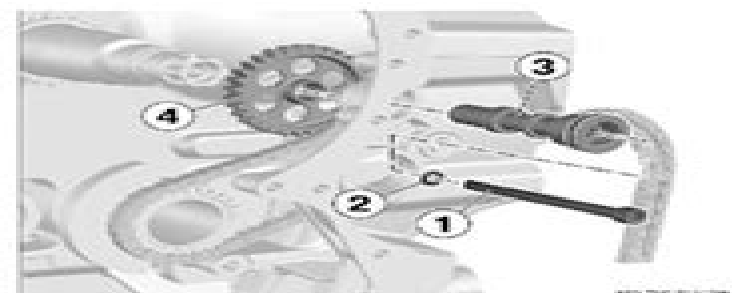


- Clean the threads.
- Install starter double gear (1).
- Check the O-ring (arrow) for damage; replace if necessary.
- Install axle (2).
- Install bolt (3) with sealing washer (4).

Tightening torques		
Shaft for starter double gear to crankcase		
M6 x 80, Replace screw	8 Nm	
Thread-locking compound (micro-encapsulated)		

(-) Installing starter idler gear

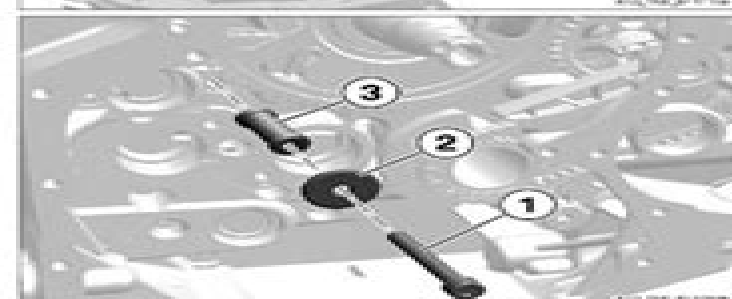
- Install starter idler gear (4).
- Check the O-ring for damage; replace if necessary.
- Install axle (3).
- Install bolt (1) and sealing washer (2).



Tightening torques		
Shaft for starter idler gear to crankcase		
Left-hand thread, M20 x 1,5	18 Nm	
M6 x 80, Replace screw	8 Nm	
Thread-locking compound (micro-encapsulated)		

(-) Installing gearwheel, starter freewheel

- Lubricate the friction face (arrow) of the gearwheel with engine oil.
- Install gear (1) on crankshaft (2).



- Clean the threads.
- Install bolt (1) with contact disc (2) and sleeve (3).

Tightening torques		
Sleeve (axial stop, freewheel gear) to crankcase		
M6 x 50, for re-use	10 Nm	
Thread-locking compound (Loctite 243, Medium strength)		

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Tao Wei



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