CAUTION

- **Do not apply sealant to the area near the main bearings.**
- **Install the oil orifice with the larger inner diameter side facing the upper crankcase.**
- **If the lower crankcase installation is difficult, make sure the transmission assembly is installed correctly.**

NOTE

- Refer to page 11-18 for crankcase bolt location.

Requisite Service

- Oil pump installation (page 4-3)
- Starter motor installation (page 17-7)
- Alternator installation (page 15-7)
- Clutch installation (page 9-4)
- Gearshift linkage installation (page 10-2)
- Cylinder head/camshaft idle gear case installation (page 8-4)
- Engine installation (page 7-2)

	Procedure	Q'ty	Remarks
	Lower Case Side		
(1)	O-ring	1	
(2)	Oil orifice	1	Install it as illustrated.
(3)	Dowel pin	3	
(4)	Lower crankcase	1	After installation, make sure shift forks engage properly with the corresponding gears.
(5)	9mm bolt	8	Tighten in a gradual, crisscross pattern. Apply engine oil to the threads and seating surface.
(6)	8mm bolt	1	
(7)	6mm bolt	8	Tighten in a gradual, crisscross pattern.
	Upper Case Side		
(8)	Sealing washer	2	
(9)	10mm bolt	2	Tighten gradually.
(10)	6mm bolt	7	
(11)	Mainshaft bearing stopper plate	1	Apply a locking agent to the threads of the attaching bolts.