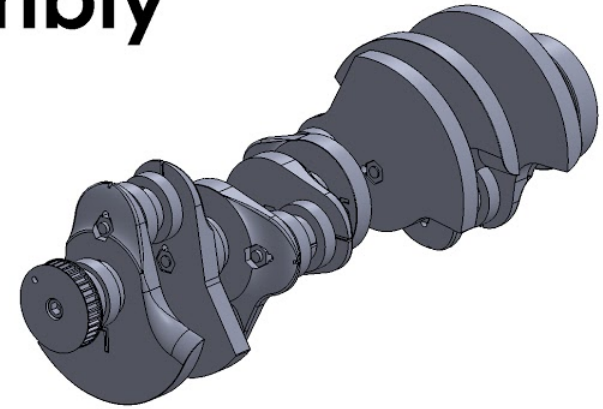
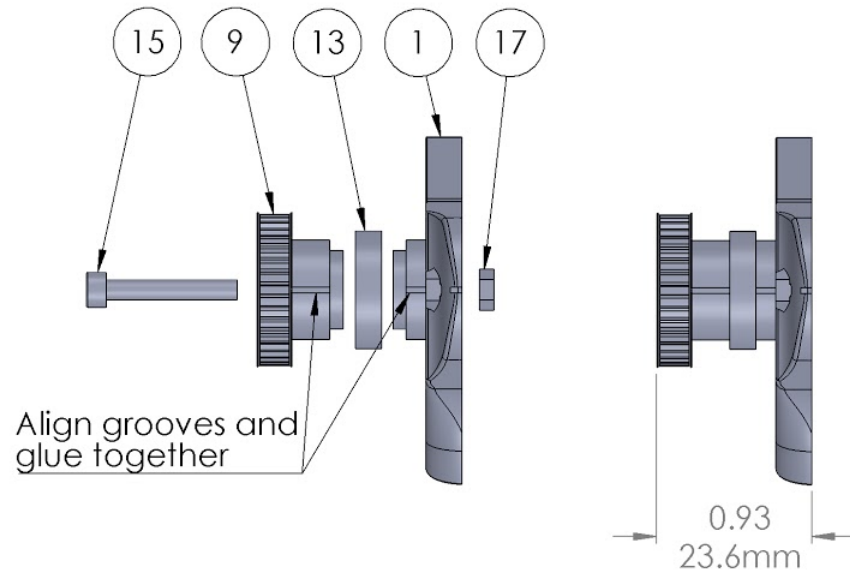


Crankshaft Assembly

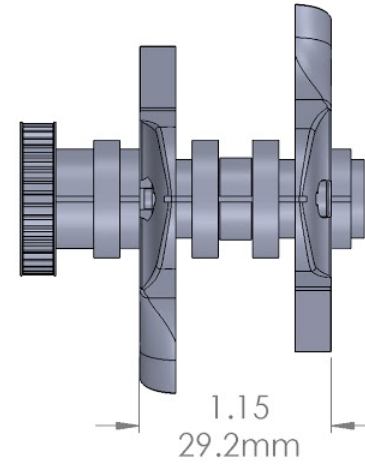
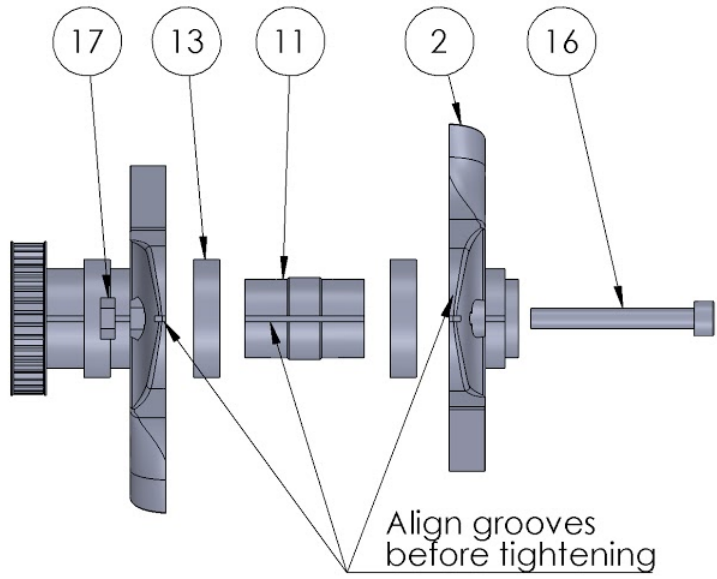
| ITEM NO. | PART NUMBER | Default/ QTY. |
|----------|--------------------------|------------------|
| 1 | Crankshaft 1 | 1 |
| 2 | Crankshaft 2 | 1 |
| 3 | Crankshaft 3 | 1 |
| 4 | Crankshaft 4 | 1 |
| 5 | Crankshaft 5 | 1 |
| 6 | Crankshaft 6 | 1 |
| 7 | Crankshaft 7 | 1 |
| 8 | Crankshaft 8 | 1 |
| 9 | Crank Gear | 1 |
| 10 | Crankshaft Output Flange | 1 |
| 11 | Crankshaft spacer 1 | 4 |
| 12 | Rear Main spacer | 1 |
| 13 | 6701zz Bearing | 13 |
| 14 | M3 18mm SHCS | 3 |
| 15 | M3 20mm SHCS | 1 |
| 16 | M3 25mm SHCS | 5 |
| 17 | m3 nut | 9 |



