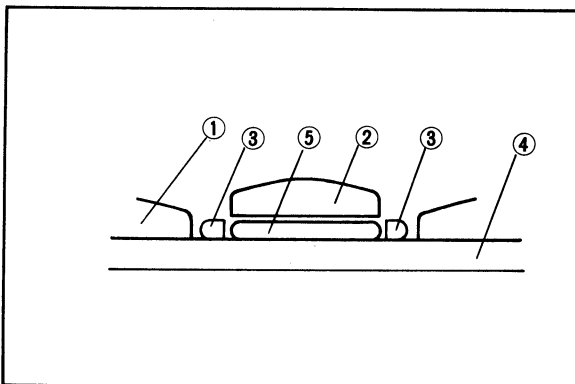


- Place washers on both sides of the small end, insert the piston pin into the small end so that the jig is pushed out, then push the pin into the opposite side piston pin hole.

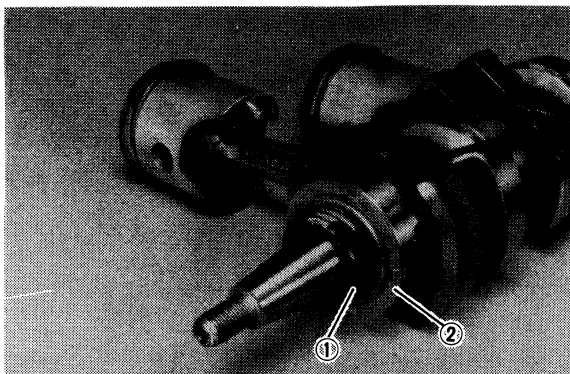


- | | | |
|---------------|-------------------|-----------|
| 1. Piston | 2. Con-rod | 3. Washer |
| 4. Piston pin | 5. Needle bearing | |

- Connect the lower cylinder connecting rod to the piston pin.
- Install the spacer and oil seal on the upper part of the crankshaft.

NOTE: _____

- Before installing the oil seal, grease the lip.
- Make sure the oil seal faces in the correct direction.



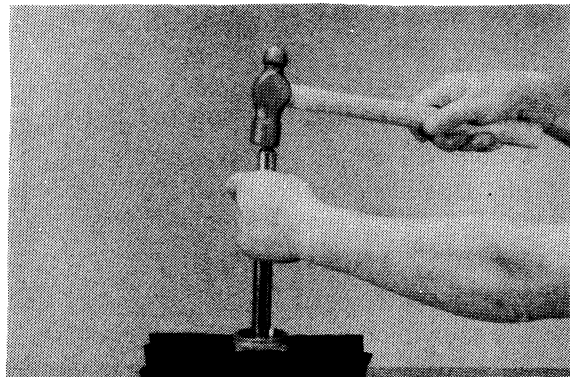
- | | |
|-------------|-----------|
| 1. Oil seal | 2. Spacer |
|-------------|-----------|

Oil seal housing

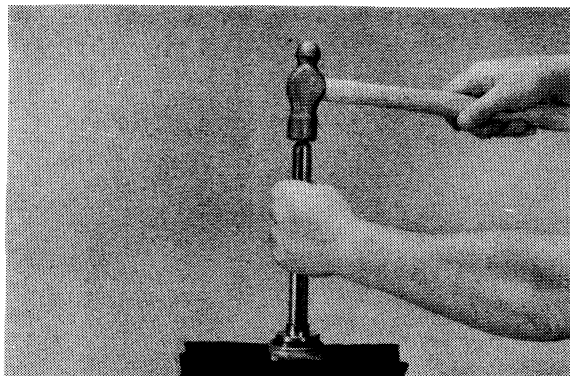
NOTE: _____

When press-fitting the oil seal, be sure that it faces in the correct direction.

- Using the jig, press-fit the two oil seals (smaller in outside diameter) one by one.



- Using the jig, press-fit the oil seal (larger in outside diameter).



- After installing the oil seals, pack the lips with Yamaha all-purpose grease, P/N LUB-GREAS-13-00.
- Fit new O-ring in the grooves in their outer surfaces.