

## CRANKPIN BEARING

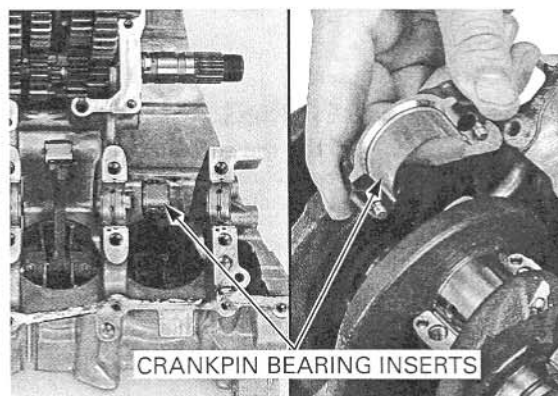
### NOTICE

*Do not interchange the bearing inserts. They must be installed in their original locations or the correct bearing oil clearance may not be obtained, resulting in engine damage.*

Remove the crankshaft (page 13-5).

### BEARING INSPECTION

Check the bearing inserts for unusual wear or peeling.  
Check the bearing tabs for damage.



CRANKPIN BEARING INSERTS

### OIL CLEARANCE INSPECTION

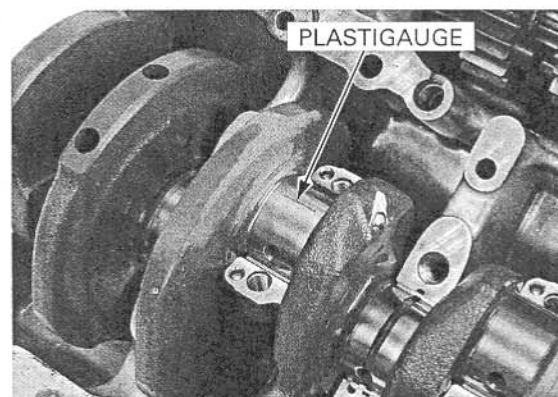
Clean off any oil from the bearing inserts and crankpins.

Carefully install the crankshaft onto the upper crankcase.

Set the connecting rods onto the crankpins.

Put a strip of plastigauge lengthwise on each crankpin avoiding the oil hole.

- Do not rotate the crankshaft during inspection.



PLASTIGAUGE

Carefully install the connecting rod bearing caps, aligning the dowel pins with the holes in the connecting rods.

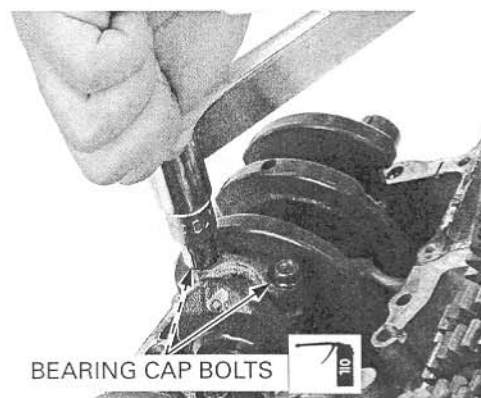
Apply oil to the connecting rod bearing cap bolt threads and seating surfaces and install the bolts. Tighten the bolts in two or three steps alternately.

Further tighten the bolts 90 degrees.

**TORQUE: 14 N·m (1.4 kgf·m, 10 lbf·ft) + 90°**

*Use the removed connecting rod bolts when checking the oil clearance.*

Further tighten the bolts 90 degrees.



BEARING CAP BOLTS