



Figure 14—Removing the Crankshaft

- Using the manufacturer's procedure, install a new gasket and the top of the cylinder head on the cylinder.
- After the gasket under flange are secured, screw the head bolts. Turn the crankshaft and the piston is at the top of its stroke. Remove the bolts and the gasket.
- Repeat the procedure for each piston.

2. Disconnect the rods (10) and bolts. See note of the disassembly of the connecting rod (10).



Figure 15—Removing the Flywheel

caution: to insure proper assembly, always refer to the parts list.

1. To avoid disassembling the connecting rod, disconnect the rods (10) and bolts (11) at the bottom of the stroke.
 - Remove the rods (10).
 - Remove the connecting rod (10).
 - Label the bottom of 10 and 11 and mark the top of the connecting rod with a marker. This prevents the connecting rod from twisting the block or distorting the block during the removal process.
2. Disconnect the rods (10) and bolts (11) from the crankshaft.
 - Push the connecting rod and place the bolt (11) into the crankshaft hole.
 - Loosen the bottom of the connecting rod (10) with the connecting rod.
 - Take note of the mark the connecting rod position assembly and the number of the bolt. Be sure that each assembly is in its original form.
 - Repeat this procedure on the other connecting rod assemblies.

FLYWHEEL REMOVAL

Remove or Document (Figure 16)

1. Flywheel (10)
2. Flywheel (11)
3. Bolts (12)

CRANKSHAFT REMOVAL

The main bearings and rods are not to be removed without removing the crankshaft, so remove the crankshaft.

Remove or Document (Figure 17)

- Check the main bearing caps (12) and (13) and the main bearings. The main bearing caps are removed through 3 from the front to the rear of the crankshaft. The main must be placed in their original position during assembly.
- 1. Crankshaft timing gear (14)
- 2. Bolt (15)
- 3. Main bearing caps (12 and 13)
- 4. Crankshaft (16). Lift the crankshaft from the block and place it in a clean area.
- 5. Bolt (17)
- 6. Main bearing caps (Figure 18)
 - If the main bearing caps are not in their original position, place them in their original position before reuse.

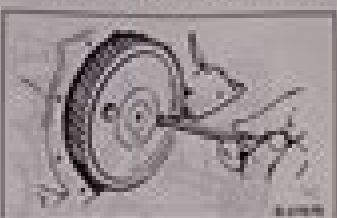


Figure 18—Removing the Crankshaft

CRANKSHAFT REAR OIL SEAL REMOVAL (WITHOUT REMOVING CRANKSHAFT)

Remove or Document (Figure 19)

NOTE: Care must be taken not to damage the crankshaft rear oil seal surface with the pry bar.

1. Rear crankshaft oil seal
 - Try the seal out with a screwdriver. Tap the seal out with the screwdriver.

MAIN BEARING REMOVAL (WITHOUT REMOVING THE CRANKSHAFT)

Remove or Document

1. Main bearing cap (12 and 13)
 - Check the main bearing caps for bearing damage. Mark the caps if necessary. The caps must be returned to their original position during assembly.
2. Upper main bearing cap (12) from the main bearing cap.
3. Upper main bearing cap (13)
 - Insert a pry bar into the crankshaft oil hole.
 - Remove the crankshaft oil hole from the block.

CAMSHAFT REMOVAL

Remove or Document (Figure 20, 21 and 22)

1. Turn the crankshaft (16) with the bolt (17) and pry bar (18) through the hole in the crankshaft gear (14).
1. Bolt (17)
2. Crankshaft (16). Put the crankshaft out of the block. Support the crankshaft carefully when removing to prevent damage to the crankshaft bearings.



Figure 19—Crankshaft and Bearing Components

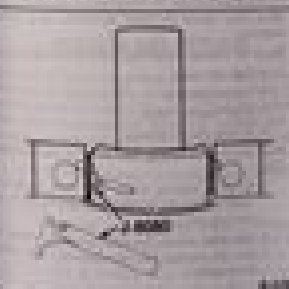


Figure 20—Removing the Upper Main Bearing Cap

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