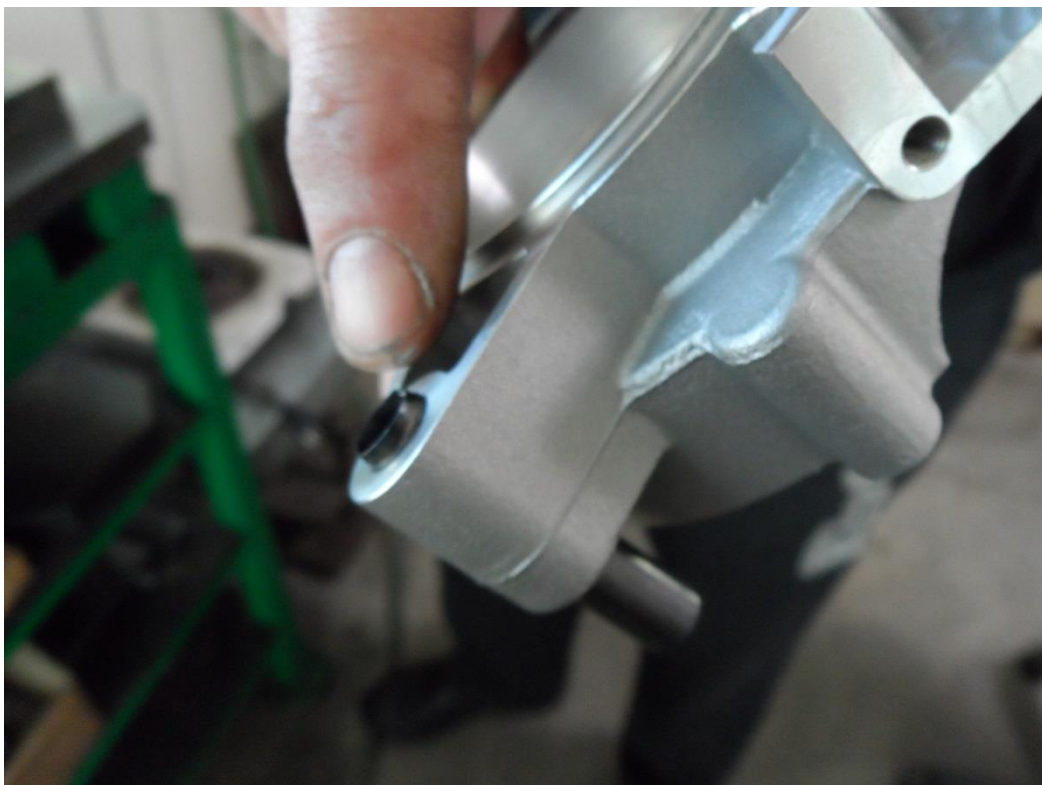


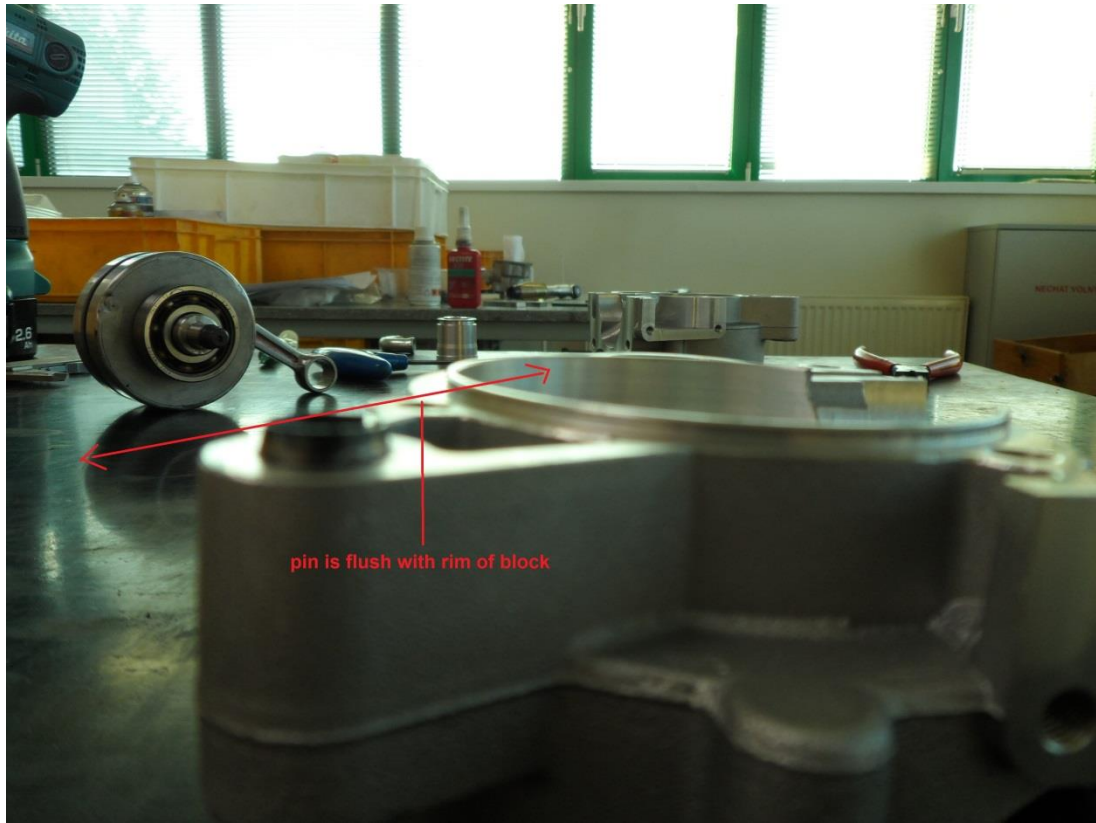
Crank assembly air & water cooled engine