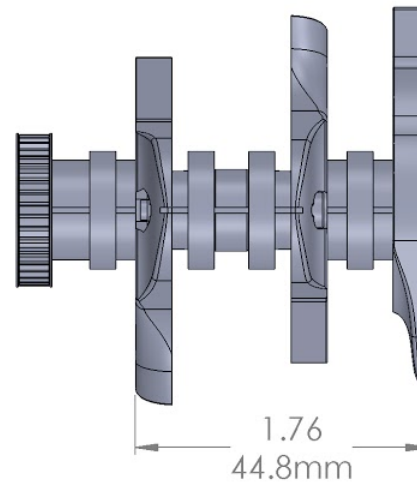
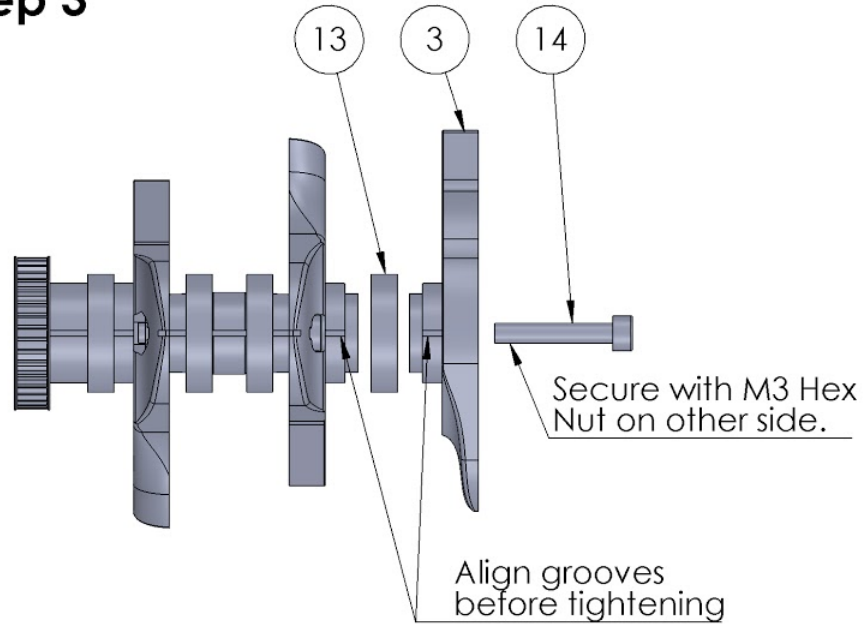
Step 1



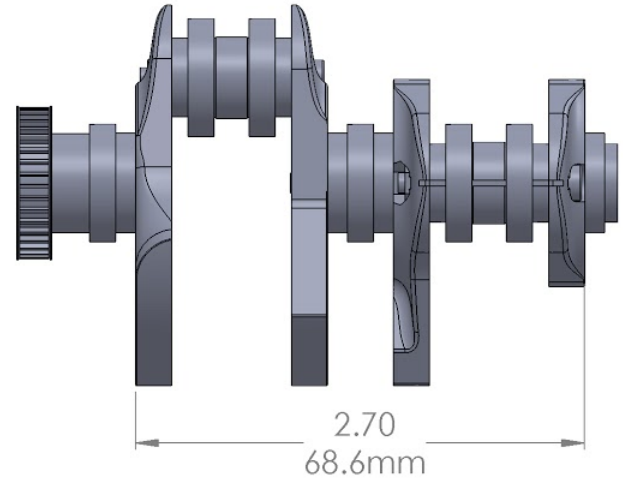
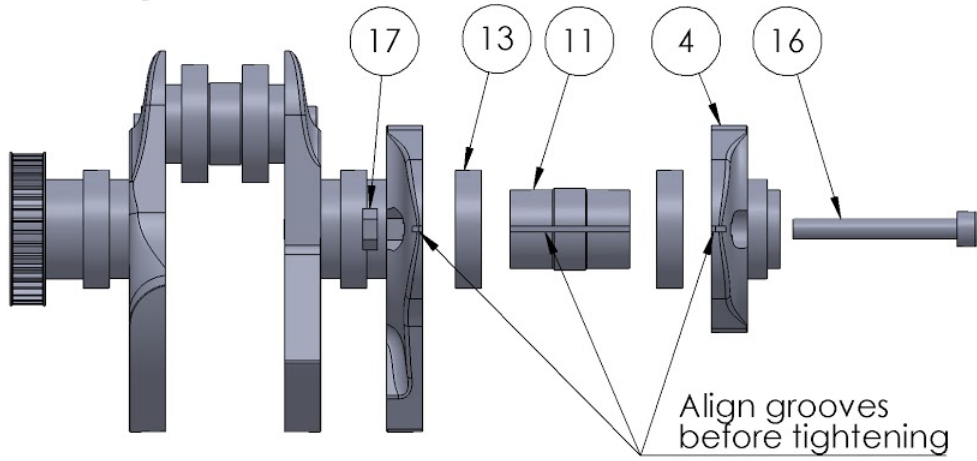
Step 2



