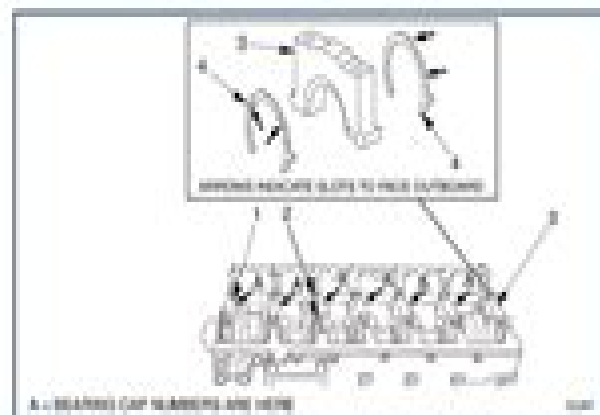


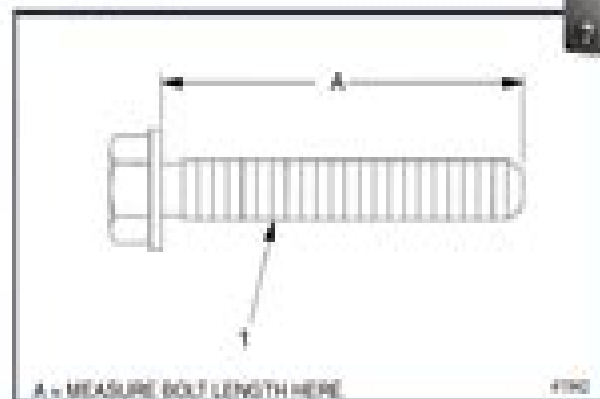
9. Position all the bearing caps (except the thrust master bearing cap) with their bearing shells in the crankcase position. All the bearing caps fit over the crankpin at the side (left) end only. Make sure the numbers on the bearing caps are in ascending order, starting from the front of the engine. [See Figure A228.](#)



1. Bearing Cap	2. Thrust master Bearing Cap
3. Bearing Cap Bolt	4. Thrust master (crankpin) nut and cone in the center

Main Bearing Cap Markings

10. Measure the shaft length of the main bearing cap bolts. Replace any bolts that exceed the maximum size (4.77 in.). [See Figure A229.](#)



1. Main Bearing Cap Bolt

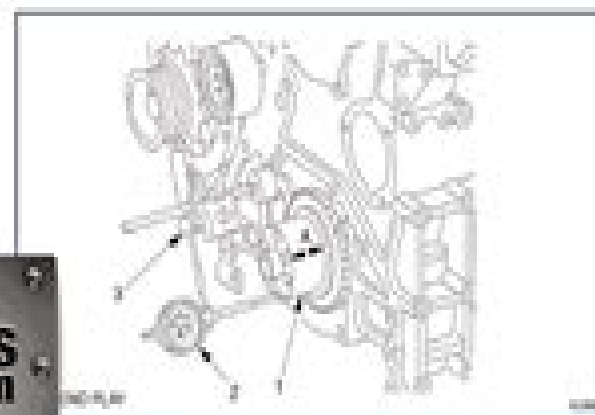
Measuring a Main Bearing Cap Bolt

11. Put a light coat of oil on the main bearing cap bolts. Turned at the M14 main bearing cap bolts. Tighten each one to the proper torque. [See Figure A230.](#)

Max. Shaft Length	Tightening Torque	Target Value
2.63 in. (6.67 in.)	Stage 1	27.0 - 36.0 ft. - lb.
	Stage 2	40.0 - 50.0 ft. - lb.
	Stage 3	110.0 - 120.0 ft. - lb.
	Stage 4	Additional 30 degrees

Tightening Torque, Main Bearing Cap Bolts

12. Spread the thrust washers in the bearing cap, making sure the direction the thrust washers are facing is correct. [See Figure A231.](#)
13. Spread the thrust master bearing cap. Tighten the bolts in stages in the same manner as the other bearing cap bolts.
14. Increase the crankshaft end play (clearance) at the thrust master bearing pin(s). [See Figure A232.](#)
1. Torque in 30-degree and a final torque torque. [See Figure A233.](#)



1. Thrust Master	2. Thrust Master
------------------	------------------

Flushing the Crankshaft End Play (Clearance)

1. Move the crankshaft at the way forward by getting in one of the bearing caps. Run down on the final group. [See Figure A234.](#)
2. Move the crankshaft at the way to the rear. Move the nutplate on the final group. [See Figure A235.](#)
3. If the nutplate is not 0.10 in. to 0.15 in. (0.004 in. to 0.006 in.), replace the thrust washers with those of the same size thickness. Otherwise, thrust washers are available.
10. Adjust the crankshaft pin to the crankshaft flange. [See Figure A236.](#) Adjust the bearing pin to the crankshaft with the bolt in the pin. Make sure the pin is 0.10 in. to the crankshaft pin is between the markings "1 - 1" on the crankshaft pin. [See Figure A237.](#)

Mbe 900 Engine Camshaft Service Manual

JG Myers



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