

**SECTION/OPERATION**

**3**

**ENGINE MOUNT**

<u>COMPONENT</u>	<u>PROCEDURE</u>	<u>PRINT #</u>	<u>TEMPLATE</u>
ENGINE MOUNT (E13-2000) Engine mount rubber Shims	Engine mount Engine mount support ring	E13-2000	E13-1

**NOTES**

SHIMS: Do not cut out shims for the engine mount at this time. When engine is ready to be installed, determine which shims are needed and cut out only what is necessary. (See Section 12.)

## ROTORWAY

### TOOLS REQUIRED FOR OPERATION 3:

Band saw	
Drift punch	
Drill bit of the following size:	5/16"
File	
Hammer	
Hand drill (air or electric)	
Ratchet with socket of the following size:	1/2"
Wrench of the following size:	1/2"

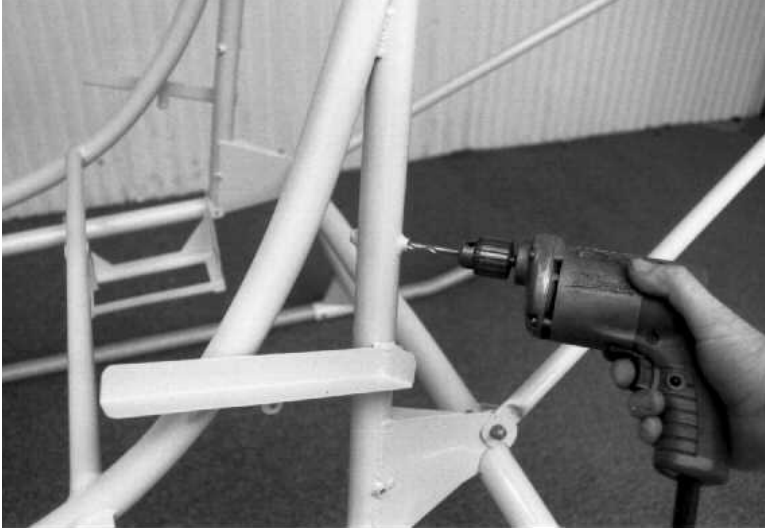


Photo #1

Use a hand drill with a 5/16" drill bit to drill the bushings for the lower engine mount.

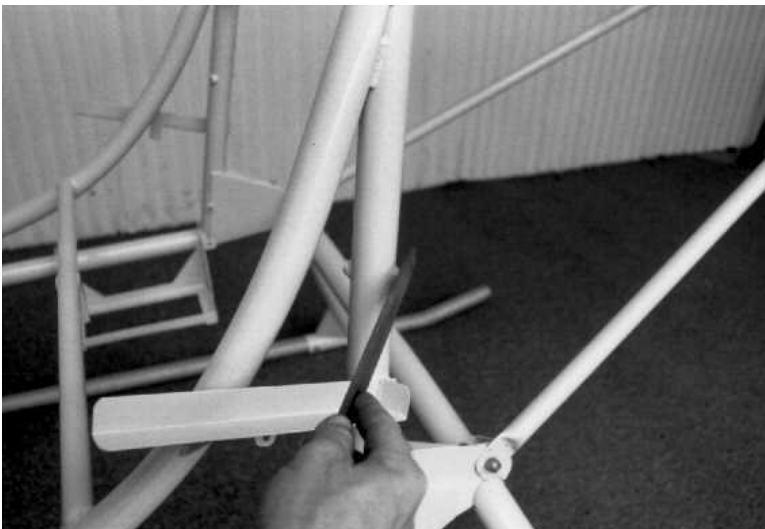


Photo #2

To fit the engine mount, the upper bushings may need to be shortened so that only about 1/16" of the bushing remains past the weld (a spot face drill works well for this procedure). On the lower passenger side bolt, shorten the bushing to allow for two battery cable ends, washer and nut. The two upper bushings should also be shortened to allow for the oil sump support straps, washers and nuts. The ends of all bushings must be 90 degrees to the hole.

