(8)

#### To Install Crankcase Cover or Sump -All Aluminum Model Series

Use seal protector from Tool #19334 or #19356, Table No. 56, to protect oil seal when installing crankcase cover or sump. DO NOT FORCE COVER OR SUMP. Make sure mechanical governor gear is engaged with cam dear.

#### Table No. 56 SEAL PROTECTORS

TOOL #	COLOR	CRANKSHAFT JOURNAL SIZE
1 SPSKSHI/11	White	_267
19304/2	Flect	.160%
19304/3	Elino	.984
NSGGM/H	Orange -	1.000
19904/5	Brown	1.062
19334/6	Green	1.181
1,900H/Y	Middlewer	1.079

#### To Correct Warped Magneto Plates

The magneto plate sometimes becomes warped and allows oil to leak at the mounting face. Mount the magneto in lathe as shown in Fig. 892 and turn the mounting face flat BEFORE correcting end play. This should be done whenever possible.

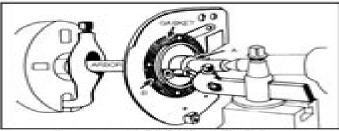


Fig. 892 - CORRECTING END PLAY

#### Torque Crankcase Cover or Sump - All Aluminum Model Series

Torque crankcase cover or sump to specifications listed in Table No. 57.

#### Table No. 57 CRANKCASE COVER OR SUMP TORQUE

MODEL SERIES	TORQUE In. Lbs.
60000, 60000, 90000	05
100200, 100900	120
11/0000	66
190000	120
140000, 170000, 190000; 220000, 250000	140

#### To Check Crankshaft End Play

#### Method #1

End play on all models is .002"-.008" cold. Check after crankshaft is installed. To check end play on an engine with magneto assembled but base removed, push crankshaft toward drive side and insert feeler gauge between thrust face of magneto and crankshaft as shown in Fig. 893.

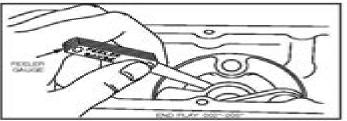


Fig. 893 – CHECKING CRANKSHAFT END PLAY

#### Crankshaft End Play - All Model Series

Crankshaft end play is .002"-.008" on all models except Model Series 92500, 92900 with code numbers having '5' as the next to last digit (example, 88042151). Procedures for adjusting end play vary between cast iron cylinders, aluminum cylinders, plain and ball bearing models.

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**Clemens Wendtner** 

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