

NOTE

- Refer to page 10-1 for the parts that is necessary to be installed after crankcase assembly.
- Refer to page 10-8 for crankcase bolt location.

Procedure		Q'ty	Remarks
(1)	Upper crankcase	1	CAUTION • Do not apply sealant around the oil passage area and main bearing journal area. Refer to the illustration on page 10-8 for applying area.
(2)	Dowel pin	3	
(3)	O-ring	1	
(4)	Oil orifice(long)	1	
(5)	O-ring	2	
(6)	Oil orifice(short)	2	
(7)	Lower crankcase	1	CAUTION • Install the oil orifice with the smaller diameter side facing the lower crankcase.
(8)	Lower crankcase bolt(8 mm)/sealing washer	10/10	
(9)	Lower crankcase bolt(10mm)/sealing washer	1/1	From the inside to outside, tighten the bolts in a crisscross pattern in several steps. Install the sealing washer to the bolt indicated by the "Δ" mark. Refer to page 10-8.
(10)	Lower crankcase bolt(6 mm)	14	
(11)	Sealing washer	3	
(12)	Upper crankcase bolt(6 mm)	7	