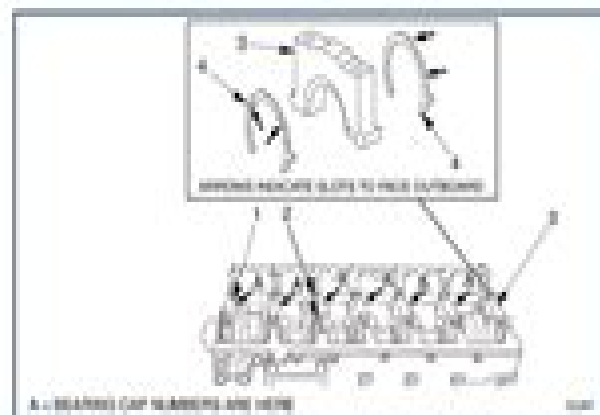


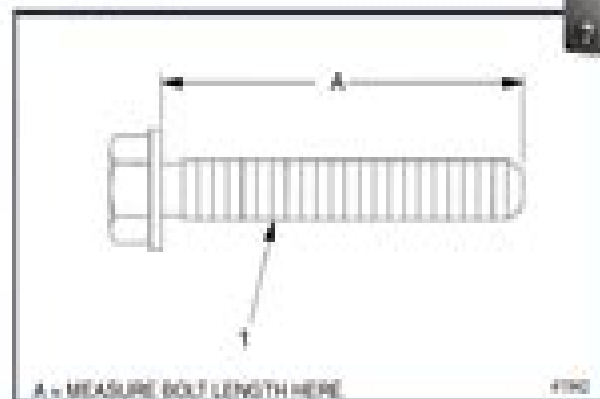
9. Position all the bearing caps (except the thrust master bearing cap) with their bearing shells in the crankcase properly. All the bearing caps fit over the crankpins in the side (left) crankcase. Make sure the numbers on the bearing caps are in ascending order, starting from the front of the engine.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



|                     |                                                          |
|---------------------|----------------------------------------------------------|
| 1. Bearing Cap      | 2. Thrust master Bearing Cap                             |
| 3. Bearing Cap Bolt | 4. Thrust master (crankcase) reducing slip 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.). [\[See Figure A221\]](#)



|                          |
|--------------------------|
| 1. Main Bearing Cap Bolt |
|--------------------------|

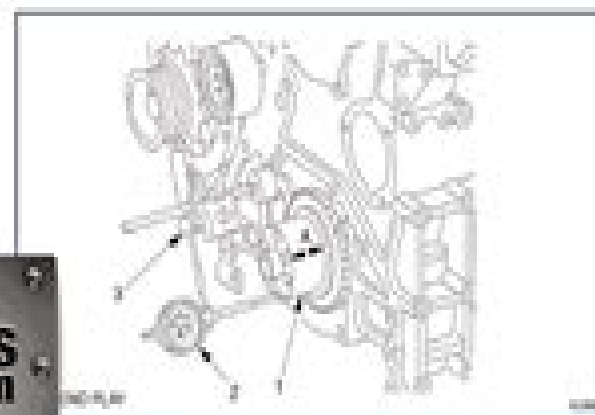
#### Measuring a Main Bearing Cap Bolt

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 - 30.0 ft. - lb.   |
|                     | Stage 2           | 40.0 - 45.0 ft. - lb.   |
|                     | Stage 3           | 110.0 - 120.0 ft. - lb. |
|                     | Stage 4           | Additional 30 degrees   |

#### Tightening Torque, Main Bearing Cap Bolts

12. Align the thrust masters in the bearing cap, making sure the direction the thrust masters are facing is correct. [\[See Figure A224\]](#)
13. Align 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 master) in the thrust master bearing cap. [\[See Figure A225\]](#)
1. Torque in 3rd stage and a final torque tighten. [\[See Figure A226\]](#)



|                  |                  |
|------------------|------------------|
| 1. Thrust Master | 2. Thrust Master |
| 3. Thrust Master | 4. Thrust Master |

#### Checking the Crankshaft End Play (Crank Endward)

1. Move the crankshaft at the way forward by getting in case of the bearing caps. Then turn out the dial gauge. [\[See Figure A227\]](#)
2. Turn the crankshaft at the way to the rear. Move the dial gauge to the dial gauge. [\[See Figure A228\]](#)
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 gear to the crankshaft flange. [\[See Figure A229\]](#)
5. Adjust the crankshaft gear to the crankshaft flange. [\[See Figure A230\]](#)

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# Mbe 900 Engine Camshaft Service Manual

**A Loxley**



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