

Bearing Kit Installation Guide

4-Stroke Engines

Tools Needed:

Bore Gauge

Micrometer

OEM Service Manual

Torque Wrench

This guide is meant to detail the choice and installation of the SBT Plain Bearing Kit. It is not a substitute for the information necessary and contained in the **OEM Service Manual** for completing an engine build. A strong background in and experience with 4 stroke engine building is **REQUIRED** for use of this kit.

Procedure

1.1 (below) Measure the crank journals with a micrometer noting the dimensions at each location.



1.2 Choose a STD size bearing set from the kit and lay them into the cases at each location. Torque the cases to spec:

Sea-Doo

| | |
|--|------------------|
| Rods | 33 ft./lbs. +90° |
| Case Center bolts 1 st torque | 29 ft./lbs. |
| Case Center bolts 2 nd torque | 41 ft./lbs. |
| Case Outer bolt torque | 17 ft./lbs. |

Yamaha

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|--|-------------------|
| Rods | 14 ft./lbs. +120° |
| Case Center bolts 1 st torque | 5.6 ft./lbs. |
| Case Center bolts 2 nd torque | 11 ft./lbs. +50° |
| Case Outer | 8.7 ft./lbs. |

Honda

| | |
|-------------------------|-------------|
| Rods | 30 ft./lbs. |
| Case bolts (9mm) torque | 27ft./lbs. |
| Case bolts (8mm) torque | 18ft./lbs. |
| | |

Kawasaki

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|-------------------------|------------------|
| Rods | 16ft./lbs. +120° |
| Case bolts (6mm) torque | 106inc./lbs. |
| Case bolts (8mm) torque | 22ft./lbs. |
| Case bolts (10mm) | 37ft./lbs |

| Part Stamping Suffix xx-xxx-xx(suffix) | Size |
|---|---------------|
| C | 2nd Oversize |
| B | 1st Oversize |
| (none) | Standard |
| Z | 1st Undersize |
| Y | 2nd Undersize |

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1.3 (below) using a bore gauge, measure the ID of the bearings and note the dimensions at each location.



1.4 Subtract the crank journal measurement from the bearing ID measurement for each location and note the resulting clearances. If the results are not between 0.001" - 0.002", reassemble the case with the appropriate over/under size bearings to create the correct clearances.

1.5 Repeat the same procedure for the rods, measuring the crankshaft pins.