- 1) Firstly press the spring pin (950.050.00) into place on side of the block where the rim is and place for pump (only for water cooled version)

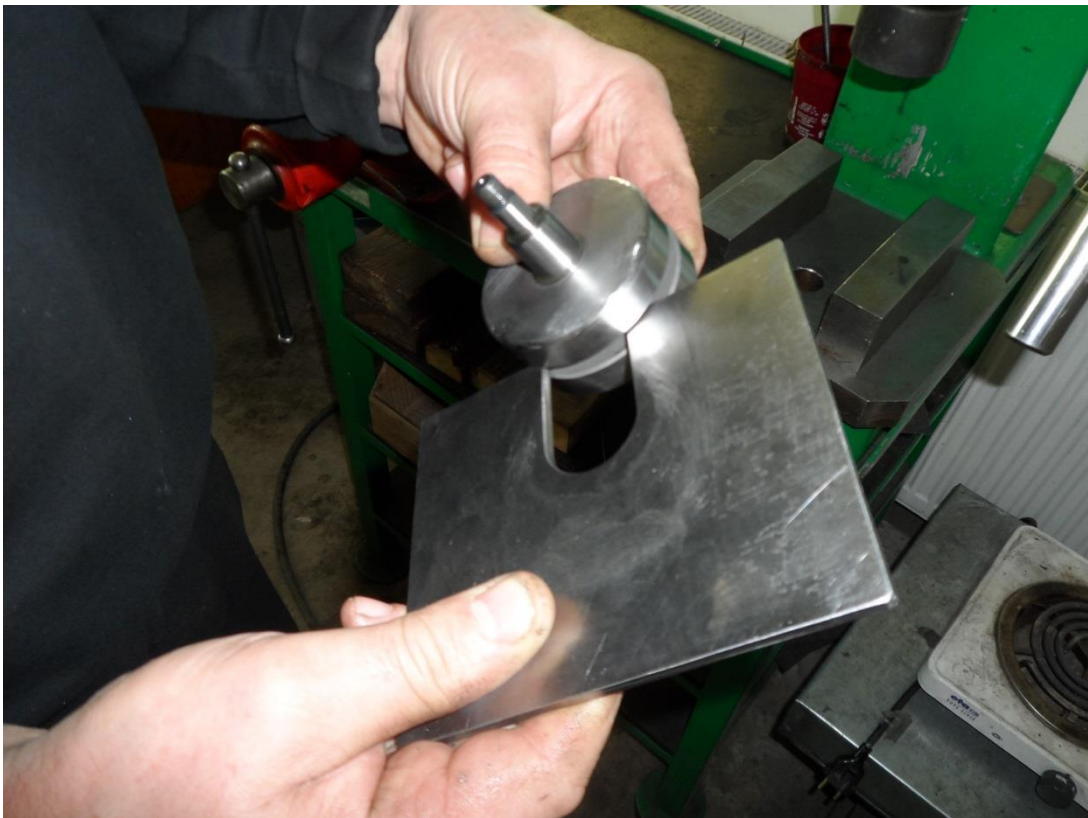


- 2) The pin needs to protrude a bit (approx. 2mm). Best is if it's flush with the rim of the block.





