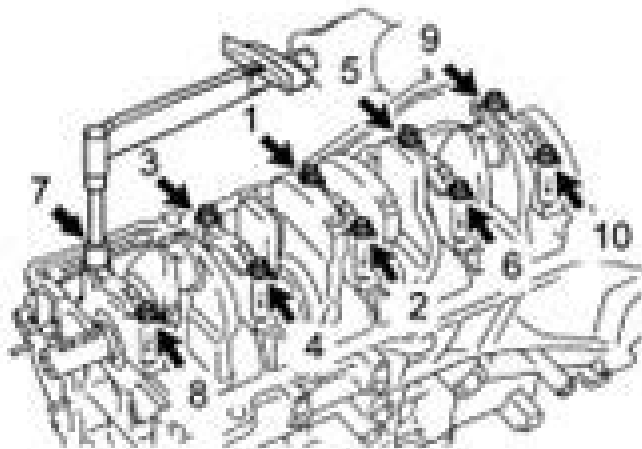


- (a) Install the 5 main bearing caps in their proper locations.
- (b) Install the main bearing cap bolts.
 - The main bearing cap bolts are tightened in 2 progressive steps (steps (2), (3) and (5)).
 - If any one of the main bearing cap bolts is broken or deformed, replace it.



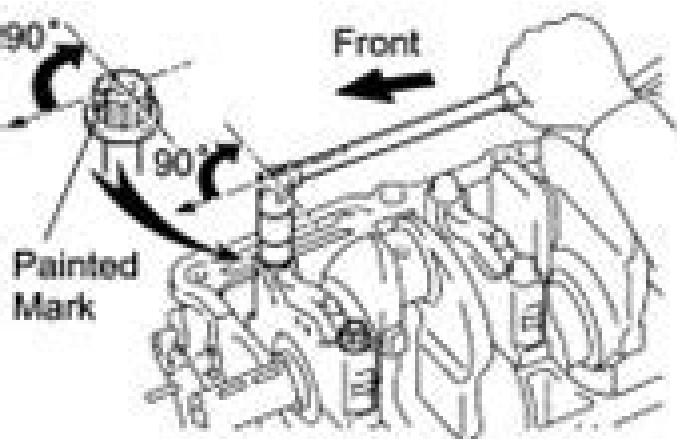
- (1) Apply a light coat of engine oil on the threads and under the main bearing cap bolts.
- (2) Install and uniformly tighten the 10 main bearing cap bolts in several passes, in the sequence shown.

Torque: 20 N-m (205 kgf-cm, 15 ft-lbf)

- (3) Retighten the 10 main bearing cap bolts in several passes, in the sequence shown.

Torque: 40 N-m (410 kgf-cm, 30 ft-lbf)

If any one of the main bearing cap bolts does not meet the torque specification, replace the main bearing cap bolt.



- (4) Mark the front of the main bearing cap bolt with paint.
 - (5) Retighten the main bearing cap bolts by 90° in the numerical order shown.
 - (6) Check that the painted mark is now at a 90° angle to the front.
- (c) Check that the crankshaft turns smoothly.

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A. Gomersall



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Idaho High-level Waste and Facilities Disposition ,2002

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Proceedings Michael A. DiPonio,Chris Dixon,2013 Annotation Every two years industry leaders and practitioners from around the world gather at the Rapid Excavation and Tunneling Conference RETC the authoritative program for the tunneling profession This comprehensive book includes more than 100 papers from industry experts highlighting their most recent projects and sharing real world experiences that will keep you up to date on the latest tunneling trends and technologies

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