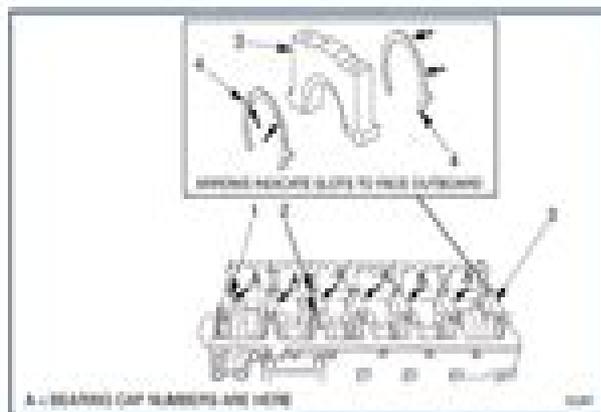


8. Position all the bearing caps (using the three-rod bearing caps) with their bearing shells in the crankcase position. All the bearing caps fit over the crankcase in the side (left) position. Make sure the numbers on the bearing caps are in ascending order, starting from the front of the engine. (See [Table A-2](#).)



1. Bearing Cap	2. Three-rod Bearing Cap
3. Bearing Cap Bolt	4. Three-rod journal end cap nut in the crankcase

Main Bearing Cap Markings

9. Measure the shaft length of the main bearing cap bolts. Replace any bolts that need to be replaced for standard size (4.77 in.) (See [Figure A-23](#).)



1. Main Bearing Cap Bolt

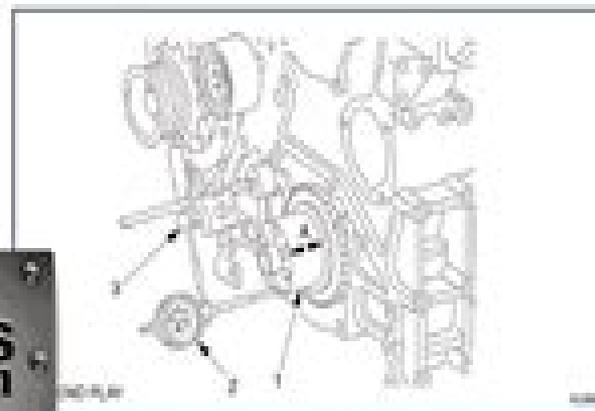
Measuring a Main Bearing Cap Bolt

11. Put a light coat of oil on the main bearing cap bolts. Remove all the M14 main bearing cap bolts. Tighten each one to the proper [torque](#). The tightening torque is listed in [Table A-3](#).

Min. Shaft Length	Tightening Torque	Target Value
4.77 in. (121 mm)	Stage 1	27.7 ft. lb. (37.6 N. m)
	Stage 2	40.5 ft. lb. (54.8 N. m)
	Stage 3	111.5 ft. lb. (151.6 N. m)
	Stage 4	additional 30 degrees

Tightening Torque (Main Bearing Cap Bolt)

12. Install the three-rod bearing in the bearing cap, making sure the slots on the three-rod bearing are facing outward. (See [Figure A-24](#).)
13. Install the three-rod bearing cap. Tighten the bolts in stages in the same manner as the other bearing cap bolts.
14. Measure the crankshaft end gap (crank clearance) in the three-rod bearing position. (See [Figure A-25](#).)
1. Torque to 80 ft. lb. and a final torque factor. (See [Table A-25](#).)



1. Crankshaft	2. End Gap Gauge
3. Feeler Gauge	

Checking the Crankshaft End Play (Clearance)

1. Move the crankshaft all the way forward by pulling in one of the bearing caps. Then zero out the feeler gauge. (See [Figure A-26](#).)
2. Move the crankshaft all the way to the rear. Then the feeler gauge on the feeler gauge. (See [Figure A-26](#).)
3. If the end play is not 0.010 in. to 0.015 in. (0.254 mm to 0.381 mm), replace the three-rod bearing with those of the necessary thickness. Otherwise, crankshaft wear may exist.
4. Adjust the crankshaft pin in the crankshaft flange. Rotate in position. Adjust the bearing pin in the crankshaft with the bolts in the pin. Make sure the mark "1" on the crankshaft pin is between the markings "1 - 1" on the crankshaft pin. (See [Figure A-26](#).)

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