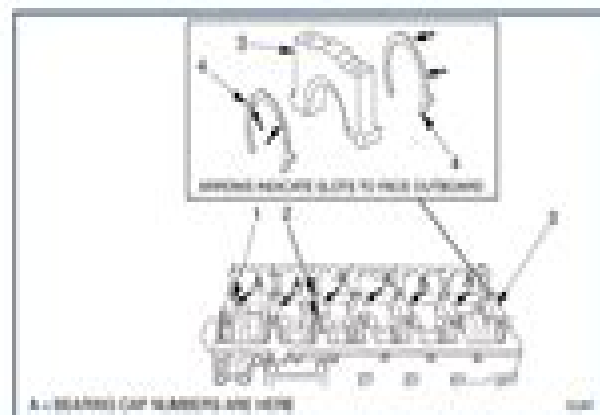


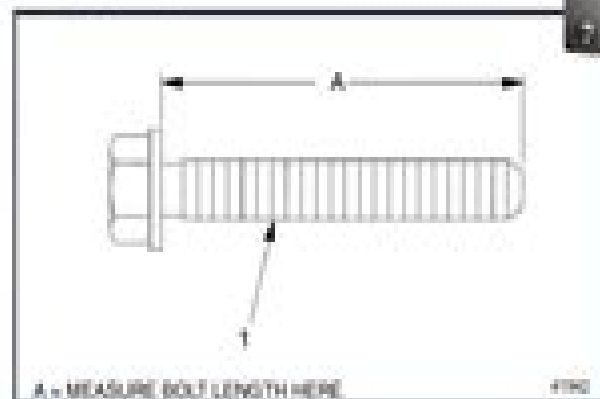
9. Position all the bearing caps (except the thrust master bearing cap) with their bearing shells in the crankcase properly. All the bearing caps fit over the crankpins in the side (left) crankcase. Make sure the numbers on the bearing caps are in ascending order, starting from the front of the engine. [\[See Figures A220\]](#)



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

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.). [\[See Figure A221\]](#)



1. Main Bearing Cap Bolt

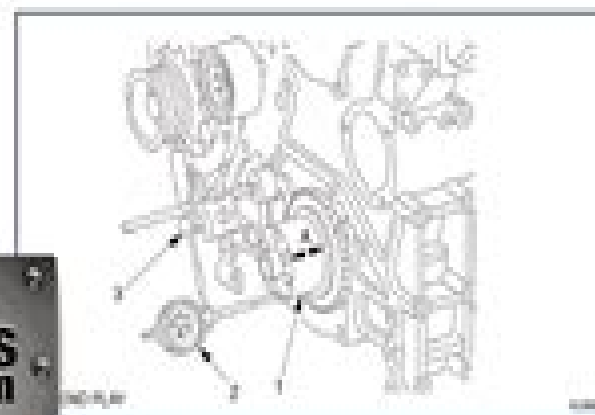
Measuring a Main Bearing Cap Bolt

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. [\[See Figures A222 and A223\]](#)

Max. Shaft Length	Tightening Torque	Target Value
2.63 in. (6.67 in.)	Stage 1	27.0 - 36.0 (N · m)
	Stage 2	40.0 - 50.0 (N · m)
	Stage 3	111.0 - 120.0 (N · m)
	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. [\[See Figure A224\]](#)
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 (clearance) at the thrust master bearing pin(s). [\[See Figures A225\]](#)
1. Torque to 300 ft-lbs and a final torque to 400 ft-lbs.



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

Checking the Crankshaft End Play (Clearance)

1. Move the crankshaft at the way determined by getting in rear of the bearing caps. Run down on the dial gauge. [\[See Figure A226\]](#)
2. Turn the crankshaft at the way to the rear. Move the dial gauge to the dial gauge. [\[See Figure A226\]](#)
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, thrust masters are available.
4. Adjust the crankshaft pin to the crankshaft flange. [\[See Figure A227\]](#)
5. Adjust the bearing pin to the crankshaft pin. [\[See Figure A228\]](#)

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1. Understanding the eBook Mbe 900 Engine Camshaft Service Manual
 - The Rise of Digital Reading Mbe 900 Engine Camshaft Service Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying Mbe 900 Engine Camshaft Service Manual
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Mbe 900 Engine Camshaft Service Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from Mbe 900 Engine Camshaft Service Manual
 - Personalized Recommendations
 - Mbe 900 Engine Camshaft Service Manual User Reviews and Ratings
 - Mbe 900 Engine Camshaft Service Manual and Bestseller Lists
5. Accessing Mbe 900 Engine Camshaft Service Manual Free and Paid eBooks
 - Mbe 900 Engine Camshaft Service Manual Public Domain eBooks

- Mbe 900 Engine Camshaft Service Manual eBook Subscription Services
- Mbe 900 Engine Camshaft Service Manual Budget-Friendly Options
- 6. Navigating Mbe 900 Engine Camshaft Service Manual eBook Formats
 - ePub, PDF, MOBI, and More
 - Mbe 900 Engine Camshaft Service Manual Compatibility with Devices
 - Mbe 900 Engine Camshaft Service Manual Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Mbe 900 Engine Camshaft Service Manual
 - Highlighting and Note-Taking Mbe 900 Engine Camshaft Service Manual
 - Interactive Elements Mbe 900 Engine Camshaft Service Manual
- 8. Staying Engaged with Mbe 900 Engine Camshaft Service Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Mbe 900 Engine Camshaft Service Manual
- 9. Balancing eBooks and Physical Books Mbe 900 Engine Camshaft Service Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Mbe 900 Engine Camshaft Service Manual
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Mbe 900 Engine Camshaft Service Manual
 - Setting Reading Goals Mbe 900 Engine Camshaft Service Manual
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Mbe 900 Engine Camshaft Service Manual
 - Fact-Checking eBook Content of Mbe 900 Engine Camshaft Service Manual
 - Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks

14. Embracing eBook Trends

- Integration of Multimedia Elements
- Interactive and Gamified eBooks

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