

2. Spray the crankcase cover mating surface with OMC Loctac Primer and allow it to air dry.
3. Apply OMC Gel Seal II sealant to the mating surface of the cylinder block. Run a continuous sealant bead along the inside of all screw holes, then carefully spread the bead over the entire surface of the flange, making sure the sealant will not contaminate the bearings, labyrinth seals or ooze into the crankcase. Keep the sealant approximately 1/4 in. (6.35 mm) from the labyrinth seal grooves and all crankshaft bearings.
4. Install the crankcase cover into position on the cylinder block. Seat the cover to the block with hand pressure.

**NOTE**

Before installing the taper pin, the crankcase cover must be seated to the cylinder block and held in place by the main bearing screws, but without any substantial clamping load being applied by the screws. The cover must be able to move (shift) slightly when the taper pin is installed, to precisely align the cover to the cylinder block.

5. Lightly coat the threads of the 14 crankcase cover screws with OMC Gel Seal II sealant, then install the screws. Tighten the six main bearing screws finger-tight

until the cover is seated to the block. Then install the taper pin (3, Figure 114) and seat it in its bore. Do not drive the taper pin too tightly into its bore or it will split the cylinder block and crankcase cover.

**CAUTION**

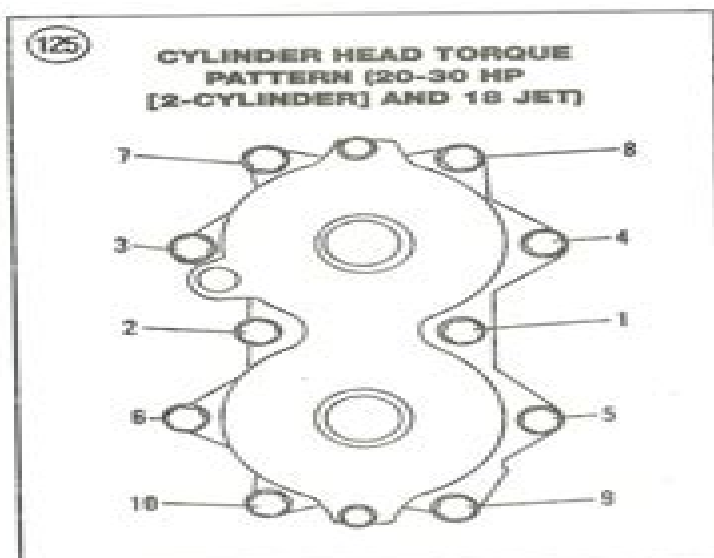
Do not strike the end of the crankshaft directly, or the crankshaft sleeve will be destroyed.

6. Insert a suitable mandrel into the crankshaft splined bore. The mandrel must fit into and contact the bottom of the splined bore. Carefully tap against the mandrel with a soft-faced hammer to seat the ball bearing in its bore.
7. Install the lower end cap. Coat the threads of three new end cap screws with OMC Gasket Sealing Compound. Install the screws and tighten them finger-tight at this time.
8. Tighten the six main bearing screws evenly to 168-192 in.-lb. (19.0-21.7 N-m) in a crossing pattern starting with the center screws and working outward. Then tighten the eight flange screws in the same manner to 60-84 in.-lb. (6.8-9.5 N-m).
9. Evenly tighten the three lower end cap screws to 60-84 in.-lb. (6.8-9.5 N-m).
10. Rotate the crankshaft several revolutions to check for binding or unusual noise. If binding or noise is noted, the crankcase cover must be removed and the cause of the defect located and corrected before proceeding.
11. Coat the metal case of a new upper crankshaft seal with OMC Gasket Sealing Compound. Lubricate the lip of the seal with OMC Triple Guard Grease. Slide the seal over the flywheel end of the crankshaft with its lip facing the crankcase. Using seal installer part No. 321539 (or equivalent), drive the seal into position in the crankcase bore.

**NOTE**

Do not sealant on the cylinder head screws.

12. Remove the cylinder head. Lightly coat both sides of a new head gasket with OMC Gasket Sealing Compound. Position the cylinder head and new gasket to the cylinder block, then install the screws (without sealant). Evenly tighten the cylinder head screws to 216-240 in.-lb. (24.4-27.1 N-m) in the pattern shown in Figure 125.
13. Install a new thermostat seal into the cylinder head cavity. Set the thermostat into the cavity and over the seal with the spring side of the thermostat facing the cylinder head. Then place the relief spring over the thermostat. Finally, install the engine temperature switch into its cylinder head bore.
14. Apply OMC Gasket Sealing Compound to a new cylinder head water cover gasket. Install the water cover using the new gasket. Coat the threads of the 14 screws with sealing compound, then install and evenly tighten the



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**David Baud**



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