

Measure the crankshaft end clearance.



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Crankshaft End Clearance - New or Reground

mm		in
0.10	MIN	0.004
0.50	MAX	0.020

Crankshafts that have been reground on the thrust bearing surfaces are marked for oversize thrust bearings on the rear crankshaft counterweight. If the crankshaft counterweight is marked, check the thrust ring part number to make sure the correct thrust ring size is used.

Example: F0.010 = front 0.25 mm (0.010 in)

Example: R0.020 = rear 0.51 mm (0.020 in)



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If the crankshaft end play is more than 0.50 mm (0.020 in), the engine **must** be removed to allow for replacement of the crankshaft. Refer to Procedure 000-001 (Engine Removal) in Section 0.



Isx Engine Manifold Bolt Torque Spec

S Ben Porath



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