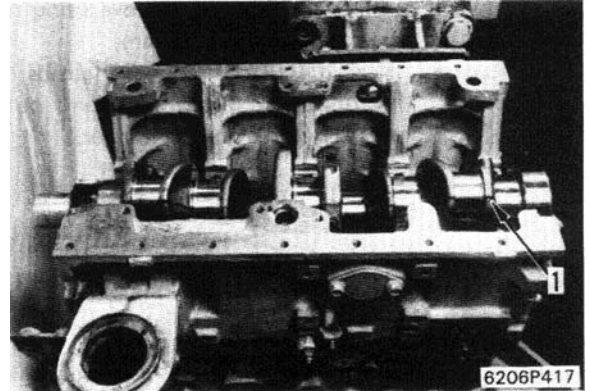


- 2) Taking care not to hit crankshaft (1) against cylinder block, set crankshaft in mounting position.

★ If the crankshaft gear has been replaced, insert the crankshaft gear in an electric furnace and heat at 230 – 250°C for about 30 minutes, then shrink fit the gear.



4. Main bearing cap

- 1) Align protrusion in lower main bearing (2) with notch in cap, then install main bearing cap (3).

★ Check that there is no dirt or dust stuck to the rear face of the bearing. Coat the inside face of the bearing with engine oil (SAE30) before assembling.

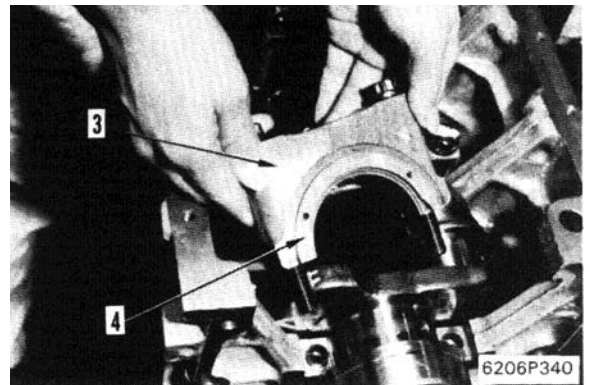
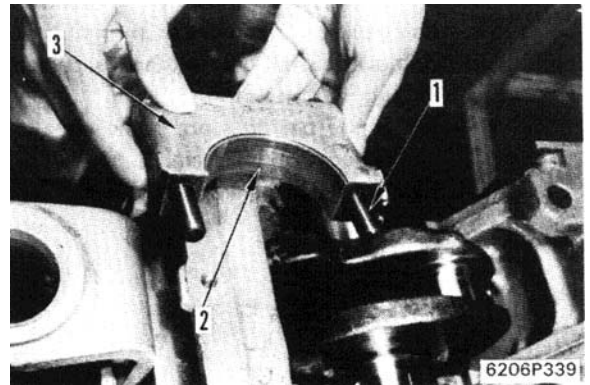
- 2) Check that number stamped on main bearing cap is the same as number on cylinder block.

- 3) Set casting number of main bearing cap facing front, and assemble with mounting bolt (1).

- 4) Align lower thrust bearing (4) with dowel pin, then install in main bearing cap (3).

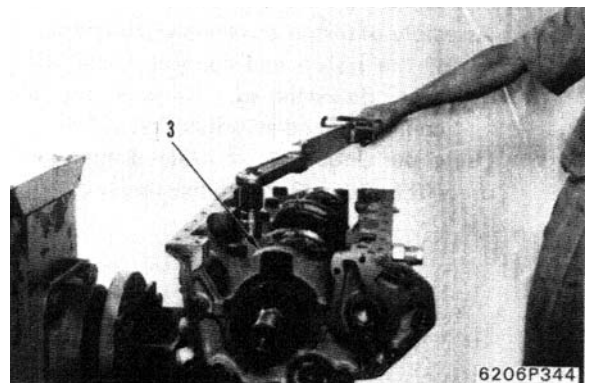
★ Assemble two pieces at the top and bottom at the flywheel end, and one piece at the opposite end.

★ Install each thrust bearing with the oil groove on the outside.



- 5) Set casting number facing front, and install main bearing cap (3).

★ Be careful not to let the thrust bearings slip out of place.

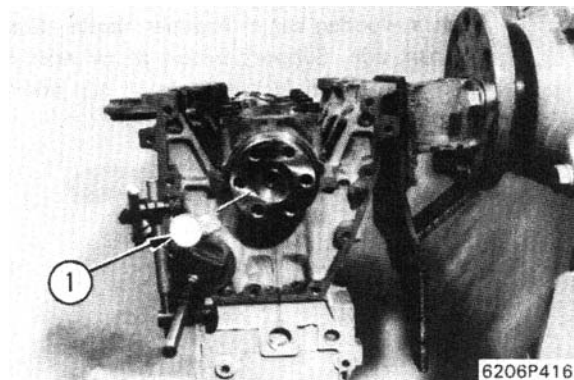


- 6) Tighten mounting bolts of main bearing cap with a torque wrench as follows.
- ★ Coat the bolt thread and seat face with engine oil.
 - ★ When tightening the mounting bolts of the main bearing cap, start in the middle and work to the outside. Tighten to the following torque.

⏏ Mounting bolt of main bearing cap
Unit: Nm {kgm}

Order	Target	Range
1st step	112.8 {11.5}	107.9 – 117.7 {11 – 12}
2nd step	0	Loosen completely
3rd step	132.4 {13.5}	127.5 – 137.3 {13 – 14}

- ★ After tightening the mounting bolts, check that the crankshaft rotates smoothly.
- 7) Measuring end play of crankshaft
Put probe of dial gauge [1] in contact with end face of crankshaft. Read movement of gauge when crankshaft is moved forward and backward.
- ★ Permissible range of end play: 0.13 – 0.35 mm



5. Piston, connecting rod assembly

- 1) Assembly of piston and connecting rod assembly.
- ★ If the piston and connecting rod assembly has been disassembled, assemble the piston and connecting rod assembly first as follows.
- i) Using push tool [2] (outside diameter: 32 mm), press fit bushing (8) on connecting rod.

