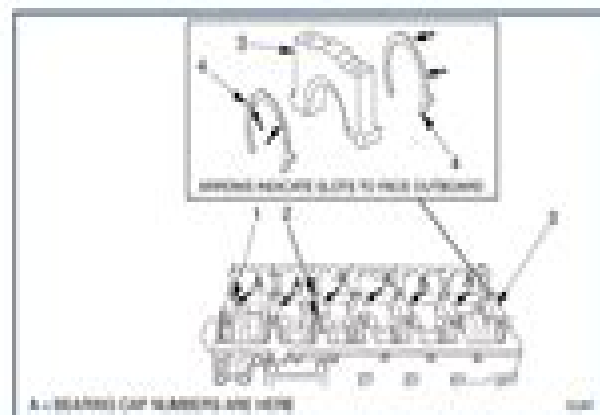


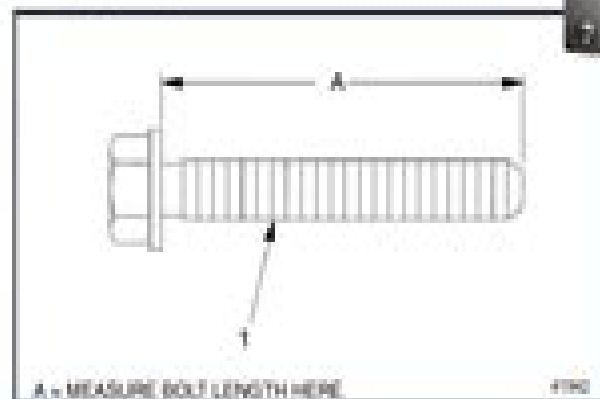
9. Position all the bearing caps (except the thrust master bearing cap) with their bearing shells in the crankcase properly. All the bearing caps fit over the crankpins in the side (left) crankcase. Make sure the numbers on the bearing caps are in ascending order, starting from the front of the engine. [\(See Figures 4220-4221\)](#)



1. Bearing Cap	10. Thrust master bearing cap
2. Bearing Cap Bolt	9. Thrust master (crankpin) reducing slot in the cap

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.). [\(See Figure 4222\)](#)



1. Main Bearing Cap Bolt

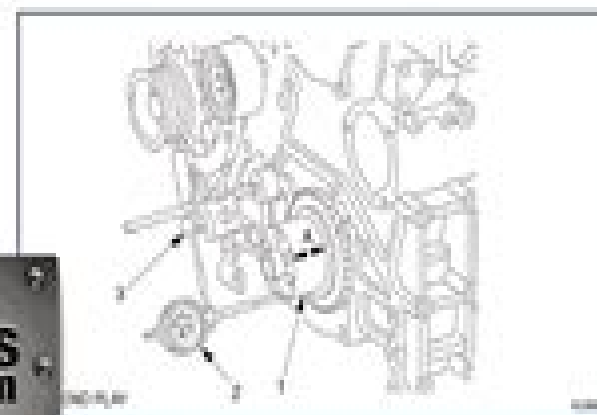
Measuring a Main Bearing Cap Bolt

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.](#)

Min. 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. Spread the thrust washers in the bearing cap, making sure the slots on the thrust washers are facing outward. [\(See Figure 4223\)](#)
13. Spread 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. [\(See Figure 4224\)](#)
1. Torque in 30-degree and a final torque torque. [\(See Figure 4225\)](#)



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

Flushing the Crankshaft End Play (Crank Clearance)

1. Move the crankshaft at the way forward by pressing in one of the bearing caps. Then turn out the final groups. [\(See Figure 4226\)](#)
2. Move the crankshaft at the way to the rear. Move the multiplier on the final groups. [\(See Figure 4227\)](#)
3. If the multiplier is not 0.1 in. (0.1 in.) or 0.1 in. (0.1 in.), replace the thrust washers with those of the same size thickness. Otherwise, the thrust washers are suitable.
4. Adjust the crankshaft gear to the crankshaft flange. [\(See Figure 4228\)](#)
5. Adjust the bearing pin to the crankshaft flange. [\(See Figure 4229\)](#)

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A red circular graphic with a gradient, appearing as a partial circle or a stylized 'C' shape, located to the right of the text 'O and R Engines, Incorporated'.

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