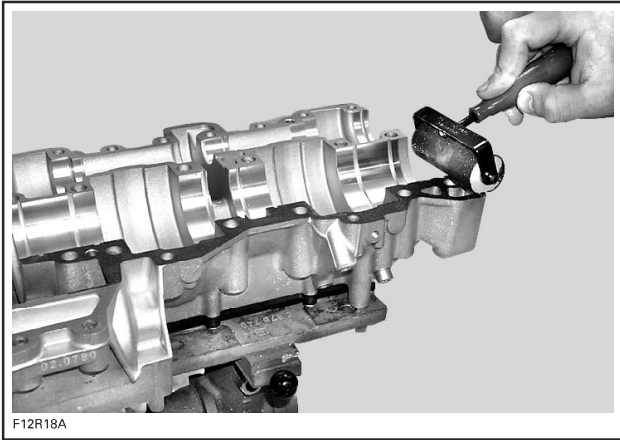


## Section 03 ENGINES

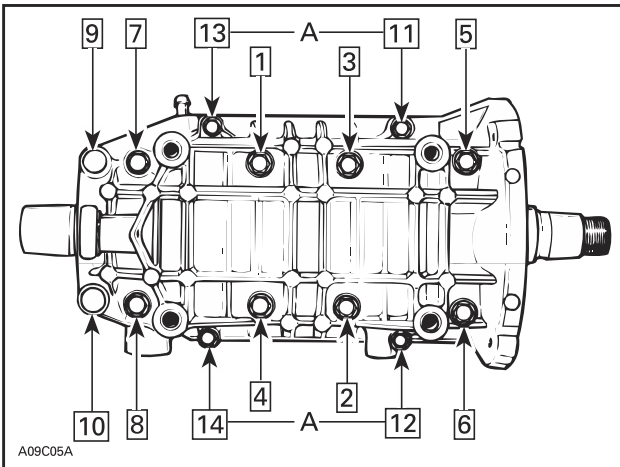
### Subsection 06 (BOTTOM END)



TYPICAL

Screw all crankcase bolts in place in the following sequence and to the appropriate torque through a two steps torquing: first, screw bolts up to 60% of the final torque 13 N•m (115 lbf•in) for M8 bolts), then, tighten to the required torque (i.e. 22 N•m (16 lbf•ft).

#### 377 Engine

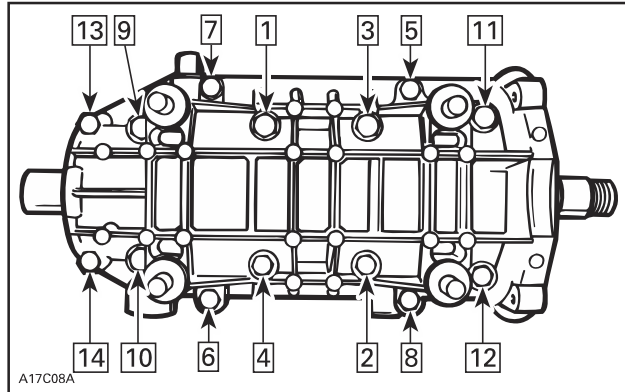


TIGHTENING SEQUENCE FOR 377 ENGINE TYPE

A. 10 N•m (89 lbf•in)

All the other screws are torqued to 22 N•m (16 lbf•ft)

#### 552 Engine



TIGHTENING SEQUENCE FOR 552 ENGINE TYPE

## BREAK-IN

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