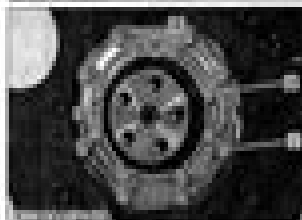
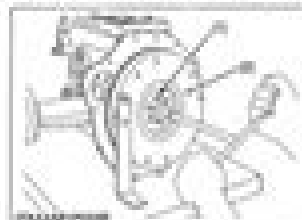


(E) Flywheel and Crankshaft



Flywheel

1. Secure the flywheel to keep it from turning, using a flywheel stopper.
2. Remove all flywheel screws (1) and then remove the flywheel (2).

(When reassembling)

- Align the "F15" mark (a) on the outer surface of the flywheel horizontally with the alignment mark (b) on the rear end plate. Note the flywheel is position.
- Apply engine oil to the threads and the underside surface of the flywheel screws and fit the nut.

Tightening torque	Flywheel screw	Oil to be used 1. 100-150 g 2. 100-150 g
-------------------	----------------	--

- (1) Flywheel screw (a) F15 Mark
(2) Flywheel (b) Alignment Mark

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Bearing Case Cover

1. Remove the bearing case cover mounting screws.
2. Remove the bearing case cover (2).

(When reassembling)

- Fit the bearing case gasket (1) and the bearing case cover gasket (2) with correct directions.
- Install the bearing case cover (2) to position the loading mark "UP" on it upward.
- Apply engine oil to the oil seal (3) to be careful that it is not rolled when installing.
- Tighten the bearing case cover mounting screws with even force on the diagonal line.

Tightening torque	Bearing case cover mounting screw	Oil to be used 1. 100-150 g 2. 100-150 g
-------------------	-----------------------------------	--

- (1) Bearing Case Cover Mounting Screw (Gasket)
(2) Bearing Case Cover Mounting Screw (Gasket)
(3) Bearing Case Cover (Gasket)
(4) Bearing Case Cover (Gasket)

- (a) Oil Seal
(b) Bearing Case Cover
(c) Top Mark "UP"
(d) Gasket

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Crankshaft Assembly

1. Remove the main bearing case screw (1).
2. Put out the crankshaft assembly.

■ IMPORTANT

- Be careful to protect crankshaft bearing 1 from scratches, caused by the crank gear, etc. (Wrap the gear in vinyl tape, etc.)

(When reassembling)

- Clean the oil passage of the crankshaft with compressed air.
- Apply oil to the main bearing case screw (1).
- Install the crankshaft assembly, aligning the screw hole of main bearing case with the screw hole of crankcase.
- Clean the oil passage of the crankshaft with compressed air.

(BX21750 (2121-24) and BX21750 (2101-24))

Tightening torque	Main bearing case screw 1	Oil to be used 1. 100-150 g 2. 100-150 g
-------------------	---------------------------	--

(BX21750 (2101-24))

Tightening torque	Main bearing case screw 1	Oil to be used 1. 100-150 g 2. 100-150 g
-------------------	---------------------------	--

(1) Main bearing case screw 1

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Main Bearing Case Assembly

1. Remove the two main bearing case screws (1) of each main bearing case.
2. Remove the main bearing case from crankshaft.

(When reassembling)

- Clean the oil passage in the main bearing case.
- Apply clean engine oil on the bearings.
- Install the main bearing case assemblies in the original positions.

Since diameters of main bearing cases vary, install them in order of markings (a) (A, B, C) from the gear case side.

- Match the alignment numbers (a) on the main bearing case assembly 1.

- When installing the main bearing case 1 and 2, face the mark "FLYWHEEL" to the flywheel.

- Install the thrust bearing (3) with its oil groove facing outward.

- Make sure that the main bearing case moves smoothly after tightening the main bearing case screw 1 to the specified torque.

(BX21750 (2121-24) and BX21750 (2101-24))

Tightening torque	Main bearing case screw 1	Oil to be used 1. 100-150 g 2. 100-150 g
-------------------	---------------------------	--

(BX21750 (2101-24))

Tightening torque	Main bearing case screw 1	Oil to be used 1. 100-150 g 2. 100-150 g
-------------------	---------------------------	--

- (1) Main Bearing Case Assembly 1 (a) Alignment Number
(2) Main Bearing Case Assembly 1 (b) Marking (A, B, C)
(3) Thrust Bearing

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