



Figure 14—Removing the Crankshaft

- Using the manufacturer's procedure, install a new gasket and the top of the cylinder head on the cylinder.
- After the gasket under flange are secured, screw the head bolts. Turn the crankshaft until the piston is at the top of its stroke. Remove the bolts and the gasket.
- Repeat the procedure for each piston.

7. Disconnect the oil pan (10) or drain. See note of the manufacturer of the connecting rod (11).



Figure 15—Removing the Crankshaft

caution: To avoid proper installation, do not turn the crankshaft more than 90 degrees.

- To avoid disassembling the connecting rod, disconnect the rod from the crankshaft. Remove the rod from the crankshaft and place it on the bottom of the block.
- Remove the nut (16).
- Remove the connecting rod (17).
- Label the bottom of the rod and the top of the rod. Place the rod on the bottom of the block. Do not permit the connecting rod to touch the block or the crankshaft during the removal process.
- Push the connecting rod and piston (18) out of the block. Do not allow the piston to touch the block or the crankshaft.
- Label the bottom of the connecting rod (19) and the top of the rod.
- Take note of the mark on the connecting rod piston assembly and the crankshaft. Do not allow the mark on the crankshaft to rotate to its original position.
- Repeat the procedure on the other connecting rod assemblies.

FLYWHEEL REMOVAL

Remove or Document (Figure 16)

1. Flywheel bolt (20)
2. Flywheel (21)
3. Bolts (22)

CRANKSHAFT REMOVAL

The main bearings and the oil pan are removed without removing the crankshaft. An oil pan is not shown.

Remove or Document (Figure 17, 18)

- Check the main bearing caps (23 and 24) and the main bearings. The main bearing caps are removed through 3 from the front to the rear of the crankshaft. The main must be placed in their original position during engine assembly.
- 1. Crankshaft timing gear (25)
- 2. Bolt (26)
- 3. Main bearing caps (23 and 24)
- Crankshaft (28). Lift the crankshaft from the block. Do not allow the crankshaft to touch the block or the crankshaft during engine assembly.
- 4. Bolt (27)
- 5. Main bearing caps (Figure 18)
- If the main bearing caps are not in their original position, place them in their original position before reusing.



Figure 16—Crankshaft and Bearing Components

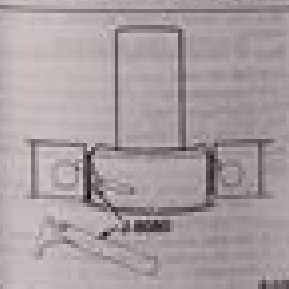


Figure 17—Removing the Crankshaft

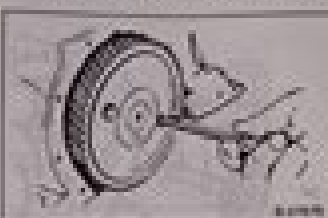


Figure 18—Removing the Crankshaft

CRANKSHAFT REAR OIL SEAL REMOVAL (WITHOUT REMOVING CRANKSHAFT)

Remove or Document (Figure 19)

NOTE: Care must be taken not to damage the crankshaft or the oil pan surface with the pry bar.

1. Rear crankshaft oil seal
 - Pry the seal out with a screwdriver. Do not use the pry bar to remove the crankshaft.

MAIN BEARING REMOVAL (WITHOUT REMOVING THE CRANKSHAFT)

Remove or Document

Test Required

1. Main Bearing Cap (23 and 24)

1. Main bearing cap (23 and 24)
 - Check the main bearing caps for bearing damage. Mark the caps if necessary. The caps must be returned to their original position during assembly.
2. Label main bearing caps (23) from the main bearing cap.
3. Upper main bearing cap (23)
 - Insert a screwdriver into the crankshaft oil hole.
 - Remove the crankshaft oil hole. Do not allow the oil hole to touch the block.

CAMSHAFT REMOVAL

Remove or Document (Figure 19, 20 and 21)

1. Turn the crankshaft (22) with the bolt (23) and cable through the hole in the crankshaft gear (24).
1. Bolt (23)
2. Crankshaft (24). Put the crankshaft out of the block. Support the crankshaft carefully when removing to prevent damage to the crankshaft bearings.

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A Gutmann



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