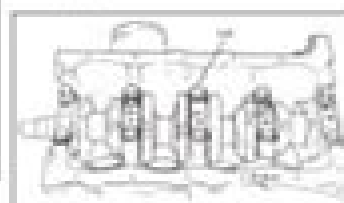
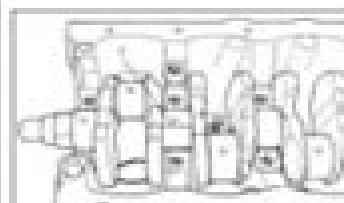


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ENGINE MOUNTING



Main Bearings

General Information

- Service main bearings are available in sizes and 0.25 mm differences.
- Upper bearing (2) is in figure.
- Lower bearing (1) is in figure.

On each main bearing cap, arrow mark and number are indicated as shown in figure.

When installing each bearing cap to cylinder block, point arrow mark toward crankshaft pulley side and install each cap from that side to flywheel side in ascending order of numbers "1", "2", "3", "4" and "5". Tighten cap bolts to specified torque.

Inspection

Check bearings for pitting, scratches, wear or damage. If any malfunction is found, replace both upper and lower halves. Never replace one half without replacing the other half.

Main bearing clearance

Check clearance by using plastigauge (1) according to following procedure.

- Remove bearing caps.
- Clean bearings and main journals.
- Place a piece of plastigauge to full width of bearing parallel to crankshaft or journal, avoiding oil hole.

- Install bearing cap as previously outlined and evenly torque cap bolts to specified torque.
- Bearing cap **MUST** be torqued to specification in order to ensure proper seating of clearance.

Tightening Torque

(1) 54 Nm (5.4 kg-m, 39.0 lb-ft)

NOTE:

Do not rotate crankshaft while plastigauge is installed.

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**Larry Warren, Doug Dodge, John Harold
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