to within 10 mm (3/8 in.) of a full stroke. Stop when the ring compressor has cleared the connecting rod cap, then remove the cap before driving the piston in.
 - Insert the piston into the cylinder, then insert the nuts to 25 N·m (18 ft·lb).
- If the crankshaft is not installed, install the ring cap, then insert the piston in the cylinder, then insert the nuts to 25 N·m (18 ft·lb).



NOTE: Maximum downward force on ring compressor can be 600 N (135 lb) from connecting rod cap, and 100 N (22 lb) from the piston cap.



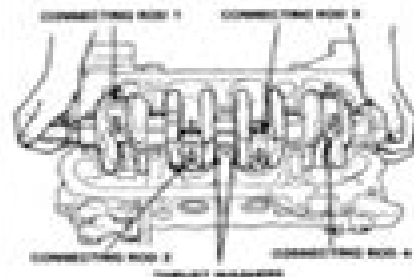
Crankshaft

Installation

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- Before installing the crankshaft, apply a coat of engine oil to the main journals and connecting rod journals.
- Insert the crankshaft into the block, seating the rod journals into connecting rods No. 2 and No. 3 and install rod caps and nuts finger tight.



- Remove the crankshaft clockwise, seat journals into connecting rods No. 1 and No. 4, and install the rod caps and nuts finger tight.
- Install the thrust washers, main bearing halves and caps, check clearance with feeler gauge (0.10 mm (0.004 in.)), then torque the nuts to 55 N·m (40 ft·lb). Oil thrust washer surfaces.

- Check the rod bearing clearance with feeler gauge (page 7-16), then torque nuts to 55 N·m (40 ft·lb).

NOTE: Reference numbers on connecting rod are for top and bottom halves and do NOT indicate the position of pistons in engine.

CAUTION: Whatever any crankshaft or connecting rod bearing is replaced, after reassembly run the engine at idling speed until it reaches normal operating temperature, then continue to run for approximately 15 minutes.

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