









B1-50

- (5) Install the main bearing caps along with the lower main bearings according to the cap number and — mark.
- (6) Tighten the caps in two or three steps in the order in the figure.

Tightening torque: 82—88 Nm (8.4—9.0 m-kg, 61—65 ft-lb)

Caution

Do not rotate the crankshaft when measuring the oil clearances.

(7) Remove the main bearing caps, and measure the Plastigauge at each journal at the widest point for the smallest clearance, and at the narrowest point for the largest clearance. If the oil clearance exceeds specification, grind the crankshaft and use undersize main bearings. (Refer to page 81–44.)

Oil clearance No.1,2,4,5: 0.025—0.043mm (0.0010—0.0017 in) No.3: 0.031—0.049mm (0.0012—0.0019 in) Maximum: 0.08mm (0.0031 in)

- Apply a liberal amount of engine oil to the main bearings and main journals.
- Install the crankshaft and the main bearing caps according to the cap number and mark.
- Verify that the crankshaft rotates smoothly by hand.
- 5. Inspect the crankshaft end play.

End play: 0.08-0.18mm (0.0031-0.0071 in) Maximum: 0.30mm (0.0118 in)

If the end play exceeds specification, grind the crankshaft and use an undersize center main bearing.

Center main bearing width
Standard: 27.94—27.99mm (1.1000—1.1020 in)
0.25mm (0.010 in) undersize:
28.04—28.09mm (1.1040—1.1059 in)
0.50mm (0.020 in) undersize:
28.12—28.17mm (1.1071—1.1091 in)
0.75mm (0.030 in) undersize:
28.20—28.25mm (1.1102—1.1122 in)

Note Wider thrust width is available only in undersize center main bearing

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