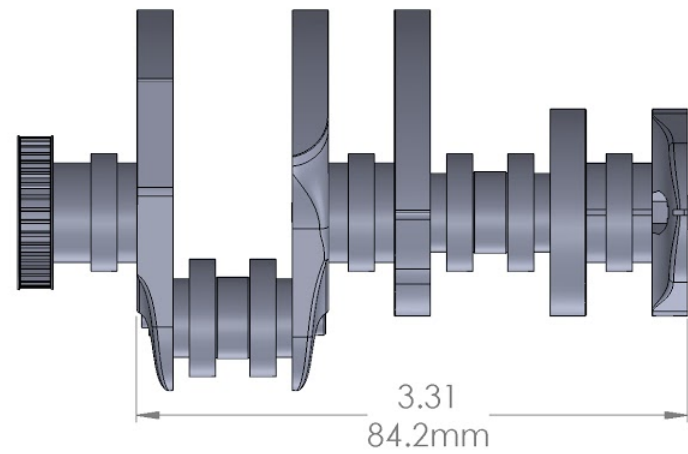
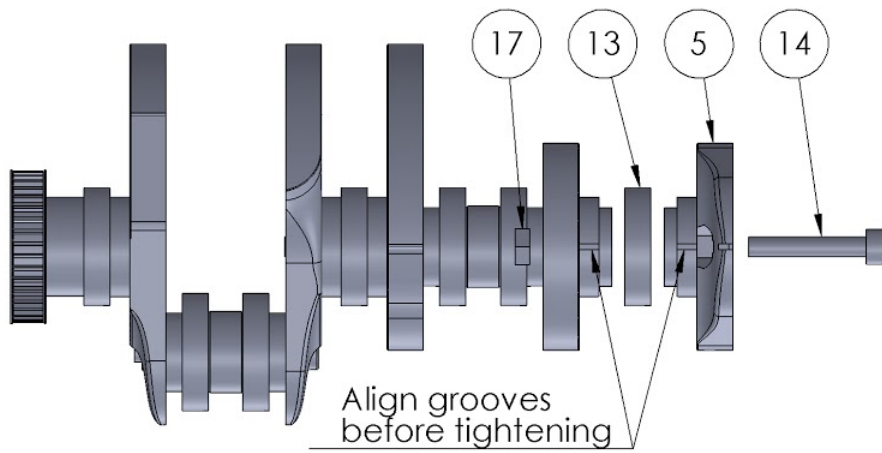
Step 3



