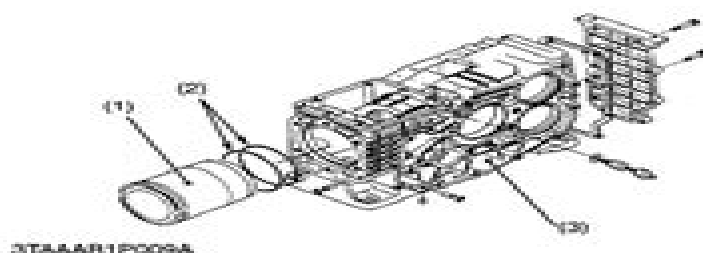


[3] CYLINDER BLOCK AND CYLINDER LINER



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The cylinder block is made of aluminium die-cast.

The cylinder block is provided with oil galleries to lubricate the crankshaft, main bearing case and rocker arm bracket. The cylinder liner (1) made of special cast iron having excellent wear resistance, is pressfitted into the cylinder block.

These engines adopt a wet type cylinder liner which periphery comes into direct contact with cooling water. To prevent water leakage, O-rings (2) are installed at the lower part of cylinder liner periphery. To prevent gas leakage, the upper part of the liner slightly protrudes from the cylinder block. This is because the gasket at this part is tightened strongly between the cylinder head and the liner.

■ NOTE

- Similarly as the aluminum alloy gear case, etc. cylinder blocks that are made of aluminum alloy are prone to scratches and greater thermal expansion. Therefore, following advises need to be followed during repair.
- Parts must be tightened when they are cold.
- Follow specified tightening torques accurately.
- Protect processed surfaces, especially, from scratches.

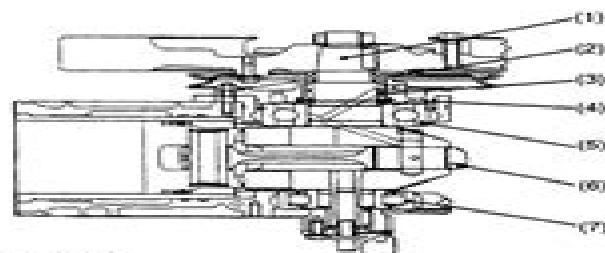
(1) Cylinder Liner

(3) Cylinder Block

(2) O-ring

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[4] CRANKSHAFT AND CRANKSHAFT JOURNALAL BEARING



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The crankshaft (1) is made of tough special alloy steel, and the pin and oil seal slinging portions are induction hardened to increase the hardness for higher wear resistance.

The journal portions are supported by main bearing 1 (7) and 2 (5).

The crankshaft is provided with an oil gallery which feeds engine oil to the pin portion and lubricate it.

The oil fed from the oil pump travels along the groove on the oil filler rings (3), passes through the oil gallery in the crankshaft and lubricates the crank pin part. The filler ring is made of aluminum alloy casting.

The oil seal (2) is provided to prevent oil leakage.

(1) Crankshaft

(5) Main Bearing 2

(2) Oil Seal

(6) Crank Pin Bearing

(3) Oil Filler Ring

(7) Main Bearing 1

(4) Main Bearing Case

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