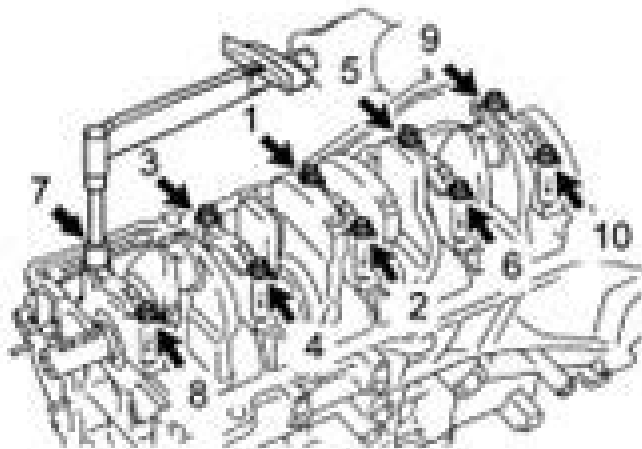


- (a) Install the 5 main bearing caps in their proper locations.
- (b) Install the main bearing cap bolts.
 - The main bearing cap bolts are tightened in 2 progressive steps (steps (2), (3) and (5)).
 - If any one of the main bearing cap bolts is broken or deformed, replace it.



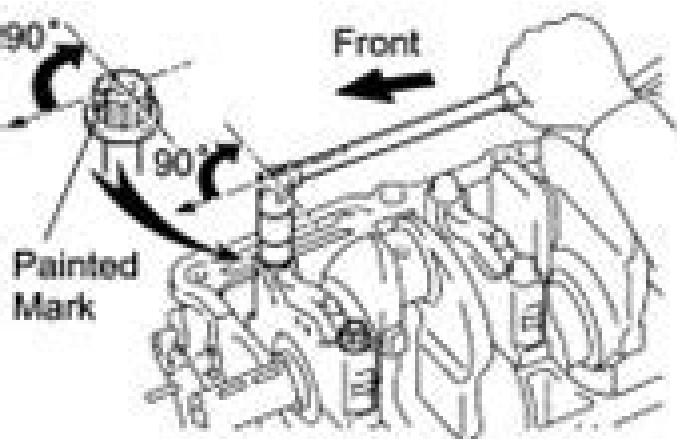
- (1) Apply a light coat of engine oil on the threads and under the main bearing cap bolts.
- (2) Install and uniformly tighten the 10 main bearing cap bolts in several passes, in the sequence shown.

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.

Intec November 2013 Exams Timetable

Victor M. Corman



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