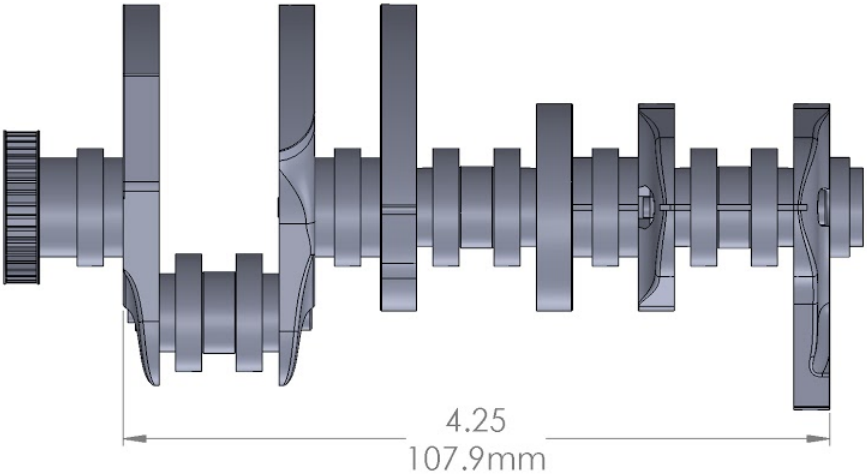
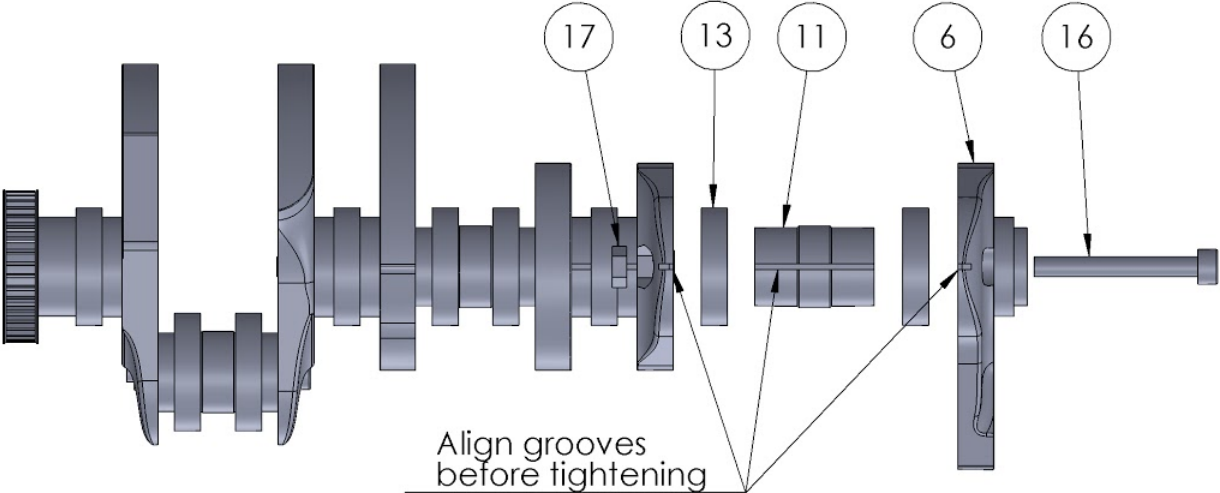
Step 4



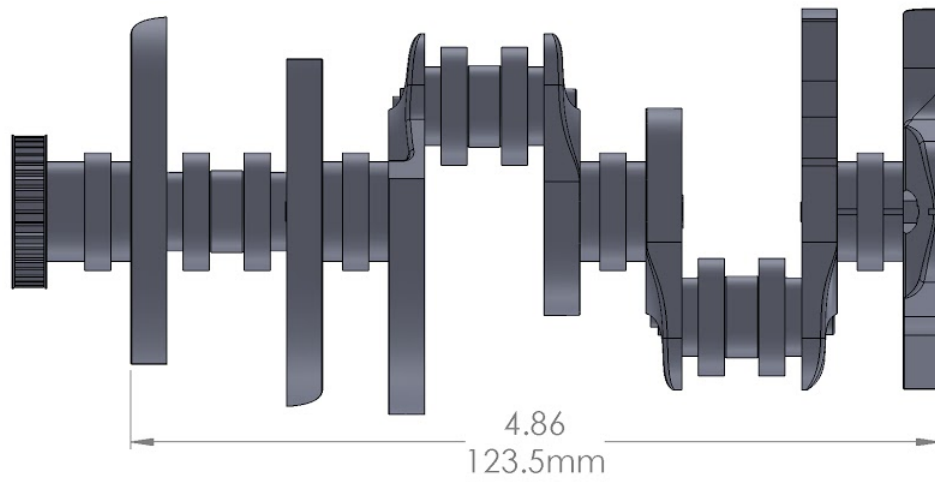
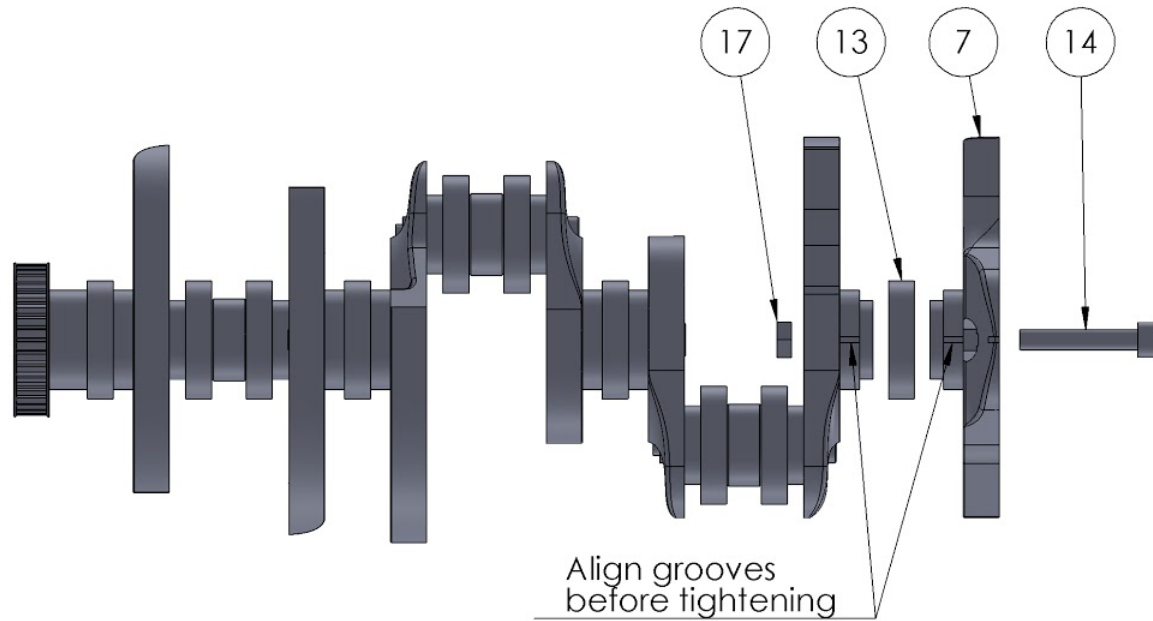
Step 5



