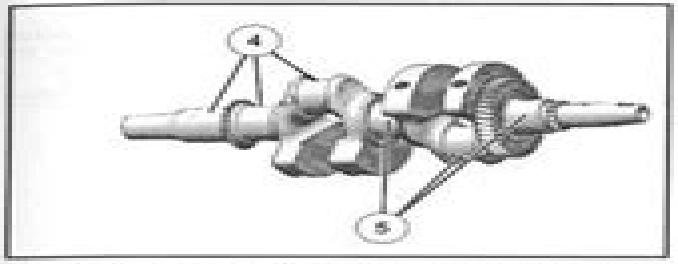
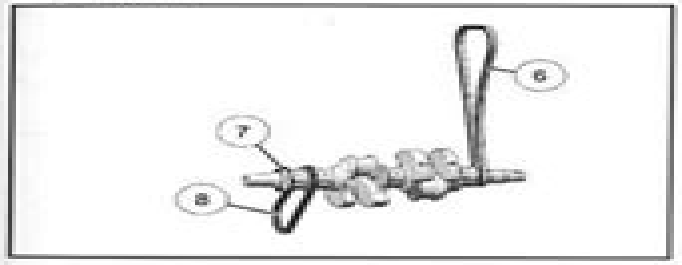
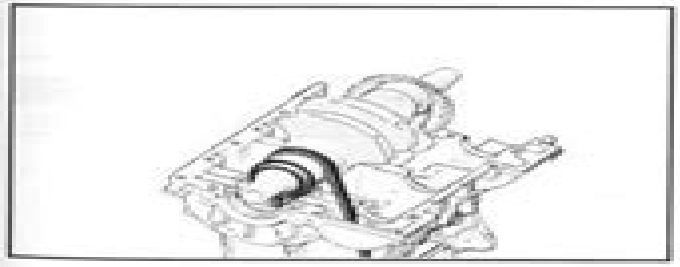
6. Apply Polaris PS-4 engine oil to each main and rod bearing journal of crankshaft ④&⑤.



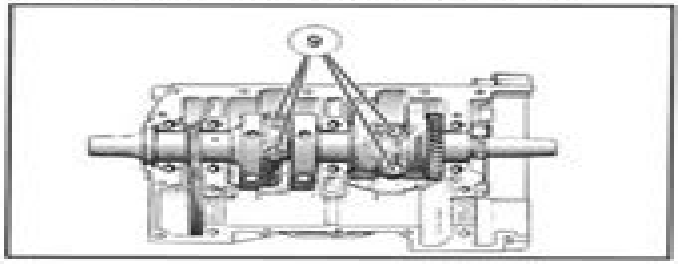
7. Loop cam chain ⑥ and oil pump drive chain ⑧ over crankshaft sprockets.
8. Apply Polaris PS-4 engine oil to the new crankshaft oil seal ⑦ and install the seal on the PTO end of the crankshaft.



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



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

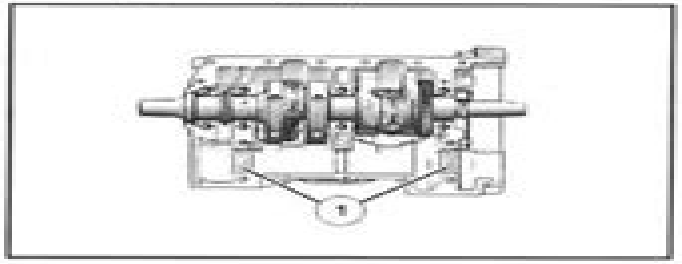


14. Torque connecting rod bolts to specification ⑨.

TORQUE
Connecting Rod Bolts: **Step 1: 9 ft-lb (12 Nm)Step 2: 22 ft-lb (30 Nm)Step 3: Tighten add'n 90°**

BALANCE SHAFT INSTALLATION

1. Clean the upper crankcase balance shaft bearing bore surfaces.
2. Align tab of new balance shaft bearings ① with the slot in each bearing bore of crankcase. Press bearing insert firmly into place.



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

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