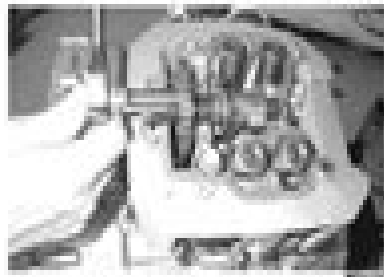
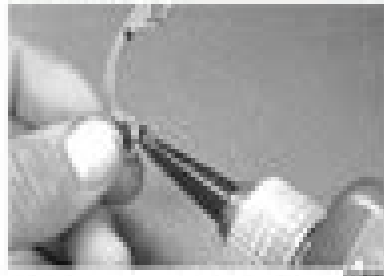


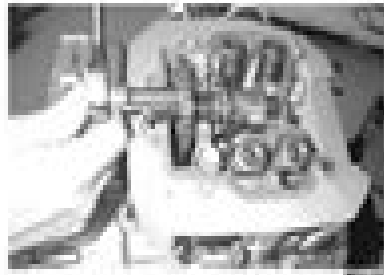
CAUTION

Care must be taken that the oil washer is installed correctly to cover the alignment hole on the sprocket. If the alignment pin falls out, severe engine damage will result.

17. Apply and Loctite 625 to the first cup screw securing the sprocket and oil washer to the crankshaft, then install the cup screw and oil washer. Tighten cup screw only until snug.



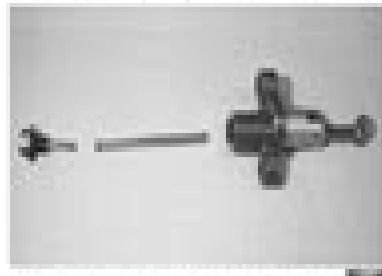
18. Rotate the crankshaft until the second cup screw securing the sprocket to the crankshaft can be installed, then install the cup screw (finger-tighten with oil Loctite 625). Tighten to 11 ft-lb, then bend the tab to secure the cup screw.



19. Rotate the crankshaft until the first cup screw (from step 17) securing the sprocket to the crankshaft can be addressed, then tighten to 11 ft-lb. Bend the tab to secure the cup screw.

20. Install the cylinder head gasket with the copper end facing the crankshaft and the opening directed toward intake.

21. Remove the cup screw from the end of the intake two screws. Account for the flange, spring, and gasket.



22. Depress the spring-loaded lock, and push the flange into the housing.



23. Place the cross slide bearing assembly and gasket into the cylinder seating area. The ribbed side is facing toward the top of the cylinder and screws with the two cup screws.



24. Install the cup screw and spring into the end of the cross slide bearing. Tighten securely.

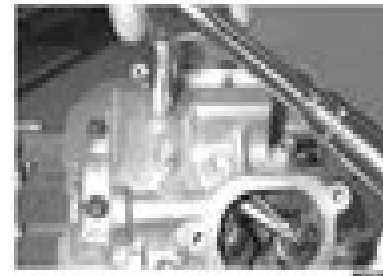


25. Loosen the adjuster screw just enough, then loosen the adjuster screws on the intake stem in the valve cover.

26. Apply a thin coat of Three Bond Sealant to the push-rod surface of the valve cover, then place the valve cover into position. Note that the two alignment pins are properly positioned.

NOTE: At this point, the rocker arms and adjuster screws must not have pressure on them.

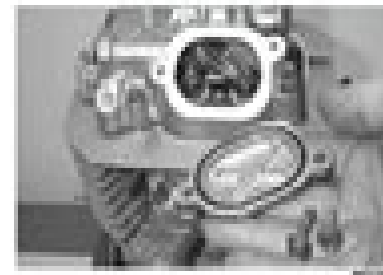
27. Install the four opposite cup screws with rubber washers, then install the remaining cup screws. Tighten only until snug.



28. In a clockwise pattern starting from the center and working outward, tighten the cup screws (from step 27) to 1 ft-lb.

29. Adjust valve-tappet clearance (see Periodic Maintenance section (Valve Tappet Clearance)).

30. Place the two valve inspection covers with O-rings into position, then install and tighten the cup screws to 1 ft-lb.



31. Install the spark plug and tighten securely, then install the timing inspection plug.

Left-Side Components

NOTE: For efficiency, it is preferable to remove and disassemble only those components which need to be addressed and to service only those components. The technician should use discretion and sound judgment.

AT THIS POINT

To service any one specific component, only limited disassembly of components may be necessary. Note the **AT THIS POINT** information in each sub-section.

NOTE: The engine/transmission does not have to be removed from the frame for this procedure.

Removing Left-Side Components

A. Cover/Stator Assembly

1. Remove the cup screws securing the cover supports and remove the cover.
2. Remove the left-side compression mounting cup screws using the location of the 4 mm cup screw with the marker near the middle of the left-side cover. Keep the different-lengthed 4 mm cup screws in order for re-install purposes.



3. Using Endless Square/Endless Remover and the 4 mm adjuster remove the left-side cover & stator assembly. Account for the two alignment pins, and the position of the shaft bracket for re-install per pins.

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