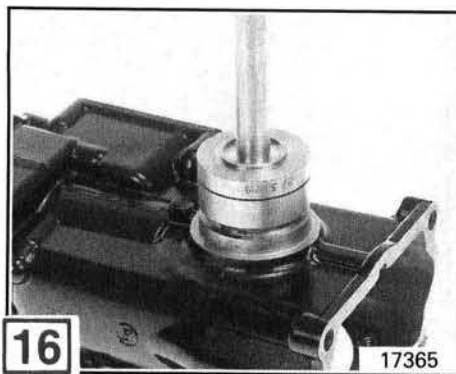


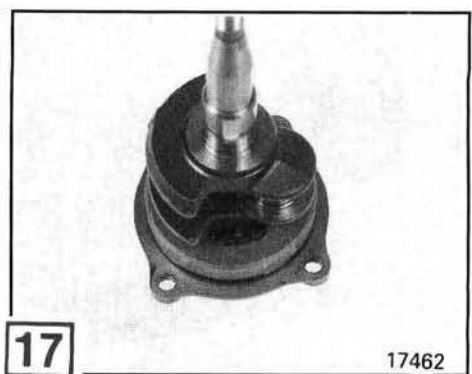
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Assembly

Note Proceed slowly. Make no forced assemblies unless a pressing operation is called for. All internal components must be perfectly clean and lightly coated with *Johnson* or *Evinrude Outboard Lubricant*.

Note Use new gaskets, seals, and O-rings during assembly.

15 1. If removed, install upper main bearing through bottom of crankcase. Press against lettered side of bearing case until bearing is recessed 0.062 in. (1,5 mm) below finish thrust face of crankcase.

16 2. Using OMC Seal Installer P/N 330219, install a new upper seal. Apply *OMC Gasket Sealing Compound* to metal case of seal. Install the seal with lip facing into the crankcase and until the tool is seated. Apply *OMC Triple-Guard* grease to seal lip.

3. If removed, install a new lower main bearing and retaining ring. Thoroughly clean the bottom journal. Place the retaining ring on the crankshaft with sharp edge facing away from the crankshaft. Support the crankshaft between the two counterweights. Lightly coat the bearing journal of the crankshaft with *OMC HT 400*. Place the bearing on the crankshaft with lettered side facing away from the crankshaft. Press the bearing onto the crankshaft until the bearing is seated.

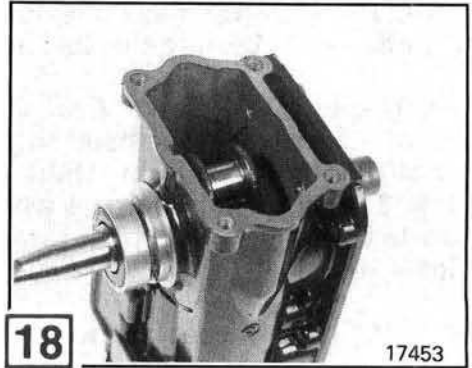
17 4. Oil the lower main bearing. Slide the crankcase head over the bearing. Using OMC Retaining Ring P/N 675032, seat the retaining ring in groove of the crankcase head.

18 5. Oil the crankshaft. Install the crankshaft. Seat the crankcase head.

19 6. Apply *Permatex No. 2* to threads of the crankcase retaining screws. Install and tighten the screws to a torque of 60-84 in. lbs. (7-9 N·m).

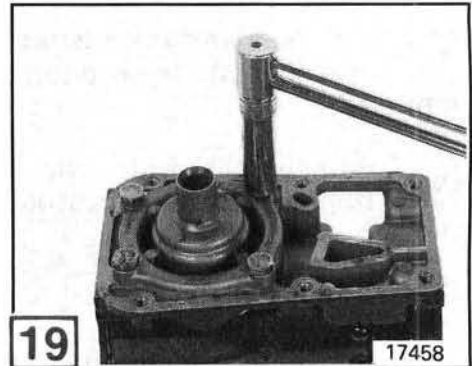
20 7. If removed, replace the needle bearing liners in the connecting rod and cap. Place the liner with hole in the cap. Be sure dovetail ends of liner match when the connecting rod and cap are assembled.

21 **Note** Connecting rod cap cannot be turned end for end. To assist correct assembly, embossments **A** are provided on matching side of rod and cap.



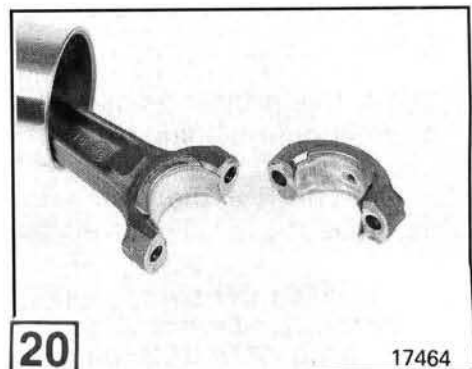
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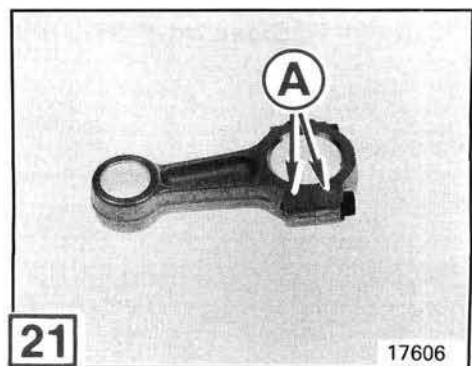
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