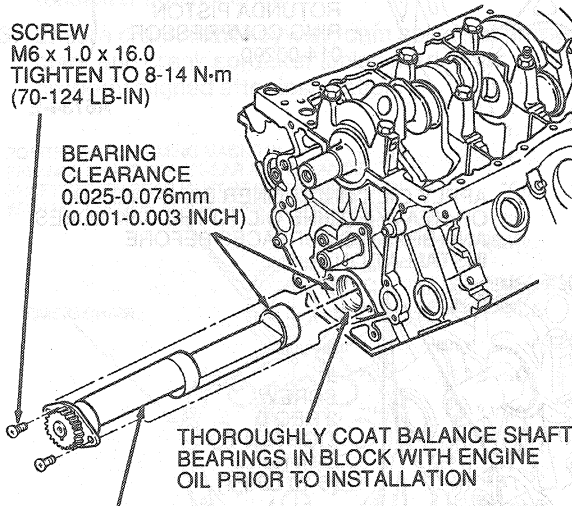


DISASSEMBLY AND ASSEMBLY (Continued)

24. Remove camshaft. Use care to prevent damage to camshaft bearing surfaces.
 25. If necessary, remove camshaft plug from back of engine.
 26. Remove screws securing balance shaft thrust plate.
- CAUTION: Use care to prevent damage to bearing surface.**
27. Remove balance shaft gear, thrust plate and shaft assembly.

SCREW
M6 x 1.0 x 16.0
TIGHTEN TO 8-14 N·m
(70-124 LB-IN)

BEARING
CLEARANCE
0.025-0.076mm
(0.001-0.003 INCH)



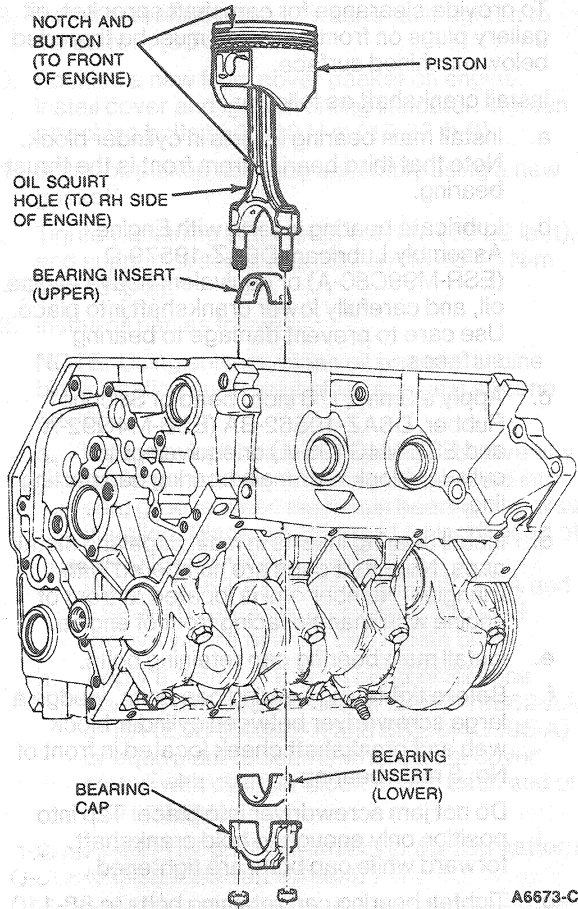
BALANCE SHAFT 6A306
THRUST PLATE 6C341
BALANCE SHAFT GEAR 6A304

A11638-C

CAUTION: Never cut into ring travel area in excess of 0.794mm (0.0325 inch).

NOTE: Before removing pistons, inspect top of cylinder bores. If necessary, remove ridge and / or carbon deposits from each cylinder using Rotunda Cylinder Ridge Reamer 014-00292 or equivalent. Before ridge or deposits are removed, turn crankshaft until piston is at bottom of its stroke. Cover piston with a clean shop towel to collect cuttings. After cutting operation, turn crankshaft until piston is at top of its stroke and remove shop towel with cuttings.

28. Remove connecting rod caps and pistons.



The location of each piston, crank bearing and rod cap should be noted. When engine is assembled each component should be installed in its original position.

29. Remove main bearing caps and crankshaft.

The location of main bearings should be identified. When engine is assembled each bearing should be installed in its original position.

30. For cleaning purposes, oil gallery and cooling jacket plugs can be removed.

Assembly

NOTE: During engine assembly, a RTV-type sealer will be applied to many components before installation. When the sealant is applied, the component should be installed within 15 minutes. After this time the sealant begins to set-up and its sealing effectiveness can be reduced.

NOTE: Lightly oil all retaining bolt and stud bolt threads before installation except those specifying special sealant.

1. If removed, install oil gallery and cooling jacket plugs. Tighten plugs to specification.

Before installation, coat plug threads with Pipe Sealant with Teflon® D8AZ-19554-A (ESG-M4G194-A and ESR-M18P7-A) or equivalent.