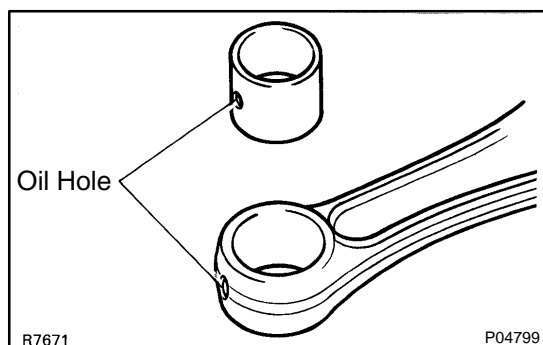


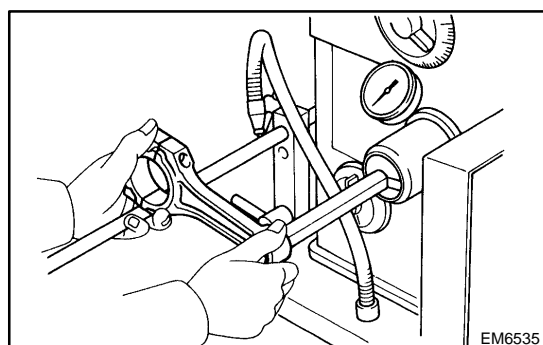
## REPLACEMENT

### 1. REPLACE CONNECTING ROD BUSHING

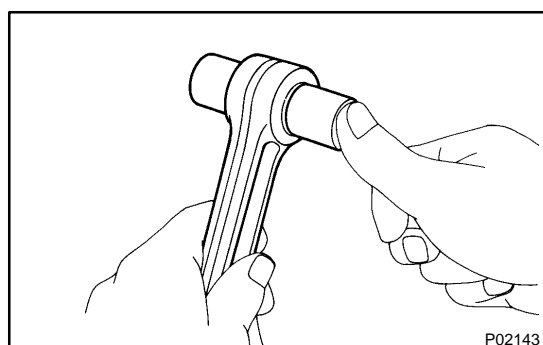
- (a) Using SST and a press, press out the bushing.  
SST 09222-30010



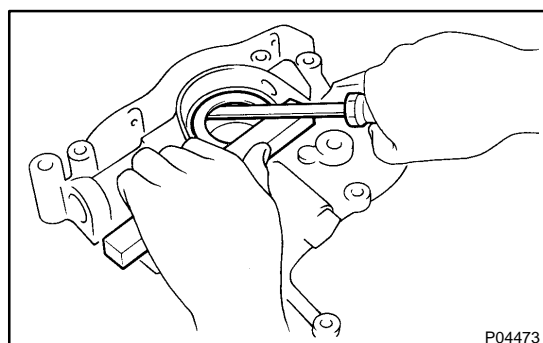
- (b) Align the oil holes of a new bushing and the connecting rod.  
(c) Using SST and a press, press in the bushing.  
SST 09222-30010



- (d) Using a pin hole grinder, bore the bushing to obtain the standard specified clearance (See page EM-83) between the bushing and piston pin.



- (e) Check the piston pin fit at room temperature.  
Coat the piston pin with engine oil and push it into the connecting rod with your thumb.

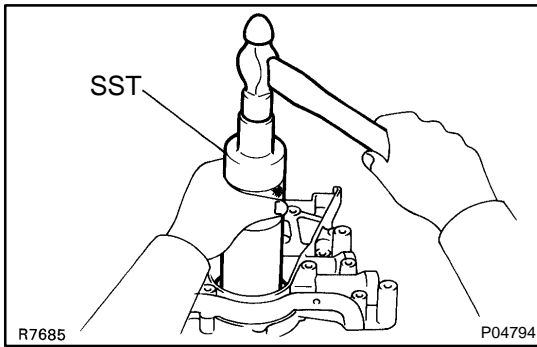


### 2. REPLACE CRANKSHAFT FRONT OIL SEAL

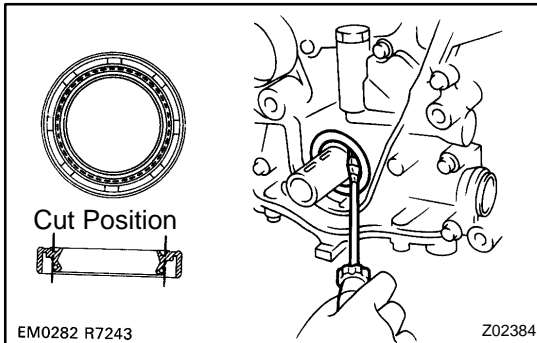
#### HINT:

There are 2 methods (a) and (b) to replace the oil seal as follows:

- (a) If the oil pump is removed from the cylinder block.  
(1) Using a screwdriver, pry out the oil seal.



