

Crankshaft end play should be limited to .0025-.005 in.; see Fig. 26. If the end play exceeds .005 in., install a new thrust plate.

CRANKSHAFT

The crankshaft is a one-piece, heat-treated steel forging supported at either end by a carefully ground steel-backed babbitt bearing. The crankthrow bearing journals and main bearing journals are carefully ground to exact specifications. Each crankshaft is carefully balanced before installed in an engine. The shaft is drilled for oil passages to the main and connecting rod bearings. An oil seal is provided on each end to prevent oil leakage.

REMOVAL

With the engine removed, the crankshaft is



Fig. 27

removed as follows:

1. Remove oil pan, see Fig. 27.
2. Remove clutch, flywheel and rear oil seal, see Fig. 28.
3. Remove cranking bolt, washer and pulley from the front of the crankshaft.
4. Remove the governor cover assembly.
5. Remove the oil breather tube assembly, see Fig. 24.
6. Disconnect the connecting rod bearing caps and remove all bearing shells.

Note: Keep all the bearing shells in order as they will have to be reassembled in the same order.

7. Remove the main bearing caps and shells.

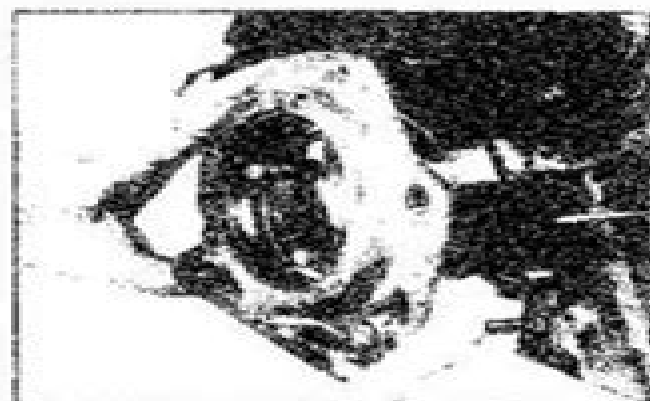


Fig. 28

The specifications for the crankshaft are as follows:

Main Bearing Journals- 1.999-2.000 in.

Connecting Rod Journals- 1.499-1.500 in.

The desired clearance between the main bearings and the crankshaft journals should be .0015-.0030 in. At no time should the clearance be less than .0015 in. or greater than .0032 in.

Longitudinal movement of the crankshaft during operation is termed "end play" and must

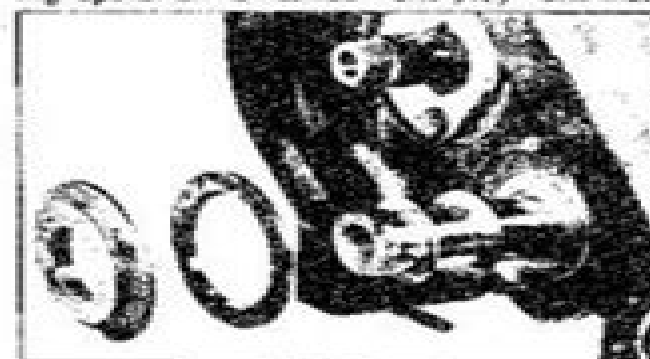


Fig. 29

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Tao Wei



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Table of Contents Massey Harris Pony Mower Manual

1. Understanding the eBook Massey Harris Pony Mower Manual
 - The Rise of Digital Reading Massey Harris Pony Mower Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying Massey Harris Pony Mower Manual
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Massey Harris Pony Mower Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from Massey Harris Pony Mower Manual
 - Personalized Recommendations
 - Massey Harris Pony Mower Manual User Reviews and Ratings
 - Massey Harris Pony Mower Manual and Bestseller Lists
5. Accessing Massey Harris Pony Mower Manual Free and Paid eBooks
 - Massey Harris Pony Mower Manual Public Domain eBooks
 - Massey Harris Pony Mower Manual eBook Subscription Services
 - Massey Harris Pony Mower Manual Budget-Friendly Options

6. Navigating Massey Harris Pony Mower Manual eBook Formats
 - ePub, PDF, MOBI, and More
 - Massey Harris Pony Mower Manual Compatibility with Devices
 - Massey Harris Pony Mower Manual Enhanced eBook Features
7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Massey Harris Pony Mower Manual
 - Highlighting and Note-Taking Massey Harris Pony Mower Manual
 - Interactive Elements Massey Harris Pony Mower Manual
8. Staying Engaged with Massey Harris Pony Mower Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Massey Harris Pony Mower Manual
9. Balancing eBooks and Physical Books Massey Harris Pony Mower Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Massey Harris Pony Mower Manual
10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
11. Cultivating a Reading Routine Massey Harris Pony Mower Manual
 - Setting Reading Goals Massey Harris Pony Mower Manual
 - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of Massey Harris Pony Mower Manual
 - Fact-Checking eBook Content of Massey Harris Pony Mower Manual
 - Distinguishing Credible Sources
13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
14. Embracing eBook Trends
 - Integration of Multimedia Elements

- Interactive and Gamified eBooks

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

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