



# CYLINDER AND CRANKCASE ASSEMBLY

PART NO. 95-7630  
PART NO. 95-7632

INSTALLATION  
INSTRUCTIONS

## Sealing Crankcase

1. Apply a 1/8 inch (3.5 mm) bead of sealer (Part No. 610372) to crankcase cover (Fig. 1).

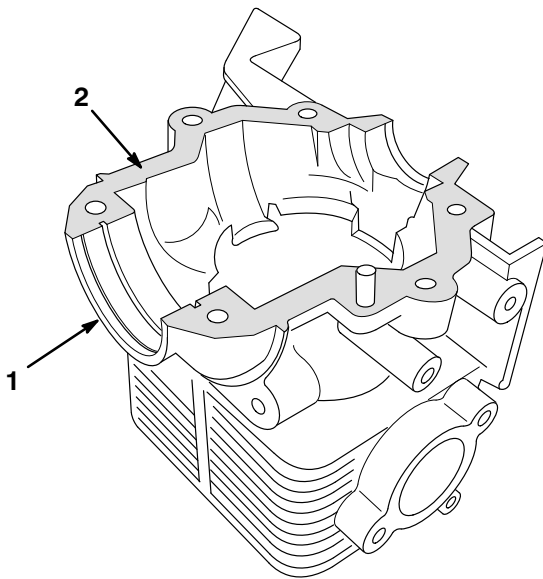
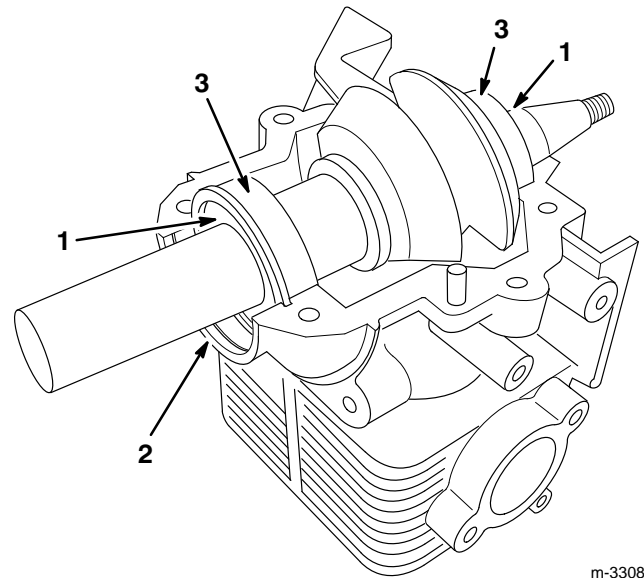


Figure 1

1. Crankcase cover
2. Add a 1/8 inch bead of sealer to this edge

2. Using your finger, carefully spread sealer evenly over crankcase cover half.

**Note:** Do not allow sealer to contact crankshaft journals, seals or bearings (Fig. 2). Serious engine damage may result.



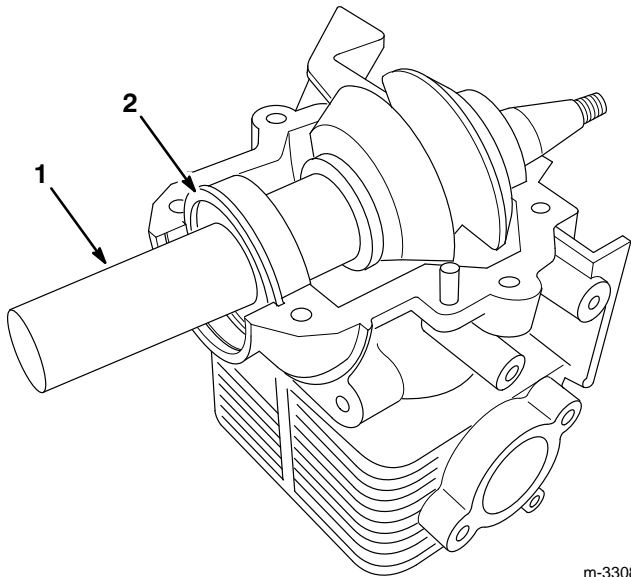
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Figure 2

