

Crankshaft end play should be limited to .0025-.008 in.; see Fig. 26. If the end play exceeds .008 in., install a new thrust plate.

CRANKSHAFT

The crankshaft is a one-piece, heat-treated steel forging supported at either end by a carefully ground steel-backed babbitt bearing. The crankthrow bearing journals and main bearing journals are carefully ground to exact specifications. Each crankshaft is carefully balanced before installation in an engine. The shaft is drilled for oil passage to the main and connecting rod bearings. An oil seal is provided on each end to prevent oil leakage.

REMOVAL

With the engine removed, the crankshaft is



Fig. 27

removed as follows:

1. Remove oil can, see Fig. 27.
2. Remove clutch, flywheel and rear oil seal, see Fig. 28.
3. Remove cranking bolt, washer and pulley from the front of the crankshaft.
4. Remove the governor cover assembly.
5. Remove the oil breather tube assembly, see Fig. 24.
6. Disconnect the connecting rod bearing caps and remove all bearing shells.

Note: Keep all the bearing shells in order as they will have to be reassembled in the same order.

7. Remove the main bearing caps and shells.

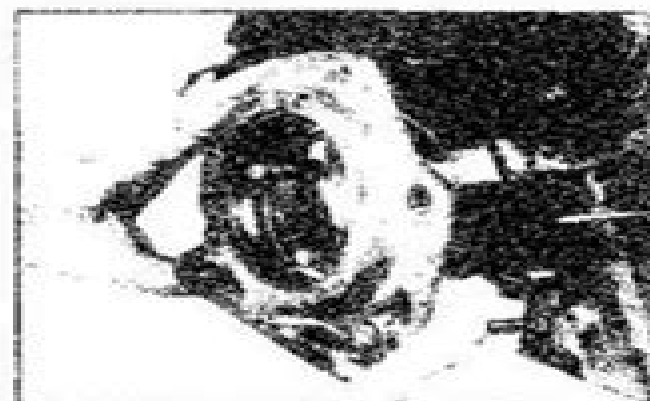


Fig. 28

The specifications for the crankshaft are as follows:

Main Bearing Journals- 1.999-2.000 in.

Connecting Rod Journals- 1.499-1.500 in.

The desired clearance between the main bearings and the crankshaft journals should be .0015-.0030 in. At no time should the clearance be less than .0015 in. or greater than .0032 in.

Longitudinal movement of the crankshaft during operation is termed "end play" and must

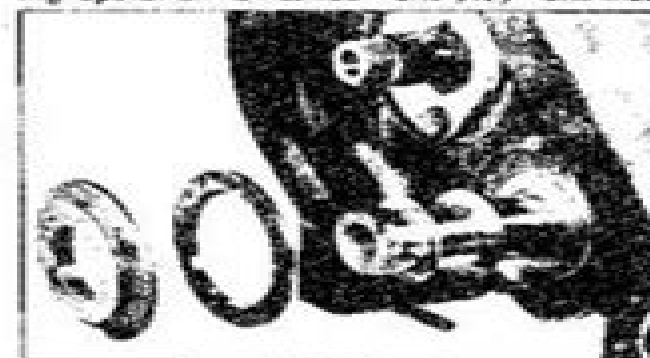


Fig. 29

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