



3. Fasten a bolt to the crankshaft.
4. Remove the caps for the crankshaft main bearing.
5. Remove the crankshaft. Weight of the crankshaft is 100 lb. (45 kg).
6. Remove the crankshaft main bearings from the cylinder block and from main bearing caps.

Install Crankshaft

| Tools Needed | | A | B |
|--------------|----------------------------|---|---|
| 581161 | Wire | * | |
| 812328 | Clear Test Indicator Group | | 1 |

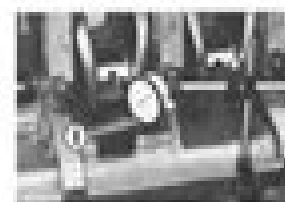
1. Clean the bearing surfaces in the cylinder block. Install the upper halves of main bearings in the block. Put clean SAE 30 engine oil on the bearings.
2. Fasten a bolt and put the crankshaft in position in the cylinder block with all the timing marks in alignment.
3. Clean the bearing surfaces of the main bearing caps. Install lower halves of the main bearings in the caps.



4. Check the main bearing clearance with wire (A). Install the caps in three inspection positions with the number on cap in alignment with the number on the pin that is on the left side of the cylinder block.
5. Put clean SAE 30 engine oil on the bearing bolt barrels and the face of the washers. Install the washers of the bolts and washers. Tighten both bolts to a torque of 30 x 3 lb-ft. (4.1 x 4.1 adg). Put

a mark on both bolt barrels and bearing caps. Tighten each bolt to additional 90° from mark. Remove bearing caps and measure thickness of wire (A). Main bearing clearance must be .0030 - .0019 in. (0.76 - 0.48 mm). Maximum permissible bearing clearance with used parts is .010 in. (0.25 mm).

6. Put clean SAE 30 engine oil on the lower halves of the main bearings. Install the main bearing caps in three inspection positions. Install bolts and washers for bearing caps. Tighten both bolts to a torque of 30 x 3 lb-ft. (4.1 x 4.1 adg). Put a mark on both bolt barrel and bearing caps. Tighten each bolt to additional 90° from mark.



7. Check the crankshaft end play that is controlled by the thrust bearing (2) on the new main bearing with tool group (B). The end play with new bearings must be .0021 - .0041 in. (0.054 - 0.103 mm). Maximum permissible end play with used bearings is .003 in. (0.04 mm).

NOTE: Install thrust bearing with side facing the identification "Backside" toward cylinder block.

8. If the accessory drive shaft gear, idler gear, or crankshaft gear has been removed or if the crankshaft gear has been replaced, it will be necessary to set the accessory drive shaft in time after assembling the engine. See REMOVE AND INSTALL FUEL INJECTION PUMP HOUSING AND GOVERNOR AS A UNIT.

and by:

- a) install pistons
- b) install timing gear cover
- c) install flywheel bearing

For more information, refer to page 2002.

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Ian Pickup



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