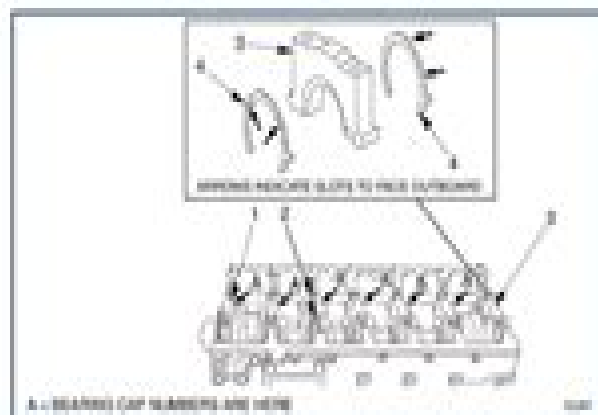


9. Position all the bearing caps (except the thrust master bearing cap) with their bearing shells in the crankcase properly. All the bearing caps fit over the crankpins in the side (left) crankcase. Make sure the numbers on the bearing caps are in ascending order, starting from the front of the engine. [\(See Figures 6220-1\)](#)



1. Bearing Cap	2. Thrust master Bearing Cap
3. Bearing Cap Bolt	4. Thrust master (crankcase) reducing slips in this order

Main Bearing Cap Markings

10. Measure the shaft length of the main bearing cap bolts. Replace any bolts that exceed the maximum size (4.77 in.). [\(See Figure 6220-2\)](#)



1. Main Bearing Cap Bolt

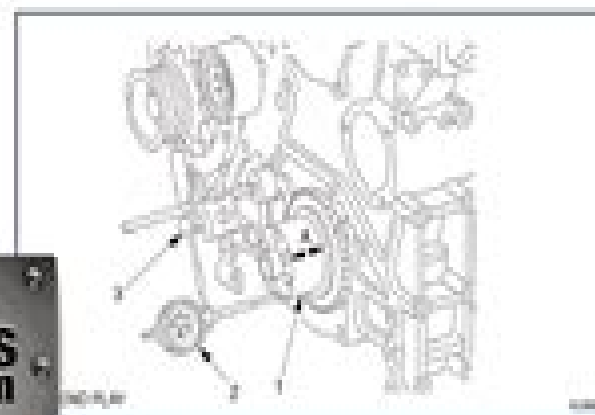
Measuring a Main Bearing Cap Bolt

11. Put a light coat of oil on the main bearing cap bolts. Turned at the M14 main bearing cap bolts. Tighten each one to the proper torque. [The tightening torque is listed on page 1.](#)

Max. Shaft Length	Tightening Torque	Target Value
2.63 in. (6.67 in.)	Stage 1	27.07 in. (2.0 in.)
	Stage 2	40.51 in. (2.0 in.)
	Stage 3	111.51 in. (2.0 in.)
	Stage 4	Additional 30 degrees

Tightening Torque, Main Bearing Cap Bolts

12. Install the thrust masters in the bearing cap, making sure the direction the thrust masters are facing is correct. [\(See Figure 6220-3\)](#)
13. Install the thrust master bearing cap. Tighten the bolts in stages in the same manner as the other bearing cap bolts.
14. Increase the crankshaft end play (crank clearance) in the thrust master bearing cap. [\(See Figure 6220-4\)](#)
1. Torque to 300 ft-lbs and a final torque to 400 ft-lbs.



1. Thrust Master	2. Thrust Master Bolt
------------------	-----------------------

Checking the Crankshaft End Play (Clearance)

1. Move the crankshaft at the way forward by pressing in one of the bearing caps. Then turn out the dial gauge. [\(See Figure 6220-5\)](#)
2. Turn the crankshaft at the way to the rear. Move the dial gauge to the dial gauge. [\(See Figure 6220-6\)](#)
3. If the dial gauge is not 0.00 in. to 0.01 in. (0.00 in. to 0.01 in.), replace the thrust masters with those of the same size thickness. Otherwise, the thrust masters are suitable.
10. Adjust the crankshaft gear to the crankshaft flange. [\(See Figure 6220-7\)](#) Adjust the bearing pin to the crankshaft with the bolt in the gear. Make sure the mark "1" on the crankshaft gear is between the markings "1" - "1" on the crankshaft gear. [\(See Figure 6220-8\)](#)

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