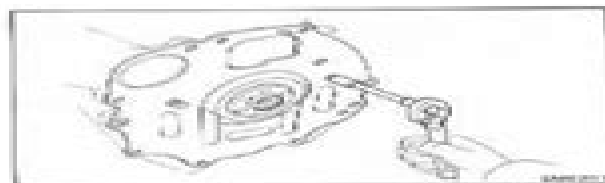
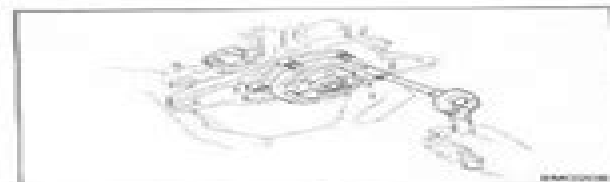
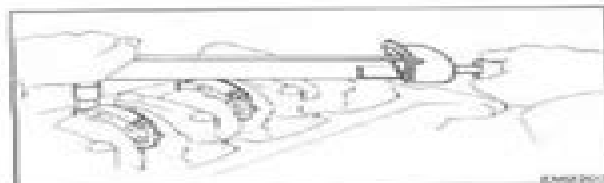


**EM-68****ENGINE MECHANICAL — Cylinder Block**

- (c) Apply a light coat of the engine oil on the threads and under the rod nuts.
- (d) Install and tighten the rod nuts alternately in two or three passes.
Torque: 600 kg-cm (43 ft-lb, 59 N-m)
- (e) Check that the crankshaft turns smoothly.
- (f) Check the rod thrust clearance.
(See page EM-51)

ASSEMBLY OF CYLINDER BLOCK

(See page EM-50)

1. **INSTALL REAR OIL SEAL RETAINER**
Install a new gasket and the retainer with the four bolts.
Torque the bolts.
Torque: 130 kg-cm (9 ft-lb, 13 N-m)
2. **INSTALL OIL PUMP**
(See steps 2 to 7 on pages LU-6, 7)
3. **INSTALL CYLINDER HEAD**
(See steps 1 to 3, 6, 10 to 14 and 16 on pages EM-46 to 49)
4. **REMOVE ENGINE STAND**
5. **INSTALL REAR END PLATE**
Install a dust seal and the end plate with the two bolts.
Torque the bolts.
Torque: 120 kg-cm (9 ft-lb, 12 N-m)
6. **INSTALL FLYWHEEL OR DRIVE PLATE**
Torque: 1,250 kg-cm (90 ft-lb, 123 N-m)

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