1. Seal
2. Journal
3. Bearing

## Assembling Crankcase

1. Insert crankshaft and piston into cylinder. Make sure lower bearing retainer is seated in its groove (Fig. 3).

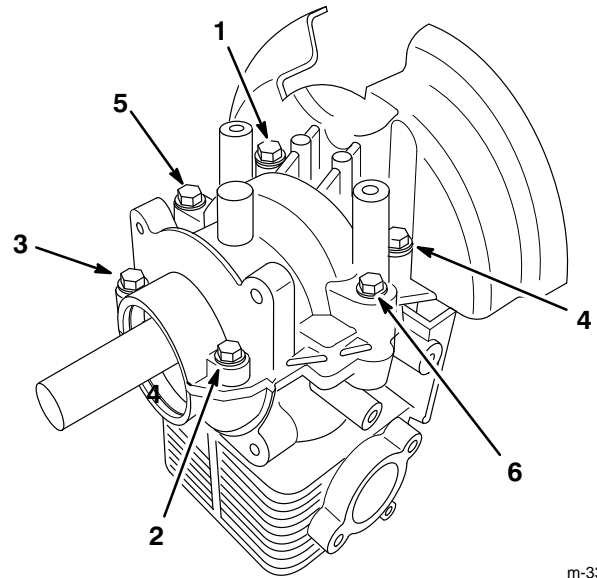


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**Figure 3**

1. Crankshaft and piston
2. Lower bearing retainer in groove

First torque to 30 in.-lbs. (3.4 N•m)  
 Re-torque to 45 in.-lbs. (5 N•m)  
 Final torque to 55-90 in.-lbs. (6.2-10.2 N•m)



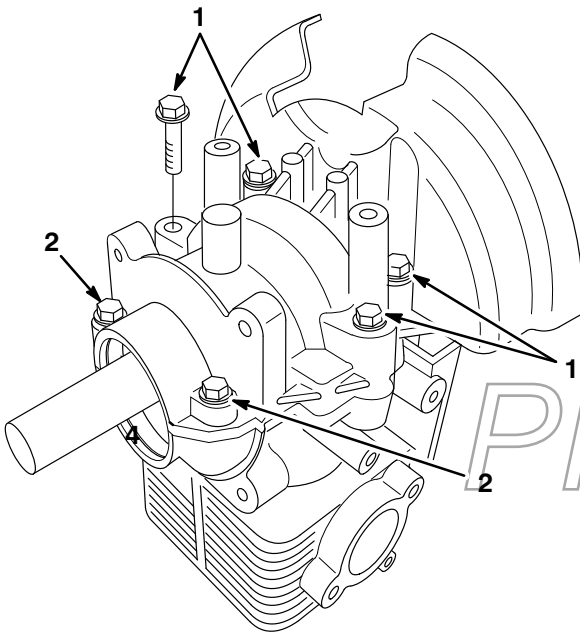
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**Figure 5**

2. Assemble crankcase cover to cylinder half and secure with six screws (Fig. 4).

**Note:** Use the two supplied short screws in lower crankcase holes (Fig. 4).

4. Install seals using protector and seal driver (Fig. 6).

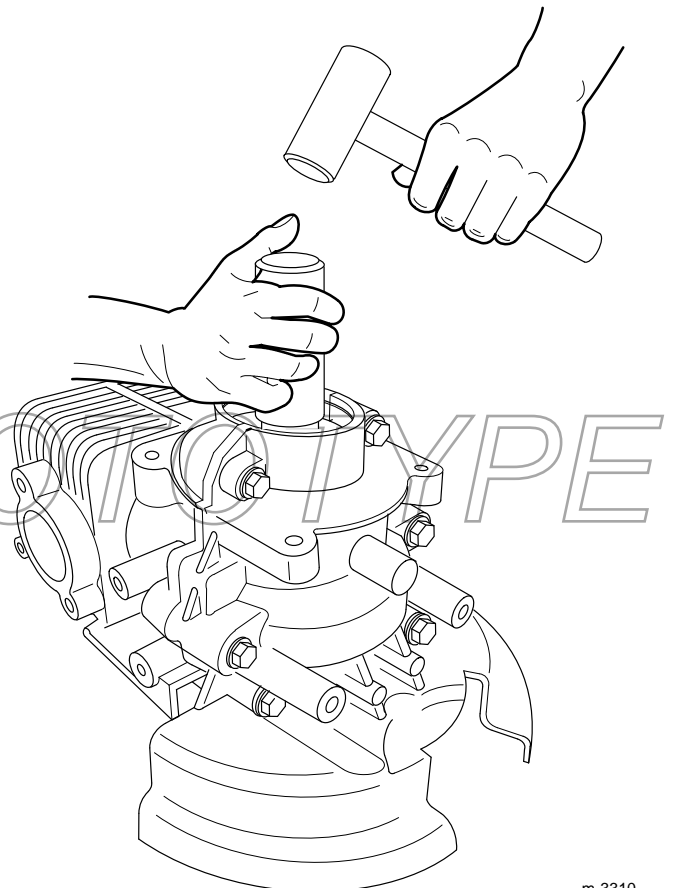


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**Figure 4**

1. Screw
2. Short screw

3. To prevent damage or distortion to crankcase cover, torque bolts in sequence (1-6) as shown in Figure 5 and steps as follows:



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**Figure 6**