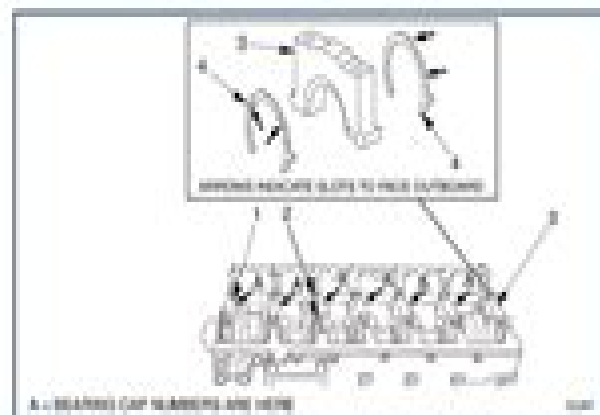


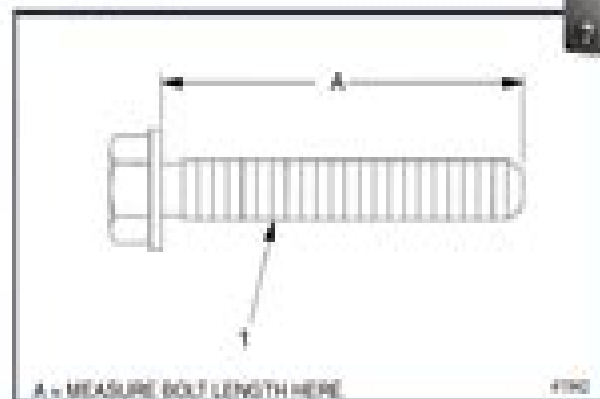
9. Position all the bearing caps (except the thrust master bearing cap) with their bearing shells in the crankcase position. All the bearing caps fit over the crankpins in the side (left) crankcase. Make sure the numbers on the bearing caps are in ascending order, starting from the front of the engine.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



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

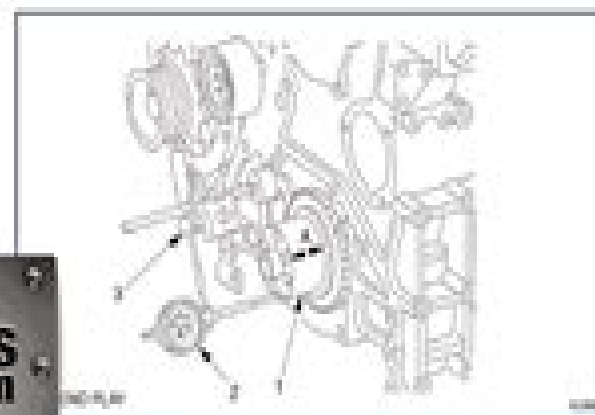
Measuring a Main Bearing Cap Bolt

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. 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 30 ft. - lb. and a final torque factor. [\[See Figures A226\]](#)



1. Thrust Master	2. Thrust Master
3. Thrust Master	4. Thrust Master

Checking the Crankshaft End Play (Clearance)

1. Move the crankshaft all the way forward by jacking up one of the bearing caps. Then turn out the dial gauge. [\[See Figure A227\]](#)
2. Turn the crankshaft all the way to the rear. Move the dial gauge to the dial gauge. [\[See Figure A228\]](#)
3. If the dial gauge is set 0.01 in. to 0.02 in. (0.025 in. to 0.05 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. [\[See Figure A229\]](#)
5. Adjust the bearing pin to the crankshaft pin. [\[See Figure A230\]](#)

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