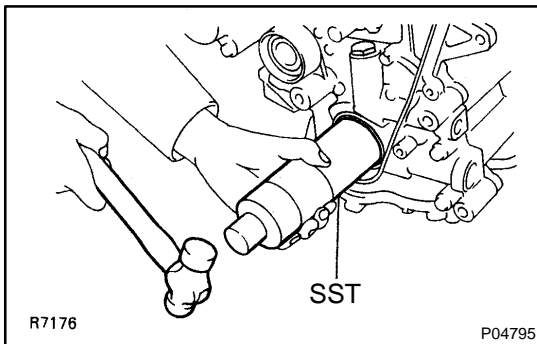
- (2) Using SST and a hammer, tap in a new oil seal until its surface is flush with the oil pump body edge.
- SST 09316-60011 (09316-00011)
- (3) Apply MP grease to the oil seal lip.



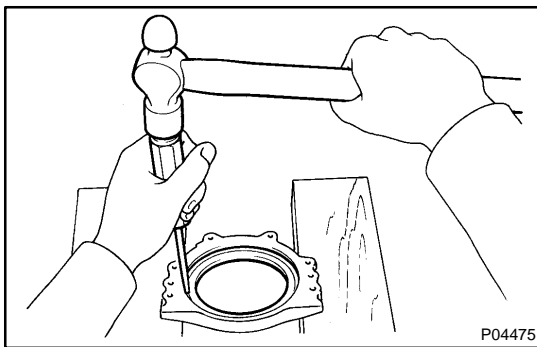
- (b) If the pump is installed on the cylinder block.
  - (1) Using a knife, cut off the oil seal lip.
  - (2) Using a screwdriver, pry out the oil seal.

**NOTICE:**

**Be careful not to damage the crankshaft. Tape the screwdriver tip.**

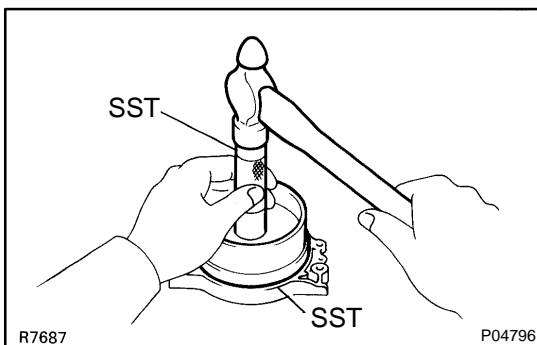


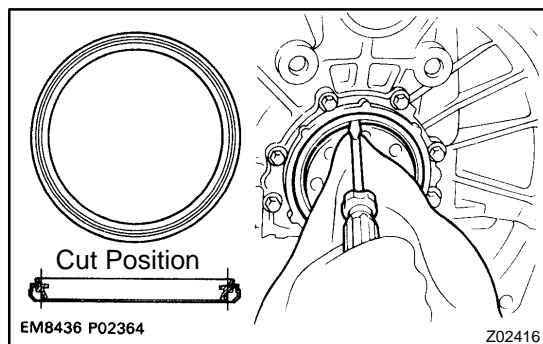
- (3) Apply MP grease to a new oil seal lip.
- (4) Using SST and a hammer, tap in the oil seal until its surface is flush with the oil pump body edge.
- SST 09316-60011 (09316-00011)

**3. REPLACE CRANKSHAFT REAR OIL SEAL****HINT:**

There are 2 methods (a) and (b) to replace the oil seal as follows:

- (a) If the rear oil seal retainer is removed from the cylinder block.
  - (1) Using a screwdriver and hammer, tap out the oil seal.
  - (2) Using SST and a hammer, tap in a new oil seal until its surface is flush with the rear oil seal retainer edge.
  - SST 09223-15030, 09950-70010 (09951-07100)
  - (3) Apply MP grease to the oil seal lip.

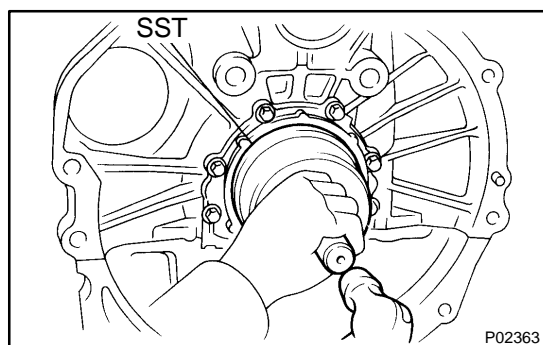




- (b) If the rear seal retainer is installed on the cylinder block.
- (1) Using a knife, cut off the oil seal lip.
  - (2) Using a screwdriver, pry out the oil seal.

**NOTICE:**

**Be careful not to damage the crankshaft. Tape the screwdriver tip.**



- (3) Apply MP grease to a new oil seal lip.
  - (4) Using SST and a hammer, tap in the oil seal until its surface is flush with the rear oil seal retainer edge.
- SST 09223-15030, 09950-70010 (09951-07100)