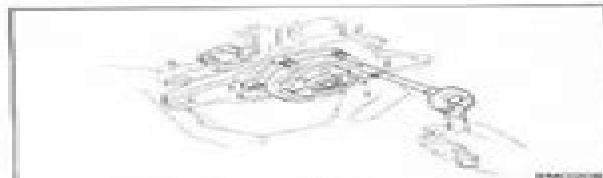
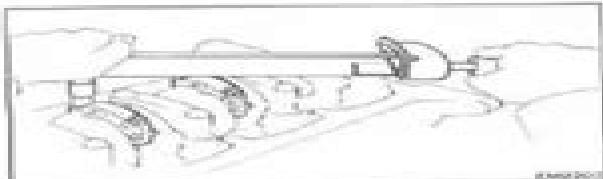




EM-68

**ENGINE MECHANICAL — Cylinder Block**

- (a) Apply a light coat of the engine oil on the threads and under the rod nuts.

- (b) Install and tighten the rod nuts alternately in two or three passes.

Torque: 600 kg-cm (43 ft-lb, 59 N-m)

- (c) Check that the crankshaft turns smoothly.

- (d) Check the rod thrust clearance.  
(See page EM-51)

**ASSEMBLY OF CYLINDER BLOCK**

(See page EM-60)

**1. INSTALL REAR OIL SEAL RETAINER**

Install a new gasket and the retainer with the four bolts.  
Torque the bolts.

Torque: 120 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, 8, 10 to 14 and 16 on pages EM-46 to 49)

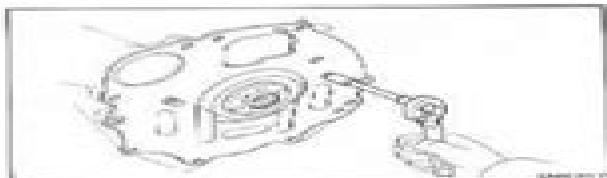
**4. REMOVE ENGINE STAND****5. INSTALL REAR END PLATE**

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)



# Pdf 2lt Surf Workshop Manual

**Noel Jamieson**

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