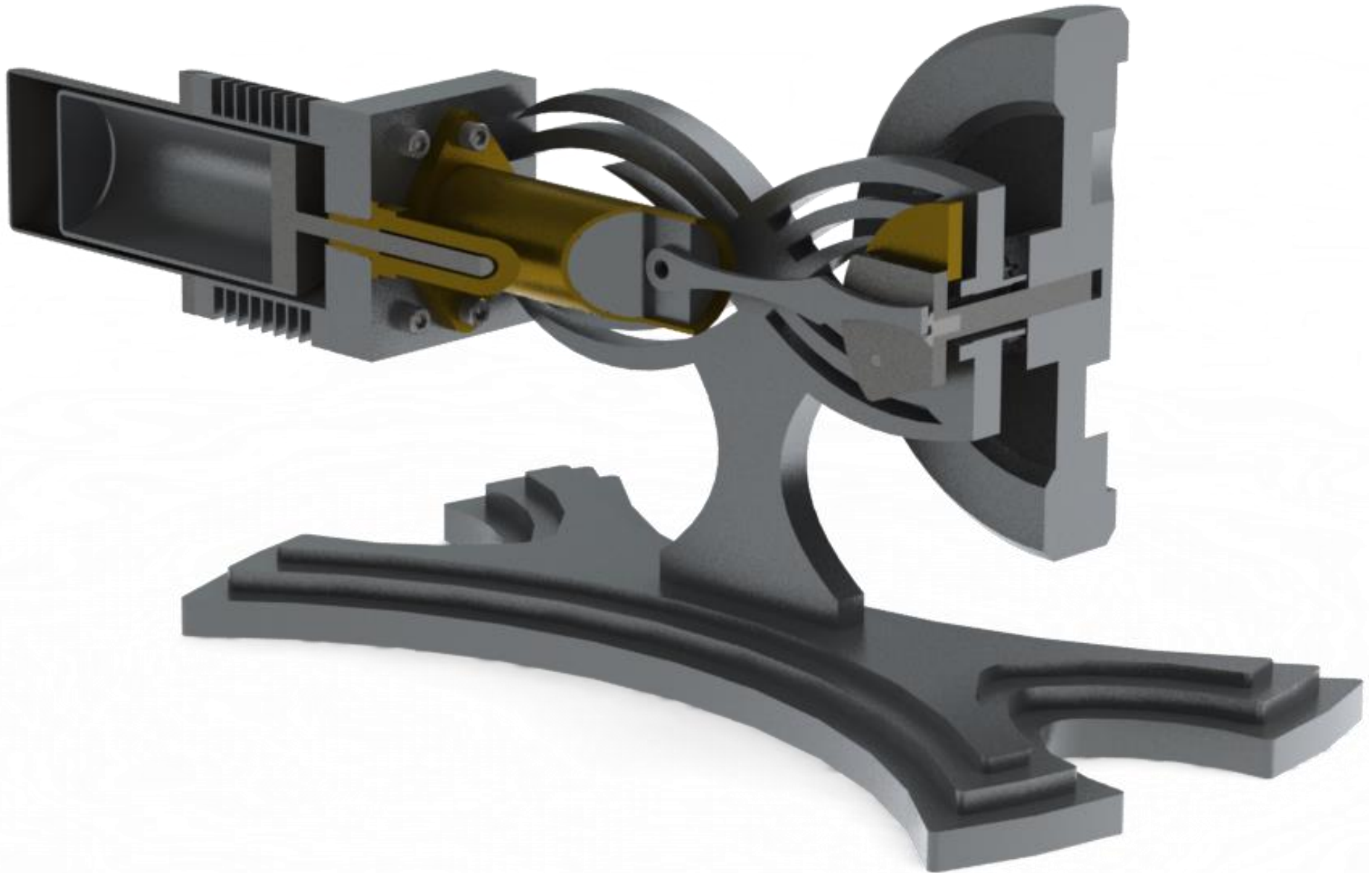


# Final Assembly



# Tasks

- Lap piston
- Press fit bushing into displacer bushing tube
- Press fit bushings or bearings into crankshaft bearing tube and connecting rods
- Apply silicone sealant to displacer bushing tube / mounting block interface
- Oil and affix gaskets to air chamber / heat sink and heat sink / mounting block interfaces
- Perform secondary operations on bedplate (reaming, countersinking)
- Press fit crankshaft bearing tube into bedplate
- Apply (or machine) shaft shims
- Assembly
- Set timing
- Beware – assembly takes a “long time” and you may find that you have to re-machine parts

# Setting Timing



# Setting Timing

