Apply Polaris PS-4 engine oil to each main and rod bearing journal of crankshaft ©6®.



- Loop cam chain ® and oil pump drive chain ® over crankshaft sprockets.
- Apply Polaris PS-4 engine oil to the new crankshaft oil seal © and install the seal on the PTO end of the orankshaft.



 Carefully lower the crankshaft into upper crankcase. Guide connecting rods onto the rod journals of orankshaft as necessary.



- Adjust the PTO crankshaft seal so it rests properly in the upper crankcase.
- Clean bolt hole threads in connecting rod to remove all oil.
- Install matching rod cap on connecting rod using markings made upon disassembly.
- 13. Install new bolts and tighten evenly until snug.



14. Torque connecting rod bolts to specification ®.

TORQUE

Connecting Rod Boits Step 1: 9 ft-lb (12 Nm)Step 2: 22 ft-lb (30 Nm)Step 3: Tighten add'n 90"

BALANCE SHAFT INSTALLATION

- Clean the upper crankcase balance shaft bearing bore surfaces.
- Align tab of new balance shaft bearings ® with the slot in each bearing bore of crankcase. Press bearing insert firmly into place.



Rotate the crankshaft until the alignment dot on the crankshaft MAG end gear is visible.

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Alan Ahlstrand, John Harold Haynes

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