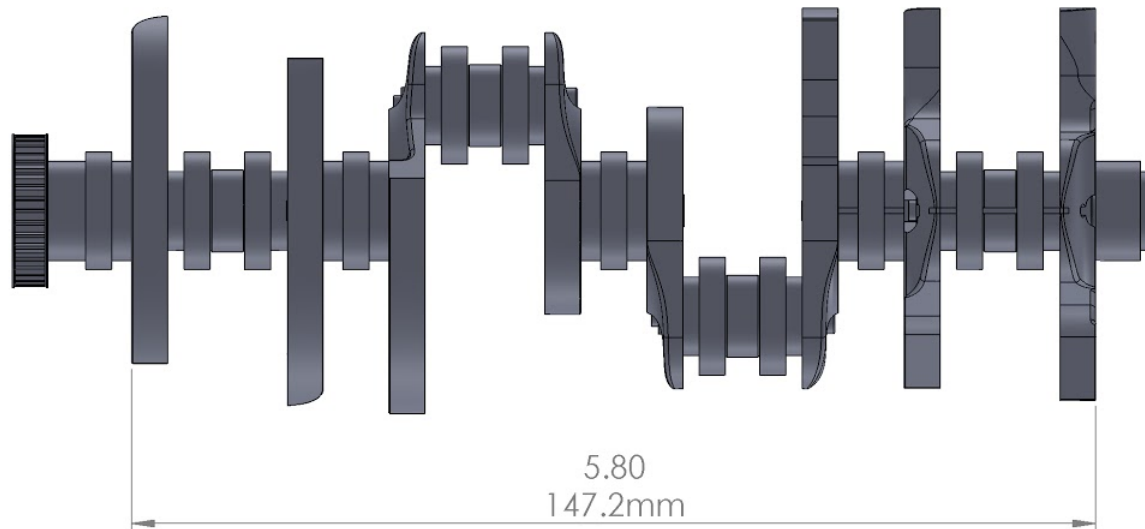
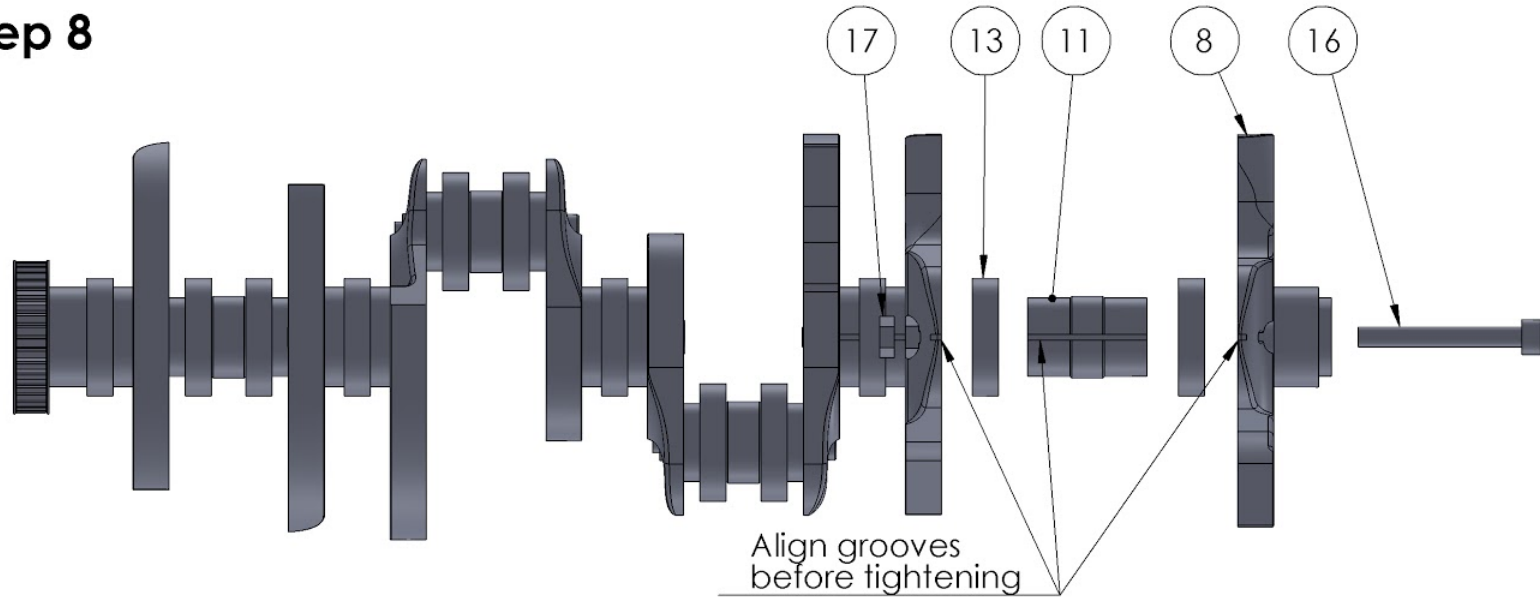
Step 6



