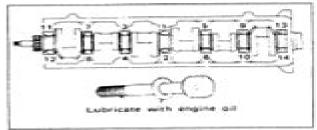




- 5. Crankshaft Bearing Cap
 - 1) Lubricate the bearing cap bolts with engine oil.
 - Install the bearing caps to the crankshaft.

The arrow mark must be pointing to the front of the engine.

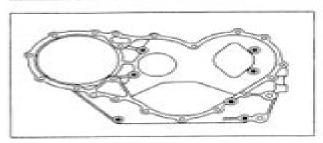
 Tighten the bearing cap bolts to the specified torque a little at a time in the numerical order shown in the illustration.





	kg-m@b.f
Crankshaft Bearing Cap Bolt Torque	24.0 ± 1 (173.5 ± 7.2)

 Check that the crankshaft turns smoothly by manually rotating it.



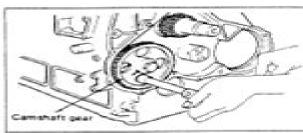


6. Timing Gear Case

- Apply liquid gasket to the timing gear case surfaces contacting the cylinder body.
- Tighten the timing gear case bolts to the specified torque.

kg-m(lb.ft)

Timing Gear Case Bolt Torque



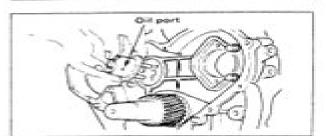


8. Camshaft

Tighten the thrust plate bolts through the camshaft gear hole.

	kg-m(lb.ft
Thrust Plate Bolt Torque	2.6 ± 0.5 (18.8 ± 3.6)

	kg-m(ib.ft
Camshaft Gear Bolt Torque	16 ± 1.5 (115.7 ± 10.5)





9. Idler Gear Shaft

Use the thrust collar fixing bolt as a guide to install the idler gear shaft.

The oil port must be facing the camshaft.

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M Tight

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