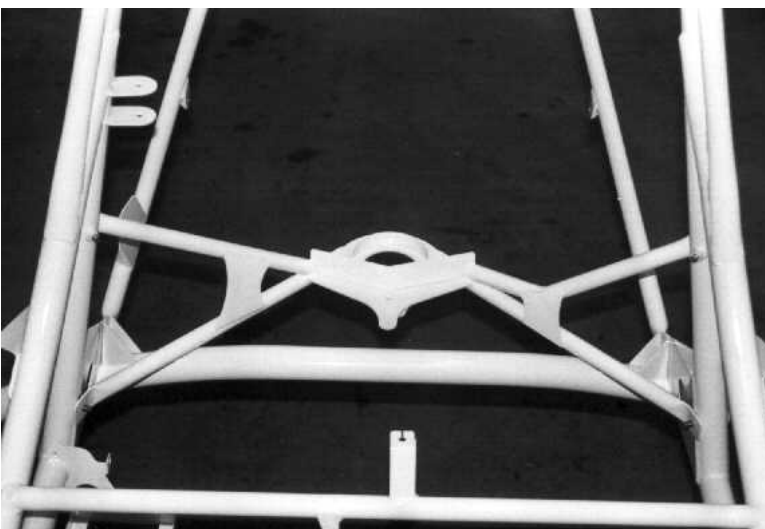


Photo #3

Install the lower engine mount and check location of the support ring.

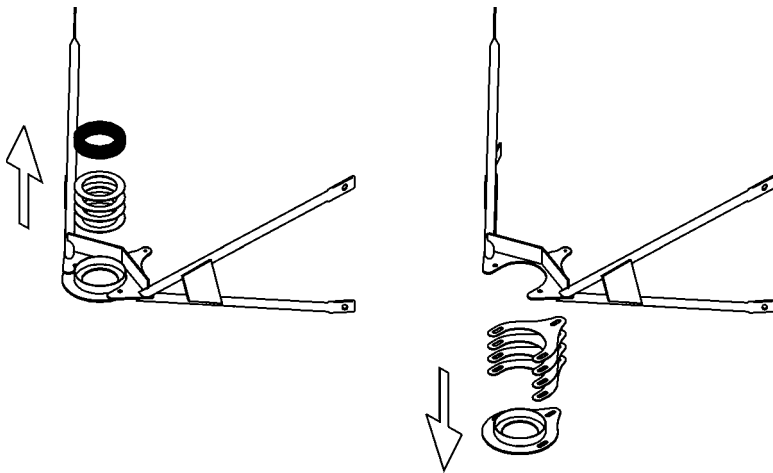


Photo #4

Shims will be installed later to change the height of the engine. Add "O" shaped shims between the engine mount and the rubber to raise the engine, OR add "Y" shaped shims between the engine mount and the support ring weldment to lower the engine. (See template E13-1.) Do not cut out shims at this time, but wait until installing engine to determine which shims are needed. (See Section 12 page 4).



Photo #5

Use the support ring weldment as a template to mark the outside diameter to be cut.

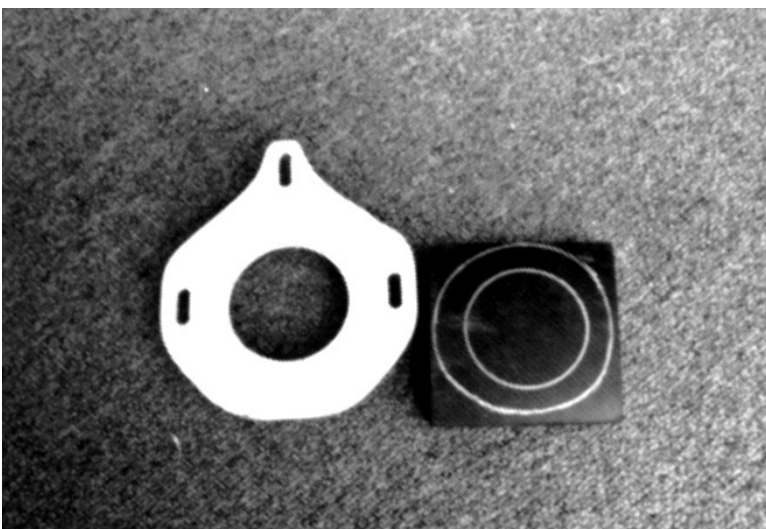


Photo #6

Rubber shown marked where it is to be cut. Cut on the line and install it in the support ring weldment.



Photo #7

The photo shows the approximate area to be cut out. The actual dimensions should be 2.650", as shown on the print. The rubber should fit snug inside the support ring and around the bottom of the engine.



Photo #8

Cut the rubber on the line and install it in the support ring weldment.



Photo #9

Support ring weldment bolted to the lower engine mount.