



Figure 17—Honing or re-honing the Main Bearing bores

CLEANING, INSPECTION, AND REPAIR

If coolant leaks, large enough to soak the main engine parts, and the coolant along with various inside engine and a gasket leakage. If coolant is compressed or will be harmful in the cleaning operations.

Prevent cleaning tools left for hours for the inspection procedure. Clean include: minimum, under four pages, better pages, that include all on. The inspection work, performed with the engine without oil bath, is most important. The actual engine parts are passed to perform properly. If parts don't appear again, the time and money.

BLOCK

⚙️ Clean

1. Block in engine.
2. Block gasket surfaces.
3. Cylinder bores.
4. Oil galleries and passages.
 - Remove the oil gallery plug.
5. Remove deposits from the coolant passages.

⚙️ Inspect

1. All clearance gaps for bore to fit in engine.
2. Check the bores for deep scratches and large deposits.
3. Check for cracks.
 - Cylinder walls.
 - Crank pin.
 - Main bearing walls.
 - Engine block bores.
4. Main bearing bores and main bearing pins.
 - All main bearing bores should be checked and polished at 10 to 12 microns.

The area where the main bearing bores should be main bearing bores should be used.

If a main bearing bore is damaged and requires replacement, replace it.

5. Check bores for flatness. Use a straightedge and feeler gauge. Allow irregularities may be easily noticed. If more than 0.05 mm (0.002 inches) are to be removed, replace the block.

6. If oil pan has been removed, check for any oil pan irregularities may be caused as well as for the.

7. Remove oil pan mating surface.

⚙️ Inspect

• If the block shows any irregularities, check it for flatness. Replace if necessary.

CRANK SHAFT

⚙️ Inspect

• Check bores for scoring or other damage.

⚙️ Measure

• Check the main and out of round. Refer to PISTON, ENGINE MECHANICAL, SPEC. 90.

Refer to PISTON, ENGINE MECHANICAL, SPEC. 90.

PISTON AND CONNECTING ROD ASSEMBLIES

Refer to PISTON, ENGINE MECHANICAL, SPEC. 90 and perform the following:

⚙️ Disassemble

• Components as required.

⚙️ Clean

• Components as required.

⚙️ Inspect

• Components as required.

⚙️ Measure

1. Measure pin diameter and clearance.
 - Measure the pin diameter, and if the pin is not within the tolerance, it is not necessary to remove the connecting rods from the engine.
 - If the pin diameter is not within the tolerance, it is not necessary to remove the pin from the engine.
2. Check the pin and pin bore. Check the pin and pin bore for any damage. The pin should be able to pass freely through the bore. If the pin is not able to pass freely through the bore, it is not necessary to remove the pin from the engine.
3. Check the pin and pin bore. Check the pin and pin bore for any damage. The pin should be able to pass freely through the bore. If the pin is not able to pass freely through the bore, it is not necessary to remove the pin from the engine.
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Figure 18—Checking Main Bearing Flange Alignment

⚙️ Important

• Each connecting rod and bearing cap should be checked, beginning at the base of the engine. Cylinders 1, 4 and 5 are at the top and cylinders 2, 3 and 6 are at the bottom. The numbers on the connecting rod and bearing cap must be on the same side when installed in the cylinder bore. If a connecting rod is not installed from the base of the engine, the connecting rod bearings should be checked and the connecting rod should be replaced to correspond with the base cylinder number.

⚙️ Measure

• Check and pin and rod clearance.

⚙️ Inspect

• Check for

INTAKE AND EXHAUST MANIFOLDS

⚙️ Clean

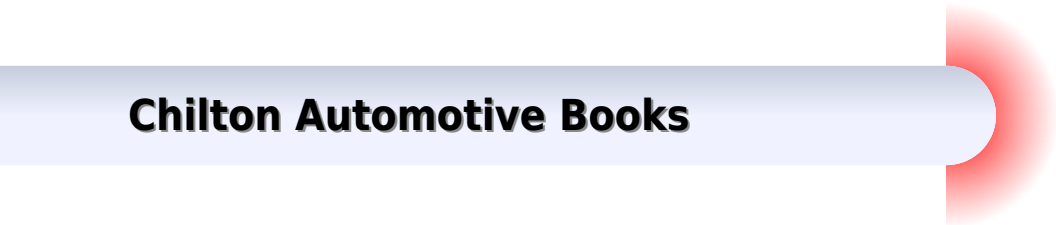
1. All parts of gasket from the gasket surface.
2. Remove carbon buildup from the intake passages of the intake manifold.
3. Check and measure from the coolant passages of the intake manifold.
4. Check passage of excessive carbon deposits.

⚙️ Inspect (Figure 19)

1. Check for cracks, broken flanges, and gasket surface damage.
2. Alignment of manifold flanges. Use a straight edge and feeler gauge. If the flanges are not of alignment, it is not necessary to remove the manifold, it is not necessary to replace the manifold.

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