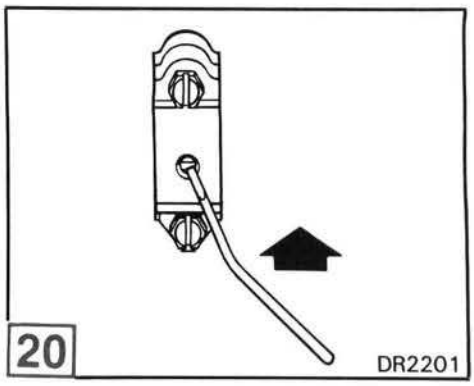
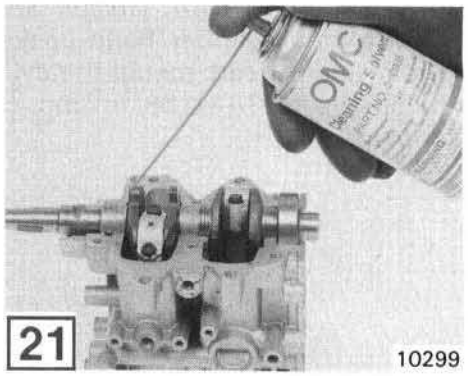
18. Move the pistons up so that the connecting rod bearings are against the crankpin. Place the remaining 16 needle bearings on the crankpin. Orient and place the connecting rod cap on the needle bearings. Oil threads of the rod cap screws. Install and tighten the screws in stages to a final torque of 60-70 in. lbs. (7-7,5 N·m).

20 19. Check whether all the needles are in place in the assembled connecting rod bearing by inserting a small rod or wire through the oil hole in the cap. It will not be possible to touch the crankpin with the wire if the correct number of needles has been used.

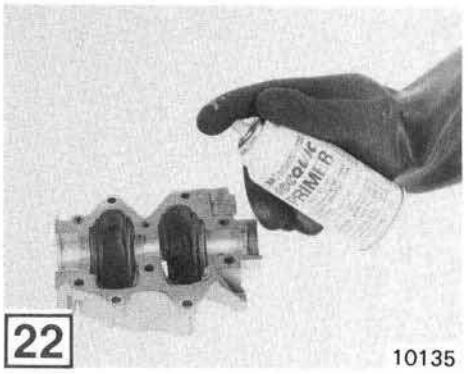


20. Place remainder of the 30 needles on center journal of the crankshaft. Place bearing liner on needles aligning dovetails.

21 21. Thoroughly clean and degrease the crankcase mating flange of the cylinder block with *OMC Cleaning Solvent* and let air dry.

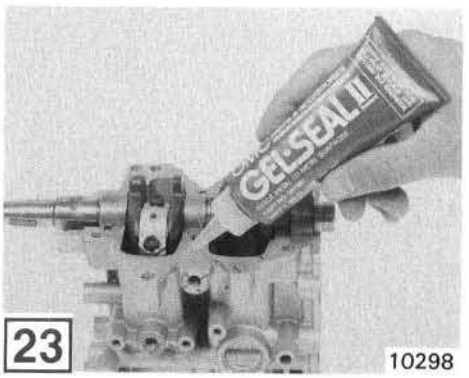


22 22. Apply *Locquic Primer* to the mating flange of the crankcase and let air dry.



23 23. Apply *Gel Seal II* to the cylinder block flange. The application must cover the flange evenly and consistently without being excessive. The application must not come within ¼ in. (6,4 mm) of the labyrinth seals or bearings.

Note *Gel Seal II* has a shelf life of at least one year when stored at room temperature. Test the *Gel Seal II* or replace it if the age of the tube can not be determined. **Using old *Gel Seal II* could cause crankcase air leaks.**



24. Lower the crankcase into place. Lightly coat threads of the two center and two bottom main bearing screws with *OMC Gel-Seal II.* Install the six main bearing screws **finger tight.**

25. When the crankcase is seated, install and firmly seat the crankcase taper pin.

26. Using a soft face mallet, lightly tap bottom of the crankshaft to seat the lower main bearing.

24 27. Tighten the six main bearing screws in stages to a final torque of 144-168 in. lbs. (16-19 N·m). Begin with center screws and work outward in a spiral pattern.

- Install and tighten the flange screws to a torque of 60-84 in. lbs. (7-9 N·m).