

GENERAL DESCRIPTION AND FEATURES OF DESIGN

CYLINDER BLOCK AND CRANKCASE

The cylinder block and crankcase are cast in one piece, in order to permit more efficient cooling, by water jacketing the cylinders the full length of the bore. This construction results in a very rigid unit, which provides a sturdy support for the crankshaft.

The cylinder block is so designed as to be reversible; that is, the crankshaft may be installed in the crankcase so that the crankshaft may be on either the right-hand or the left-hand side of the engine. However, the timing gears and gear cover cannot be assembled to either end of the cylinder block. Therefore, it is essential that, when this engine is torn down for rebuilding, it be known and recorded which way the cylinder block is installed. That is, if the distributor or magneto is mounted on either the right or left-hand side of the engine.

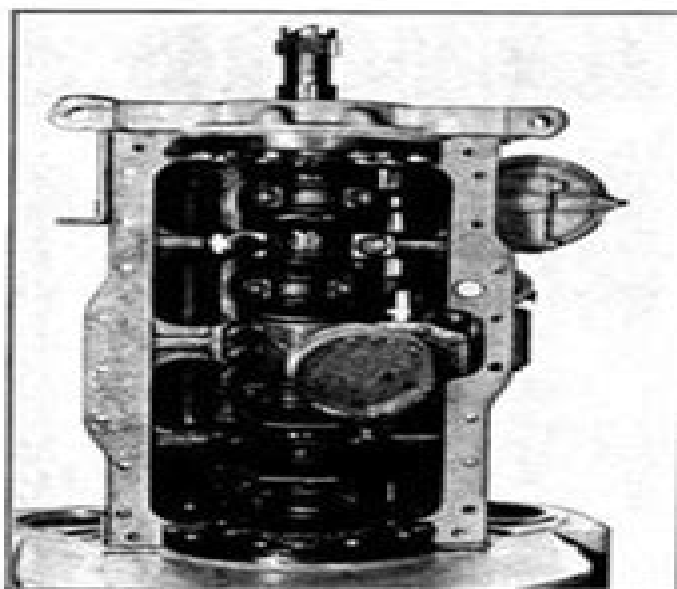


Illustration No. 1

MAIN BEARINGS

The four cylinder engine has five main bearings and the six cylinder has seven main bearings. This permits a main bearing being placed on each side of each connecting rod bearing, see Illustration No. 1. This construction helps to eliminate vibration at high speeds. The center main bearing cap is held in position by four alloy steel cap screws $\frac{1}{2}$ " in diameter, while the remaining bearing caps are held by two alloy steel cap screws $\frac{5}{16}$ " in diameter.

The crankshaft end thrust is controlled by the center main bearing. This shell has suitable flanges on both sides of the bearing, which form a thrust bearing.

Precision or insert type bearings are used; in this construction there is a removable shell in each cap, as well as for the upper part, and the upper shell is interchangeable with the lower shell for each bearing. These bearing shells are completely finished before being put in place and no line running or scraping is required. This allows removal of the bearings to be easily accomplished. Each bearing shell has a small ear or projection which fits into a recess in the cylinder block or cap, which allows the ear or projection to rest against the adjoining case or cap to prevent the shell from rocking or rotating. These shells are approximately $\frac{1}{16}$ " thick, and the bearing metals commonly used are harder and have a higher melting point than ordinary babbit metal. This permits the use of a hardened crankshaft.

CYLINDER HEAD

The cylinder head is a one piece casting and is detachable. The valve seats are a part of this casting while the valve guides are removable bushings. The head is held to the cylinder block by studs and screws; and, in order to insure against leaks, the head must be carefully drawn down by means of the stud nuts and screws which should be progressively tightened, working from the center of the head toward the ends.

A torque wrench is recommended for this operation. See "Wrench Tension" for recommended tensions. If a torque wrench is not available, a wrench approximately 18" long should be used for this operation.

Hercules G339 Engine Manual

Daniel F McAuley



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