

ing holes to pull main bearing caps out of place to observe the relationship between the crank neck and bearing cap.

Use bearing cap bolts as spacers.

Important

Do not cover the crankshaft.

Remove the bearing cap, leaving the gaging pins in place. It does not matter whether the gaging pins rest on the surface of the bearing cap.

Insert the forward gaging pins in the bearing gaging with the main gaging pin in the gaging plastic package (Fig. 18).

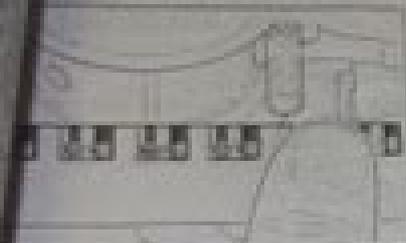


Fig. 18 Measuring Bearing Clearance

Remove all traces of the gaging plastic after measuring.

Select a set of bearing inserts that will provide the desired clearance (Fig. 18).

Replace both bearing shells as a set.

Install or Connect

NOTICE: Bearing inserts must not be cleaned, sanded or filed. Do not touch the bearing surface of the insert with the bare fingers. Use oil and slide with each the bearing surface.

Important

- Make sure the bearing cap bolt holes and the cap mating surfaces are clean and dry. (Refer to Rear Main Bearing for rear main bearing cap sealing procedure.)

Fit bearing cap bolts in clips edges of floor inserts near the bearing cap and into the engine block or connecting rod.

NOTICE: Upper and lower inserts may be different. Do not obstruct any oil passages.

Important

- The inserts will project slightly when put into place. Make sure they project an equal distance on both sides. Make sure the insert tangs are engaged.

- To the end of a shaft bearing cap, cover bearing caps with the upper main bearing cap (lower main bearing cap).
- Lubricate the bearing surfaces with clean engine oil.
- Crankshaft or connecting rod.

NOTICE: Avoid damage to the crankshaft journal. Use care when the main bearing cap is put in place.

- Bearing cap: Tap gently into place with a suitable tool.

NOTICE: Be careful to prevent the possibility of cylinder heads and/or main bearing cap damage. Use clean bearing caps and to be kept in the cylinder block cavity using a chain or better. Make sure connecting bolts are inserted. Do not use attaching bolts to pull main bearing cap into place. Failure to observe this instruction may damage a cylinder block or bearing cap.

- With crankshaft, bearing, and bearing cap installed and fully started, check crankshaft clearance to see and align bearing cap. Use three crankshaft bearings to align rear face of lower main bearing (204). Check in specifications.

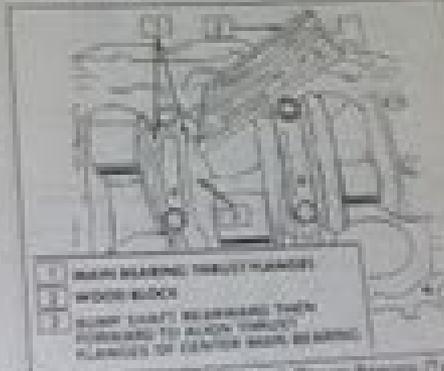


Fig. 20 Seating the Crankshaft Three Bearings (7 and 8 Angles)

- 1 MAIN BEARING THROAT PLUNGER
- 2 WOOD BLOCK
- 3 MAIN SHAFT BEARING TAPER PLUNGER TO ALIGN THROAT PLUNGER OF LOWER MAIN BEARING

Inspect

- Fit the connecting rods back and forth and check for loading. If necessary, loosen and re-tighten the bearing cap.

Measure

- Crankshaft end play (Fig. 10)
- Connecting rod side clearance (Fig. 12 or 14)

Clean

- Oil pump intake screen
- Oil pan

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Guillaume Favre



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