

## Q. Disassembly and Assembly of Crankcase

### Disassembly:

1. Disassemble the engine (see Job No. 01—4, Sections A to P).
2. Remove the two front engine supports at the left and at the right.
3. Remove the partition plate.
4. Remove the chain guides. To do this use Puller 187 589 07 33. When pulling out chain guide pivot pins, lift the lock-wire of the chain guide with a hook.

**Note:** When pulling out the pivot pins for the chain guide use the correct thread adapter of Puller 187 589 07 33. The pivot pins had originally an M 5 thread and now have an M 6 thread.

5. Unscrew the screw plugs at the ends of the longitudinal oil passages.
6. Pull out the rear bearing bushing for the idling gear shaft with Puller 186 589 09 33. Pull out the vertical bearing bushing for the helical gear with Puller 186 589 09 33 or drive out with a suitable drift from the oil pan side.
7. Take off the two cylinder covers which cover the engine water jacket compartments after removing the hexagon socket screws. Remove any fragments of the old gasket from the sealing surfaces on the crankcase and the two cylinder covers.

### Assembly:

8. Fit the two cylinder covers which cover the engine water jacket. Use a new gasket and smear sealing compound on both sides. The cylinder covers must form a perfect seal. It is therefore essential to test for leakage after doing this (see Job No. 01—5, Section A).

**Note:** The bearing block for the twin lever of the carburetor linkage should be installed at the same time as the right cylinder cover.

9. Smear the threads of the screw plugs for the oil passages with sealing compound and screw in at the end of the oil passages. In doing this, care must be taken to ensure that no sealing compound enters the oil passages.
10. Press the vertical bearing bushing for the helical gear into the crankcase bore with a suitable drift.

Press in the rear bearing bushing for the idling gear shaft with a suitable drift. In doing this, care must be taken to ensure that the outer through-way groove in the bushing faces upward. The open end of the inner groove must point toward the rear (Fig. 01—4/29).

11. Install the chain guides. The left chain guide in the crankcase is shorter. The pivot pins are 51 mm long. Press the pivot pins in far enough for the lock wire on the chain guide to engage in the annular groove in the pivot pin.

The upper pivot pin (for the left chain guide) has an external thread and hexagon head.

12. Fit the partition plate.
13. Screw the two front engine supports to the crankcase. The left engine support serves at the same time for the fixing of the timing pointer. The upper screw on the right engine support serves at the same time for the fixing of the generator tensioning screw and the lower screw for the fixing of the ground lead to the generator.
14. Assemble the engine (see Job No. 01—4, Sections A to P).