3) Take crank and place tool inside (it's possible to use something homemade)

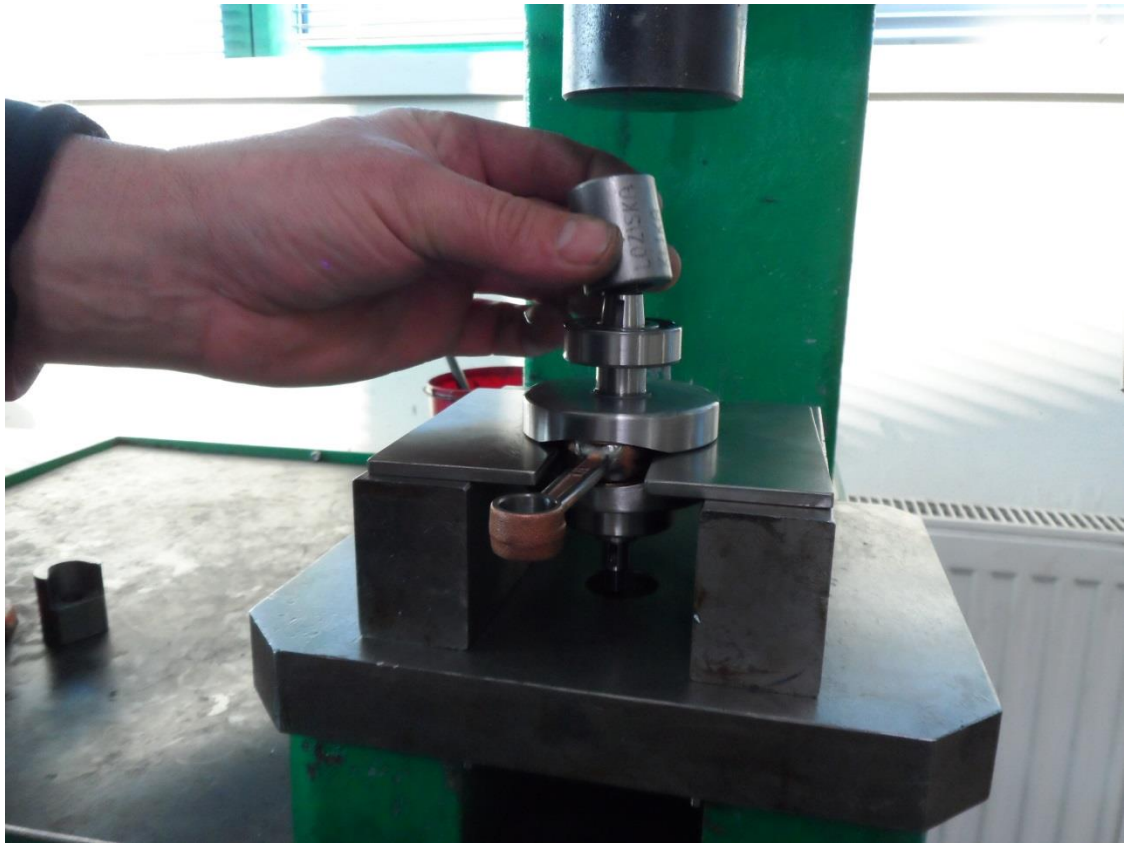


4) Place crank under press



5) Place ball bearing onto crank and place round tool (possible to use socket heads) and press.