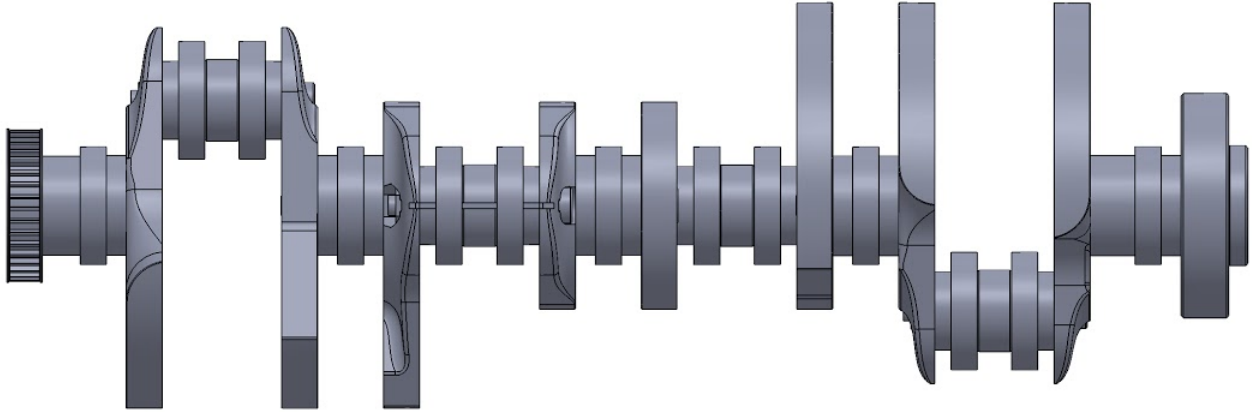
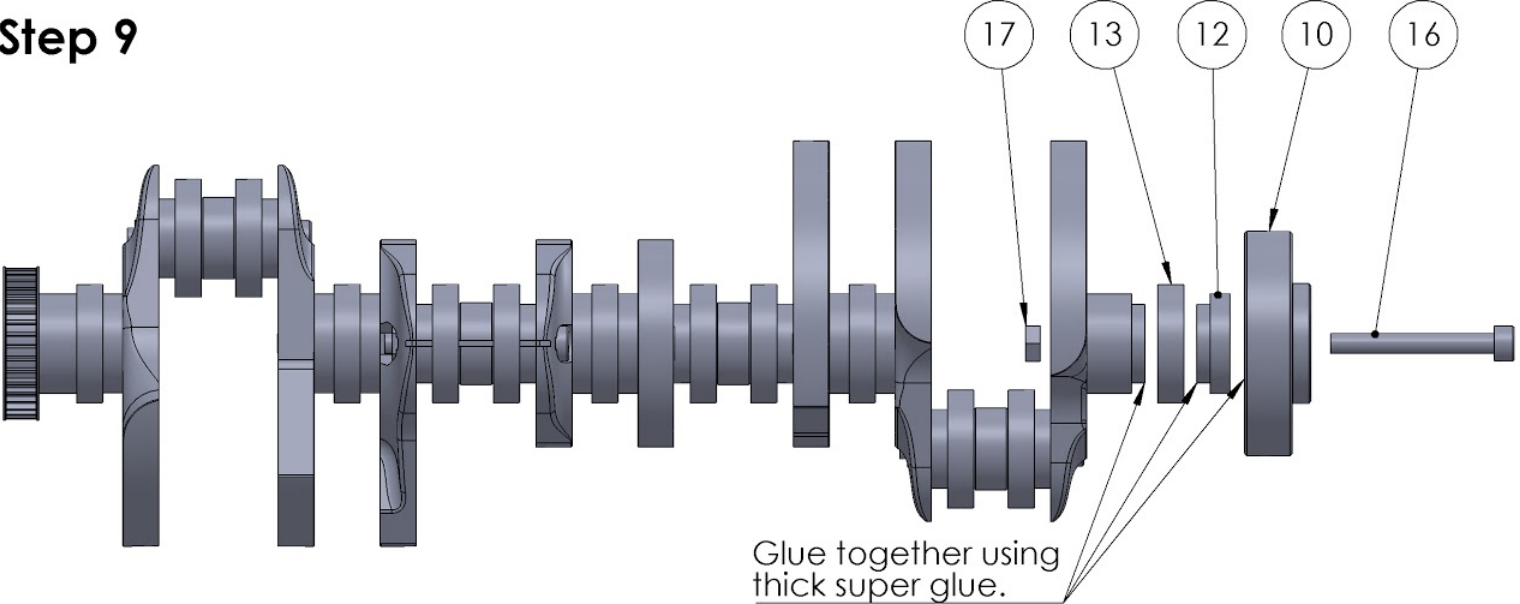
Step 7



