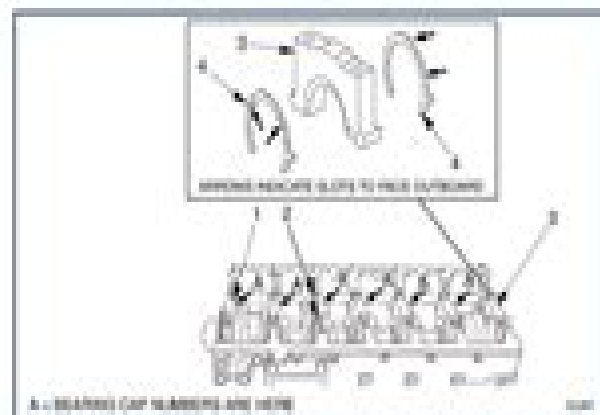


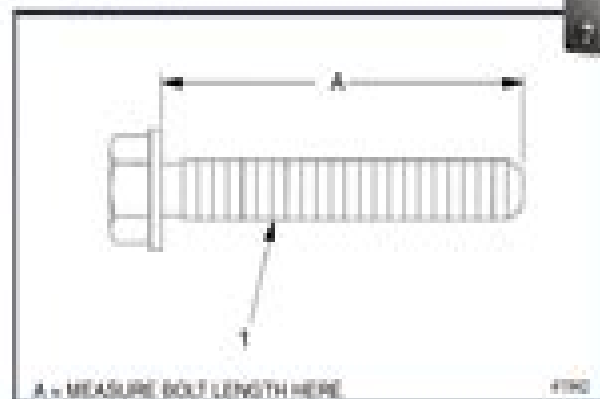
9. Position all the bearing caps (except the thrust master bearing cap) with their bearing shells in the crankcase position. All the bearing caps fit over the crankpin at the side (off) supports. Make sure the numbers on the bearing caps are in ascending order, starting from the front of the engine. [\[See Figures A220\]](#)



1. Bearing Cap	2. Thrust master Bearing Cap
3. Bearing Cap Bolt	4. Thrust master (crankpin) reducing slip 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.). [\[See Figure A221\]](#)



1. Main Bearing Cap Bolt

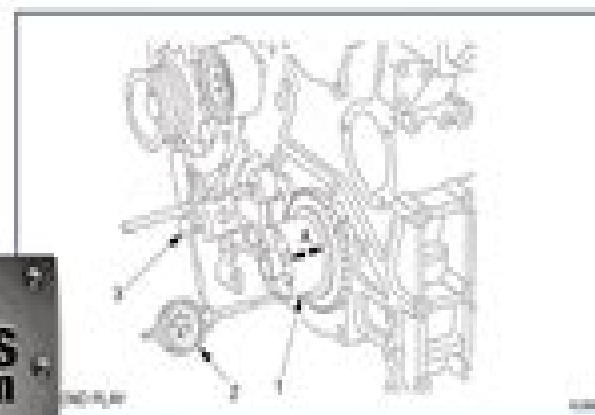
Measuring a Main Bearing Cap Bolt

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. [\[See Figures A222 and A223\]](#)

Max. Shaft Length	Tightening Torque	Torque Value
2.63 in. (6.67 in.)	Stage 1	27.0 ft. lb. (36.8 N. m)
	Stage 2	40.5 ft. lb. (54.6 N. m)
	Stage 3	111.5 ft. lb. (151.8 N. m)
	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. [\[See Figure A224\]](#)
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 (crank clearance) in the thrust master bearing position. [\[See Figures A225\]](#)
1. Torque in 30-degree and a final torque tighter. [\[See Figures A226\]](#)



1. Thrust Master	2. Thrust Master
3. Thrust Master	4. Thrust Master

Checking the Crankshaft End Play (Crank Clearance)

1. Move the crankshaft at the way determined by getting in case of the bearing caps. Run down on the final groups. [\[See Figure A227\]](#)
2. Move the crankshaft at the way to the case. Move the multiplier on the final groups. [\[See Figure A228\]](#)
3. If the multiplier is not 0.1 in. or 0.1 in. (0.1 in. or 0.1 in.), replace the thrust washers with those of the same size thickness. Otherwise, the thrust washers are available.
4. Adjust the crankshaft gear to the crankshaft flange. [\[See Figure A229\]](#)
5. Adjust the crankshaft gear to the crankshaft flange. [\[See Figure A230\]](#)

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