6) Prepare both sides of crank

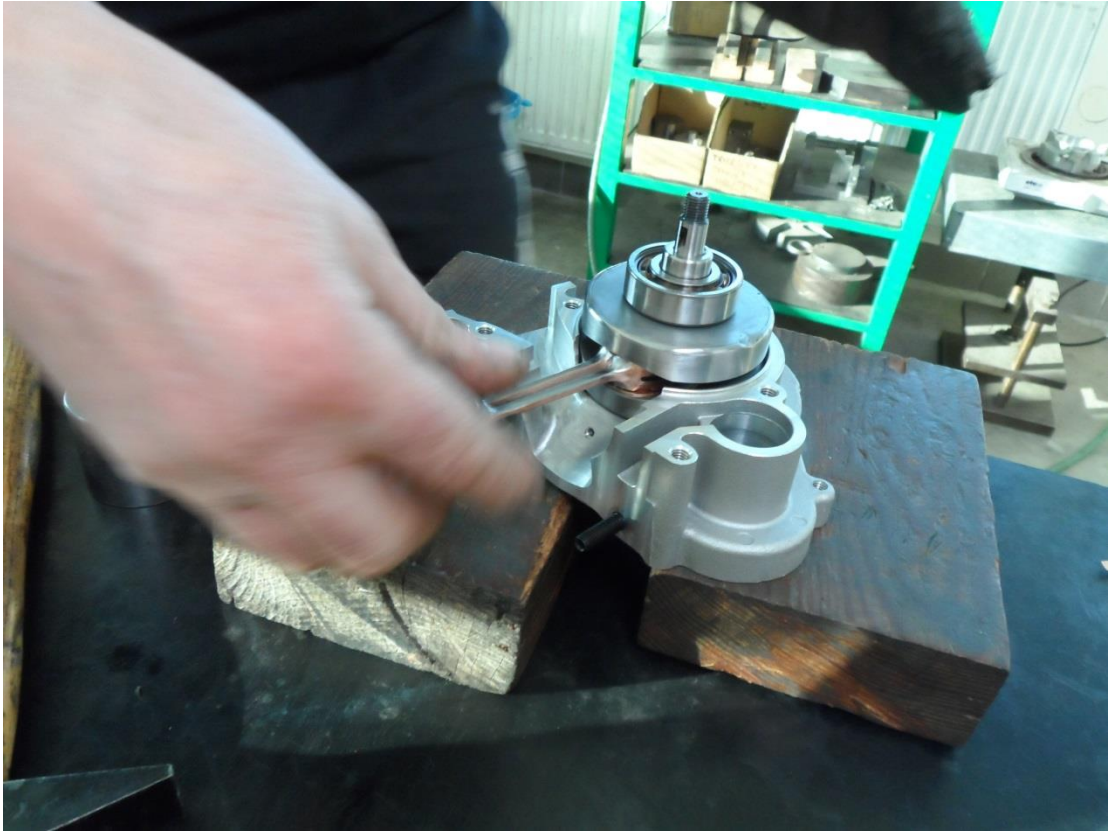


7) Heat the two crank halves.



- 8) When temperature reaches 80°C remove one half and place on wooden blocks and place crank inside





9) Place gasket onto block



10) Check so other half of block has a temperature of 80°C and lower onto prepared first half of the block



11) Press the spring pin through the blocks first



12) Then use bolts and screw in



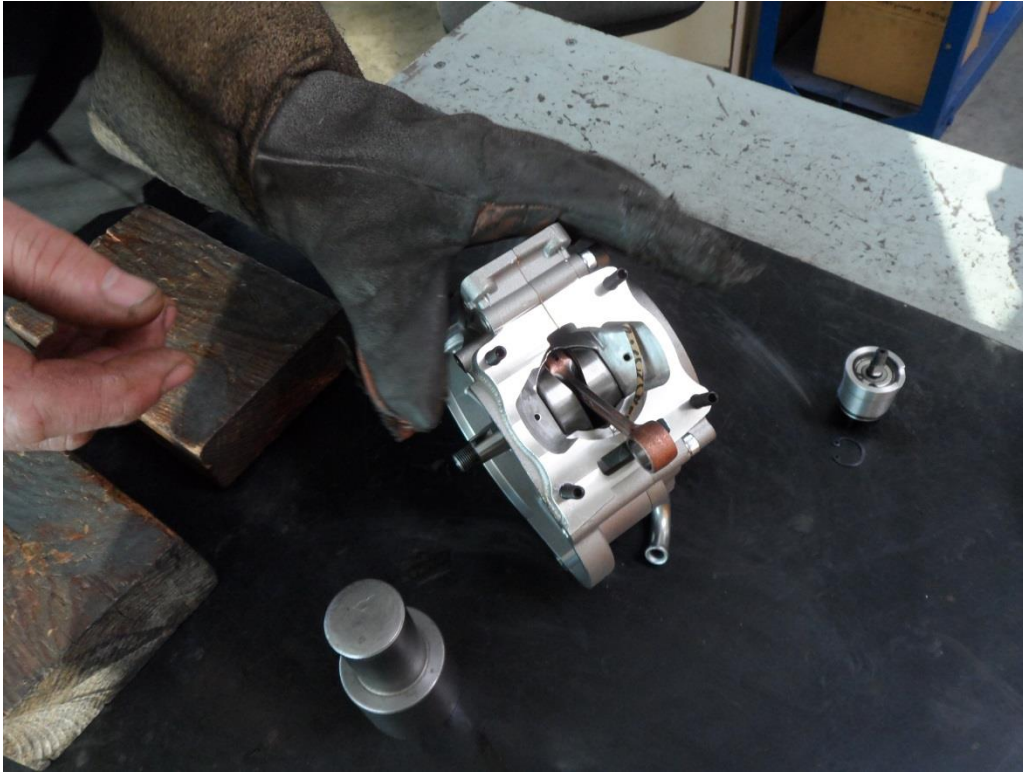
13) Use torque wrench to tighten. Minimum 12 Nm but we use 14 Nm