Step 8



Step 9

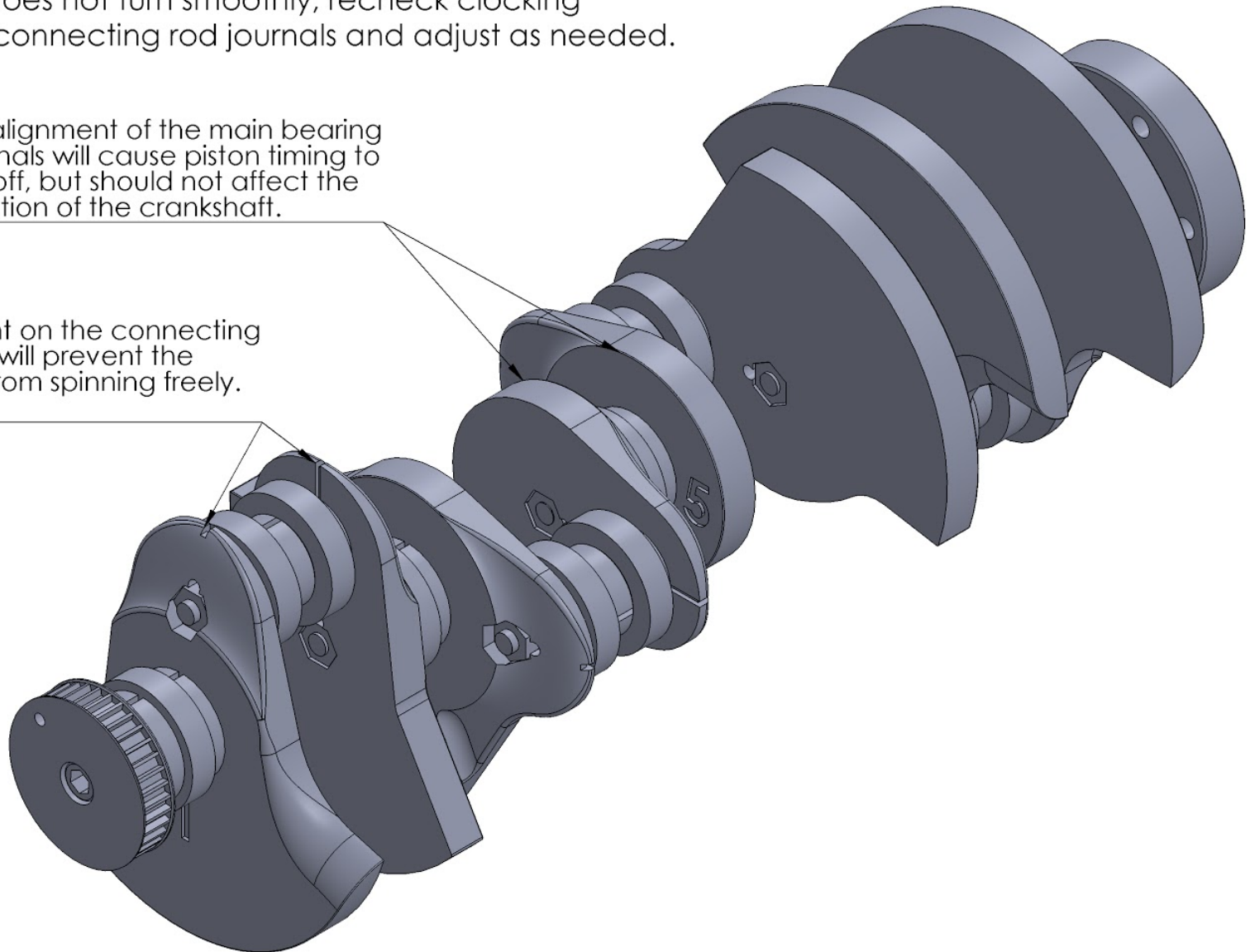


Step 10

Test fit crankshaft to engine block.
Install and completely tighten main bearing caps.
If crankshaft does not turn smoothly, recheck clocking
marks on the connecting rod journals and adjust as needed.

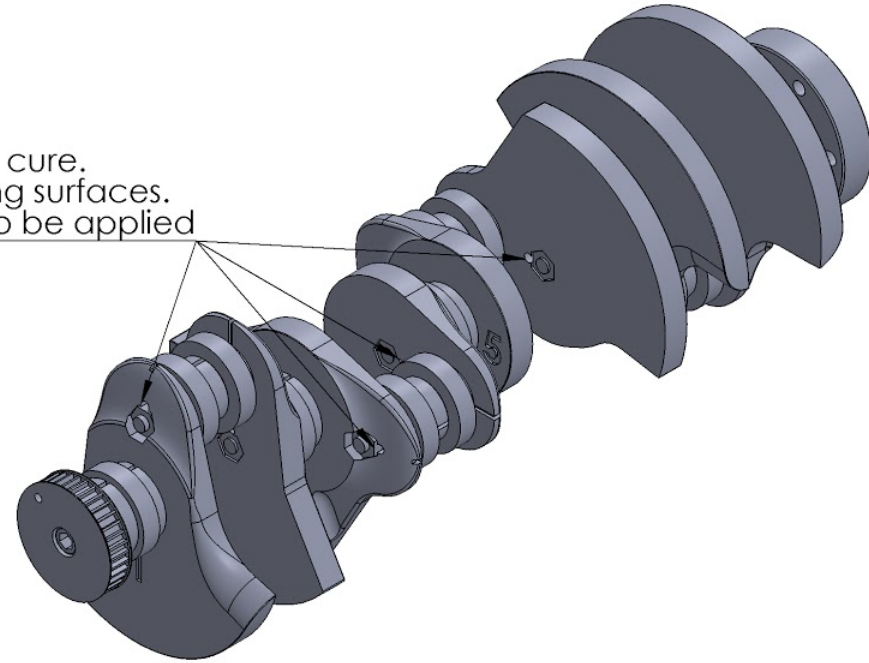
Misalignment of the main bearing journals will cause piston timing to be off, but should not affect the rotation of the crankshaft.

Misalignment on the connecting rod journals will prevent the crankshaft from spinning freely.

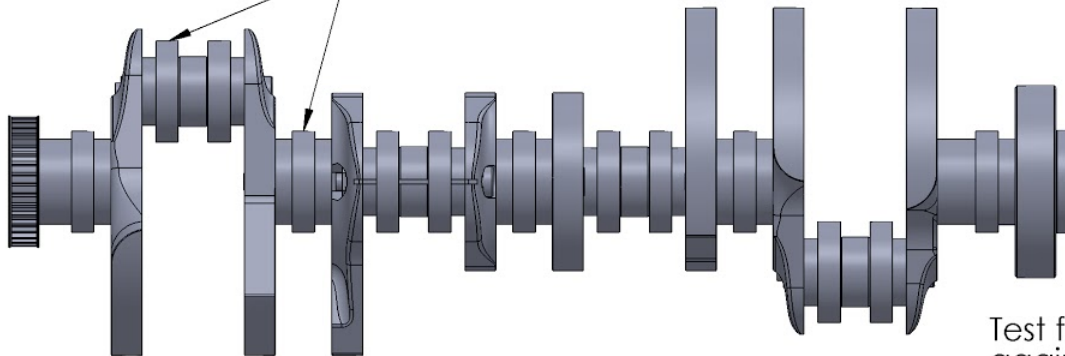


Step 11

Using extra thin super glue, glue crankshaft together. Place a few drops into each hole. The extra thin super glue should wick in between the mating surfaces. Do one hole a time and give plenty of time for glue to cure. The glue will take longer to cure between the matching surfaces. There are a total of 14 holes where super glue needs to be applied



Check that no super glue is on the bearings and that they all rotate smoothly. Use a super glue de-bonder if needed.



Test fit the crank into the block again and install main bearing caps.