

Installation

Position bearing inserts in cylinder block and main bearing caps with the tang on the insert engaged in the slot in the cylinder block and main bearing caps (Fig. 7).

Apply a coat of clean engine oil to the bearing surface of the inserts.

Position crankshaft in cylinder block.

NOTE: Tangs on main bearing halves in main bearing caps must be positioned to the same side of the crankshaft as the tangs on main bearing halves in cylinder block.

Install main bearing caps with numbers (1, Fig. 8) corresponding to numbers in oil pan rail (2). If there is no arrow (3) machined on main bearing cap, install cap with number to same side as numbers in oil pan rail. If there is an arrow machined on main bearing cap, arrow must point toward camshaft side.

Dip main bearing cap screws in clean engine oil and position them in the main bearing caps.

IMPORTANT: Do not use pneumatic wrench to install main bearing cap screws.

Before tightening cap screws on main bearing caps, align upper and lower thrust flanges on main thrust bearings. Using a soft-face hammer, tap crankshaft to the rear and then to the front to line up thrust bearing flanges.

Rotate crankshaft by hand. Crankshaft should rotate with little effort.

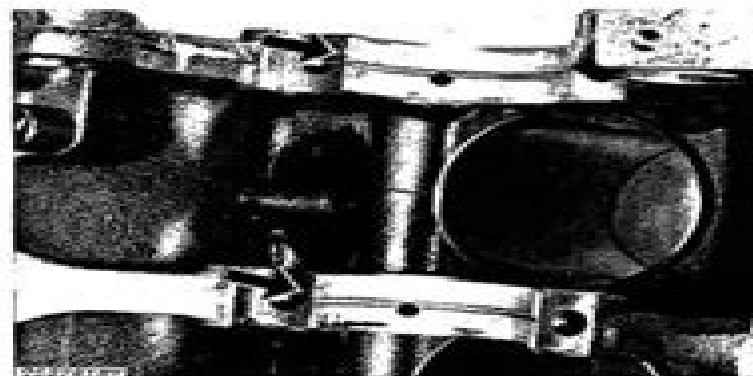


Fig. 7—Main Bearing Insert Installation



Fig. 8—Main Bearing Cap Positions

John Deere Engine Manual

Camilla Rothe



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Field Manuals United States. War Department, 1948 **Unit, Direct Support and General Support Maintenance Manual: Diesel Engine, Model 6068TF151, 6 Cylinder 6.8 Liter (NSN:2815-01-462-3596) (EIC:N/A) ,** *Diesel Servicing (D.O.T. Occupational Code 625.281)* G. O. Anderson, 1969 , **Catalog of Copyright Entries. Third Series** Library of Congress. Copyright Office, 1954 Includes Part 1A Number 1 Books January June and Part 1B Number 1 Pamphlets Serials and Contributions to Periodicals January June Agricultural Education , 1972 Operator's, Organizational, Direct Support, and General Support Maintenance Manual (including Repair Parts List) , 1982 *The eBay Price Guide* Julia L. Wilkinson, 2006 Provides lists of selling prices of items found on eBay in such categories as antiques boats books cameras coins collectibles dolls DVDs real estate stamps tickets and video games *Monthly Catalog of United States Government Publications* , 2004 **Monthly Catalogue, United States Public Documents** , 1989-03 *Popular Science* , 1983-08

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