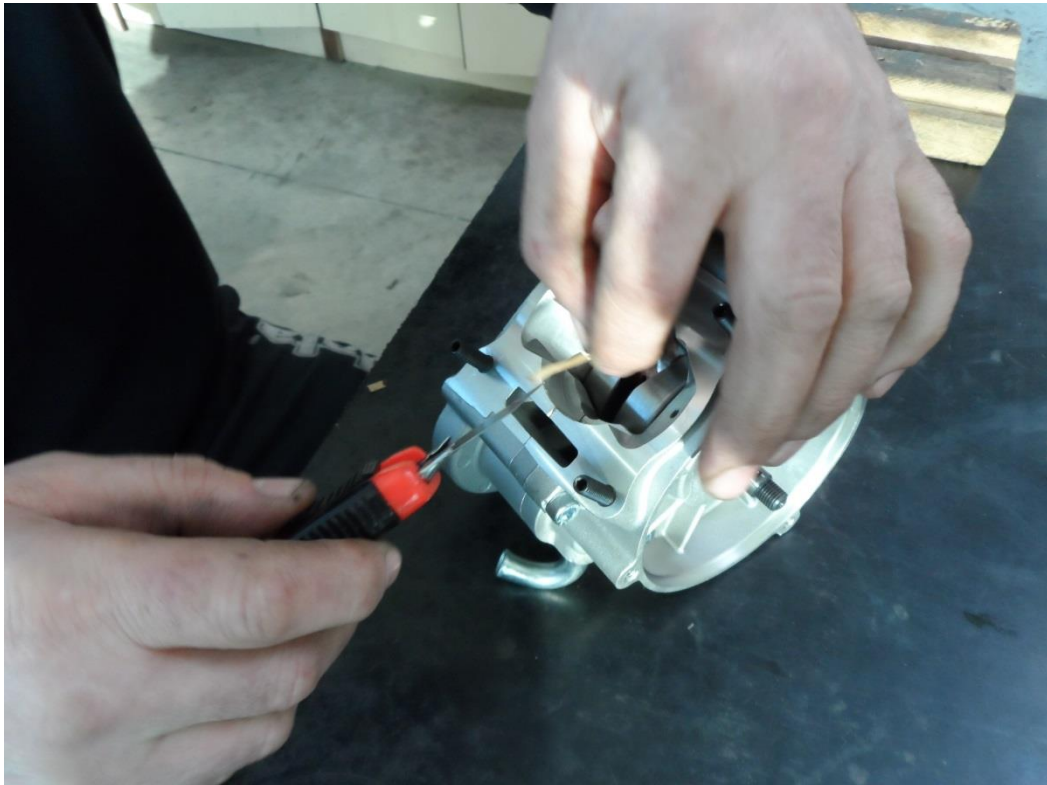
14) Using tool or perhaps a tall socket head, tap with hammer around the crank. You must NOT touch the protruding crank.



15) The crank should move freely within block.



16) Clean crank of off protruding gasket



17) blow of all remaining gasket pieces and dust



18) Add Vaseline inside the Gufero oil lips.





19) Place oil lip onto crank (Vaseline side inwards) and using a socket head and force of hand, push. Repeat on other side.

