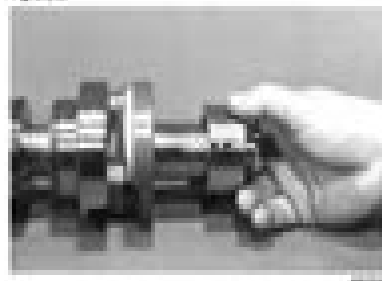


Fig. 1-150



1. The PTO-side bearing may be removed easily by sliding the bearing off the PTO end.

Fig. 1-151



3. Inspect the crankshaft bearing area for wear. If any wear is noted on either end, replace the crankshaft end.

INSTALLING OUTER CRANKSHAFT BEARINGS

NOTE: Steps 1-3 are for installing the MAG-side bearing.

1. Wrap a thick towel around the crankshaft, then secure the crankshaft vertically on a vise.
2. Coat the bearing surface by placing the outer bearing in a pan of oil or by squirting oil onto the bearing and using a prepared brush to have the inner coat of the bearing seal a slight overlap in axial coating from the bearing.

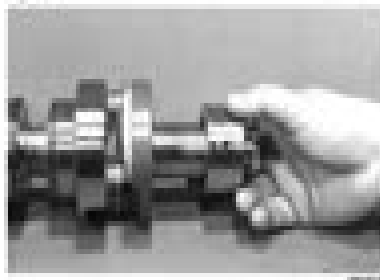
CAUTION

DO NOT overheat the bearing.

3. Place any shims removed during disassembly onto the crankshaft, then slide the bearing into the crankshaft making sure the dovetail hole in the outer race is properly positioned and will align with its hole and pin in the crankcase.

4. Slide the PTO-side bearing onto the PTO end and making sure the dovetail hole will align with the hole and pin in the crankcase.

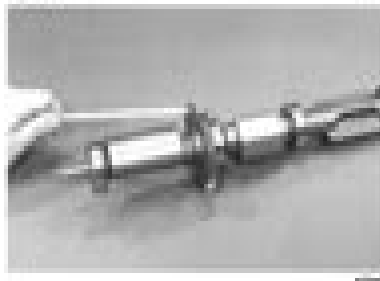
Fig. 1-152



BALANCER SHAFT (800/1000 cc Triplex)

1. Inspect the balancer shaft bearings by turning them by hand. The bearings should rotate freely without binding or feeling rough. If either condition exists, replace the bearing. Inspect the balancer pins very closely for any chipped teeth or signs of wear. If either condition exists, replace the pin.

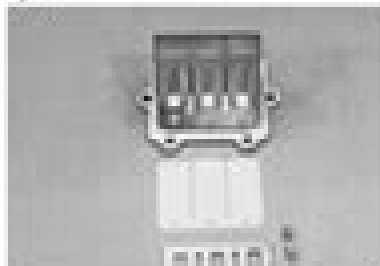
Fig. 1-153



VALVE ASSEMBLY

1. Inspect the valve stems, shippers, and valve blocks for cracks or any deterioration.

Fig. 1-154



2. Wash the valve stems, shippers, and valve assembly in parts-cleaning solvent and blow dry.

3. Inspect the valve shipper height. Using a caliper, measure the distance from the seat to the bottom outer tip-edge of the shipper. Measurement must not exceed specifications. If measurement is not within specifications, either bend or replace the valve shipper.

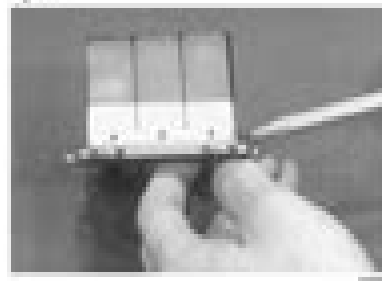
Fig. 1-155



4. Inspect the seat-to-seat clearance. Using a feeler gauge, measure the clearance. Clearance must be less than 0.20 mm (0.008 in.). If clearance is not within specifications, replace the valve stems.

5. To assemble, place the valve stems on the caps with its tapered ends protruding to the lower right hand corner of the caps. Place the valve shippers assembly over pistons and secure with the three screws coated with seal Lubricant 1271.

Fig. 1-156



Measuring Critical Components

NOTE: Critical engine component specifications are on page 54 of this section.

CYLINDER TRUENESS

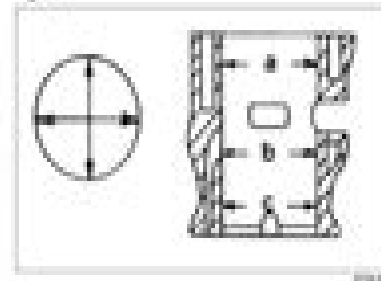
1. Measure each cylinder at the three locations from front-to-back and side-to-side for a total of six readings.

Fig. 1-157



2. The maximum run-out (run-in) is the difference between the highest and lowest readings. Maximum maximum (total-of-run-in) must not exceed specification.

Fig. 1-158



CYLINDER TRUENESS LIMIT (mm)

mm	in.
0.10	0.004

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Padhraic Smyth

A red circular graphic with a gradient, appearing as a stylized arrow or a partial circle, located to the right of the author's name.

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