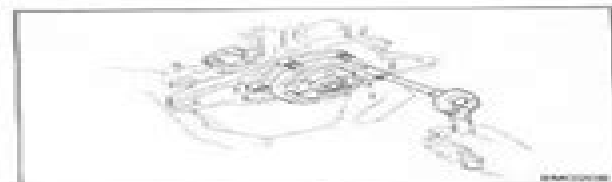
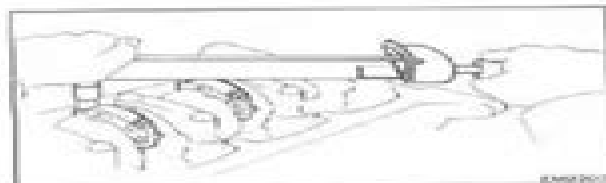


**EM-68****ENGINE MECHANICAL — Cylinder Block**

(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.

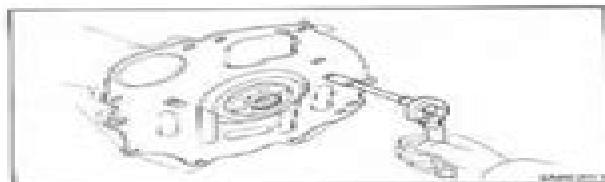
Torque: 130 kg-cm (9 ft-lb, 13 N-m)

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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Padhraic Smyth



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