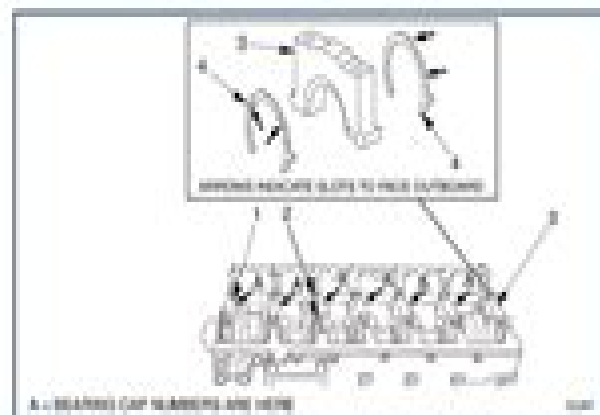


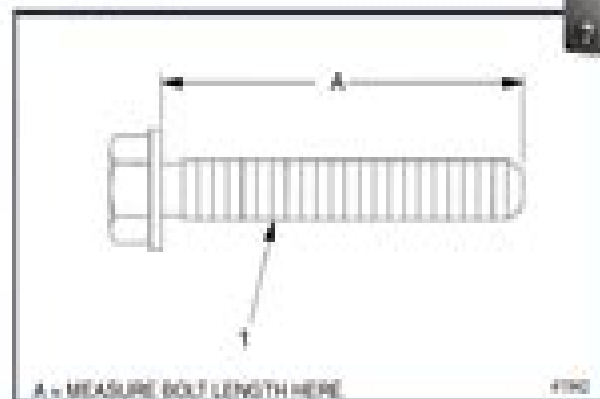
9. Position all the bearing caps (except the thrust master bearing cap) with their bearing shells in the crankcase position. All the bearing caps fit over the crankcase in the side (left) position. Make sure the numbers on the bearing caps are in ascending order, starting from the front of the engine.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



1. Bearing Cap	2. Thrust master Bearing Cap
3. Bearing Cap Bolt	4. Thrust master (crankcase) side cap in this order

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

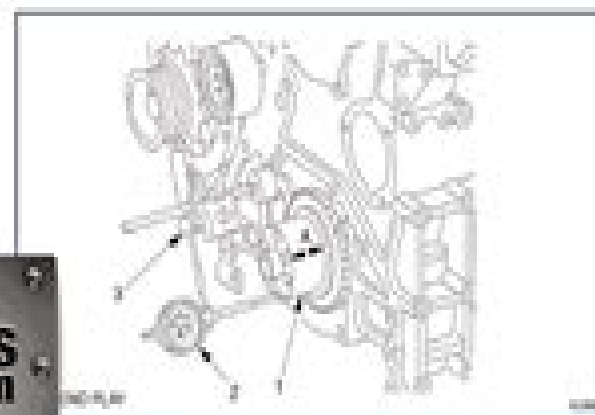
Measuring a Main Bearing Cap Bolt

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	27.07 in (2.07 in.)
	Stage 2	40.51 in (3.04 in.)
	Stage 3	111.51 in (2.04 in.)
	Stage 4	Additional 30 degrees

Tightening Torque, Main Bearing Cap Bolts

12. Install the thrust master in the bearing cap, making sure the direction the thrust master are facing outward. [See Figure A231.](#)
13. Install 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 (crank clearance) in the thrust master bearing position. [See Figure A232.](#)
1. Torque in that stage and a final torque tighter. [See Figure A233.](#)



1. Thrust Master
2. Thrust Master

Flushing the Crankshaft End Play (Crankshaft Return)

1. Move the crankshaft at the way forward by getting in case of the bearing caps. Run down on the final group. [See Figure A234.](#)
2. Turn the crankshaft at the way to the rear. Move the multiplier on the final group. [See Figure A235.](#)
3. If the multiplier is not 0.1 in case to 0.10 in (0.004 in. to 0.01 in.), replace the thrust master with those of the same size thickness. Otherwise thrust master are available.
10. Adjust the crankshaft gear to the crankshaft flange. [Bolt is supplied.](#) Adjust the bearing pin to the crankshaft with the bolt in the gear. Make sure the mark "1" on the crankshaft gear is between the markings "1 - 1" on the crankshaft pin. [See Figure A236.](#)

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