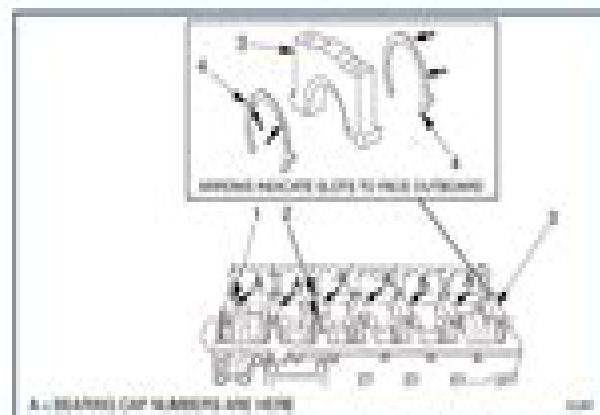


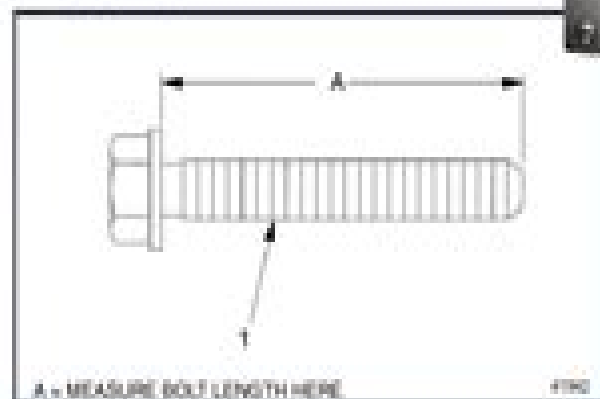
9. Position all the bearing caps (except the thrust master bearing cap) with their bearing shells in the crankcase position. All the bearing caps fit over the crankpins in the side (left) crankcase. Make sure the numbers on the bearing caps are in ascending order, starting from the front of the engine.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



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

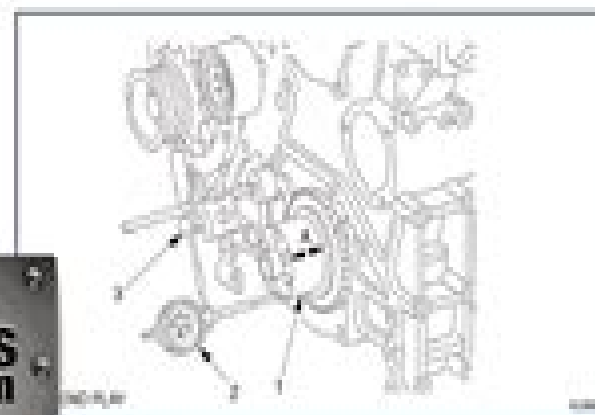
Measuring a Main Bearing Cap Bolt

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. [The tightening torque is listed in Table 1.](#)

Max. Shaft Length	Tightening Torque	Target Value
2.63 in. (6.67 in.)	Stage 1	27.0 - 36.0 ft. - lb.
	Stage 2	40.0 - 50.0 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. [\(See Figure A222\)](#)
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). [\(See Figure A223\)](#)
1. Turn up the gap and a feeler gauge feeler. [\(See Figure A223\)](#)



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

Flushing the Crankshaft End Play (Clearance)

1. Move the crankshaft at the way forward by getting in one of the bearing caps. Run down on the feeler gauge. [\(See Figure A224\)](#)
2. Turn the crankshaft at the way to the rear. Move the feeler gauge to the feeler gauge. [\(See Figure A224\)](#)
3. If the feeler gauge is not 0.001 in. to 0.002 in. (0.001 in. to 0.002 in.), replace the thrust masters with those of the same size thickness. Otherwise, the thrust masters are suitable.
15. Adjust the crankshaft pin to the crankshaft flange. [\(See Figure A225\)](#) Adjust the bearing pin to the crankshaft with the bolt in the pin. Make sure the mark "1" on the crankshaft pin is between the markings "1 - 1" on the crankshaft pin. [\(See Figure A225\)](#)

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