

Table 44 Connecting Rod Journal Diameter

Marking	Diameter	Service Limit
No mark	37.984~37.994 mm	37.97 mm
1	37.995~38.000 mm	

- Put the connecting rod big end caps on the rods and tighten the nuts with the specified torque (Pg. 201). Measure the inside diameter, and mark each connecting rod big end in accordance with the inside diameter (Table 45).

**NOTE:** The mark already on the big end should almost coincide with the measurement.

Table 45 Connecting Rod Big End Inside Diameter

Marking	Diameter
No mark	41.000~41.010 mm
1	41.011~41.020 mm

- Select the proper bearing insert in accordance with the combination of the connecting rod and crankshaft coding.

Table 46 Bearing Insert Selection

Con-Rod marking Crankshaft marking	1	Unmarked
1	Black PN 13034-043	Brown PN 13034-046
Unmarked	Blue PN 13034-045	Black PN 13034-043

Table 47 Bearing Insert Thickness

Blue	1.485~1.490 mm
Black	1.480~1.485 mm
Brown	1.475~1.480 mm

#### Connecting rod side clearance

Measure the side clearance of the connecting rod with a thickness gauge as shown. Replace the crankshaft and the connecting rod if the clearance exceeds the service limit.



Table 48 Connecting Rod Big End Side Clearance

Standard	Service Limit
0.15~0.25 mm	0.45 mm

#### Crankshaft runout

Set the crankshaft in a flywheel alignment jig or on V blocks, and place a dial gauge against the points indicated. Turn the crankshaft slowly. The maximum difference in gauge readings is the crankshaft runout. If the runout exceeds the service limit, replace the crankshaft.

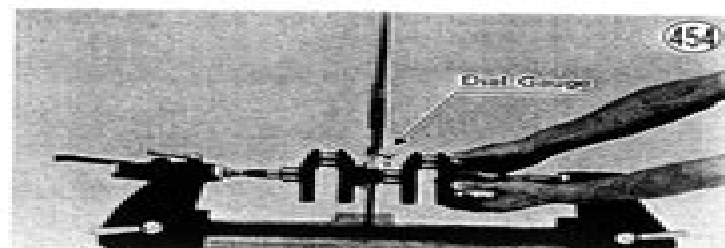


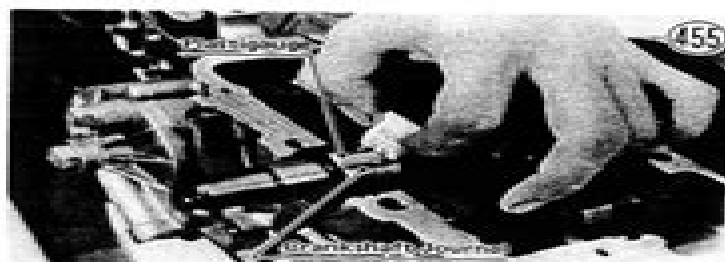
Table 49 Crankshaft Runout

Standard	Service Limit
under 0.02 mm	0.05 mm

#### Crankshaft bearing insert/journal wear

Remove the crankshaft. Cut strips of plastigauge to bearing insert width. Place a strip on each bearing insert parallel to the crankshaft so the plastigauge will be compressed between the insert and the crankshaft journal. Install the crankshaft and the lower crankcase half without turning the crankshaft, and tighten the bolts in the correct sequence with the specified amount of torque (Pg. 67).

Remove the crankshaft (making sure that the crankshaft does not turn at any time), and measure the plastigauge width to determine the bearing insert/journal wear. If either clearance exceeds the service limit, replace all six bearing inserts, and check the crankshaft journals.



# P3history Owners Manual Diagrams Stripping Guide

**CO Houle**



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