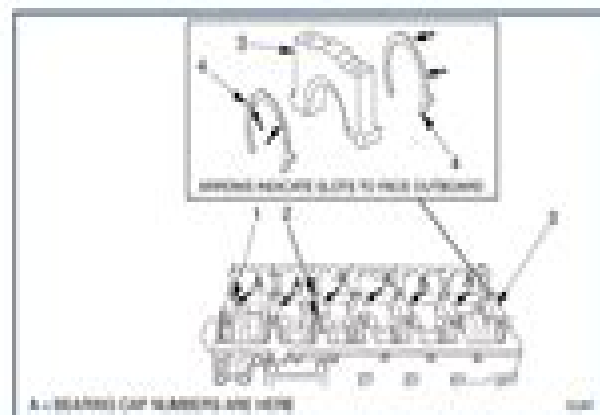


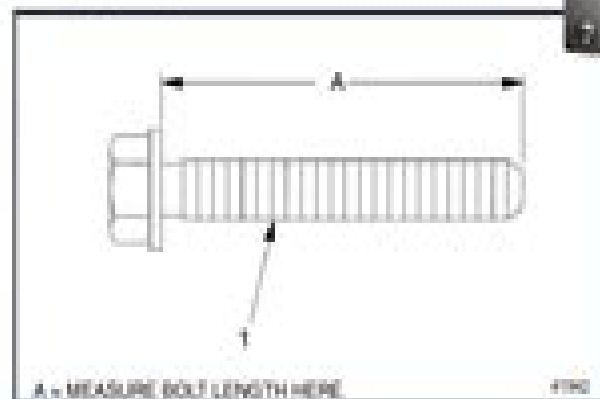
9. Position all the bearing caps (except the thrust master bearing cap) with their bearing shells in the crankcase ports. All the bearing caps fit over the crankcase at the side (off-center). Make sure the numbers on the bearing caps are in ascending order, starting from the front of the engine. [\[See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



| | |
|---------------------|---|
| 1. Bearing Cap | 2. Thrust master Bearing Cap |
| 3. Bearing Cap Bolt | 4. Thrust master (crankcase side) cap 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 |
|--------------------------|

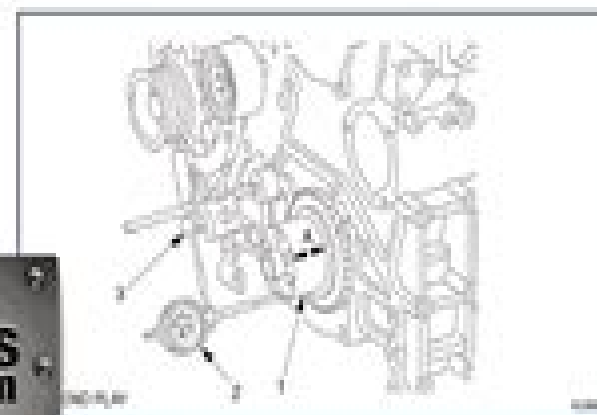
Measuring a Main Bearing Cap Bolt

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. [\[See Figure A222\]](#)

| Min. Shaft Length | Tightening Torque | Target Value |
|---------------------|-------------------|-----------------------|
| 2.63 in. (6.67 in.) | Stage 1 | 27.07 in. (2.0 in.) |
| | Stage 2 | 28.57 in. (2.0 in.) |
| | Stage 3 | 33.57 in. (2.0 in.) |
| | Stage 4 | additional 30 degrees |

Tightening Torque, Main Bearing Cap Bolts

12. Spread the thrust masters in the bearing cap, making sure the direction the thrust masters are facing is correct. [\[See Figure A223\]](#)
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 master) in the thrust master bearing cap. [\[See Figure A224\]](#)
1. Torque in 3rd stage and a final torque tighter. [\[See Figure A225\]](#)



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

Flushing the Crankshaft End Play (Crank Master)

1. Move the crankshaft at the way forward by getting in one of the bearing caps. Run each one to the final torque. [\[See Figure A226\]](#)
2. Move the crankshaft at the way to the rear. Move the multiplier on the final torque. [\[See Figure A227\]](#)
3. If the multiplier is not 0.1 in. (0.1 in.) or 0.1 in. (0.1 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. [\[See Figure A228\]](#)
5. Adjust the bearing cap to the crankshaft with the bolt in the gear. Make sure the mark "1" on the crankshaft gear is between the markings "1 - 1" on the crankshaft gear. [\[See Figure A229\]](#)

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