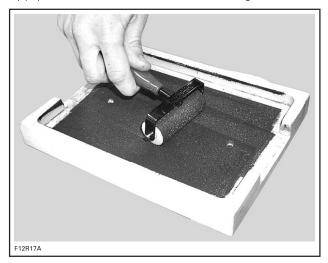
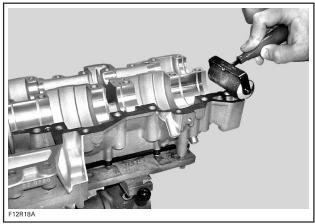
## **Section 03 ENGINES**

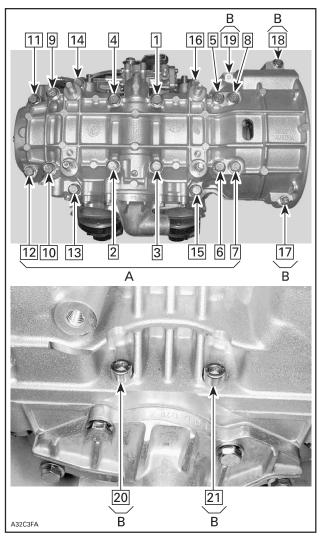
Subsection 06 (BOTTOM END)

Use a plexiglass plate and apply some sealant on it. Use a soft rubber roller (50 - 75 mm (2 - 3 in)) (available in arts products suppliers for printmaking) and roll the sealant to get a thin uniform coat on the plate (spread as necessary). When ready, apply the sealant on crankcase mating surfaces.





Screw all crankcase bolts in place in the following sequence and to the appropriate torque; this must be done in two steps torquing: first, screw bolts up to 60% of the final torque (18 N•m (13.5 lbf•ft) for most of the bolts), then, tighten to the required torque (i.e. 29 N•m (21 lbf•ft)).



A. Torque bolts 1 through 16 to 29 N $\bullet$ m (21 lbf $\bullet$ ft) B. Torque bolts 17 through 21 to 9 N $\bullet$ m (80 lbf $\bullet$ in)

## 593 HO, 593 HO SDI and 793 HO Engines

Install oil seal cover.

## **BREAK-IN**

After rebuilding an engine, always observe a break-in period as described in *Operator's Guide*.