



Crankshaft end play is adjusted by shoulder washers. These are provided with a projecting gasket surface. The rings can also be removed after a crankshaft overhaul.

Each main bearing consists of two shells, each of which is secured to the block by two screws. The upper bearing shell is provided with a gasket surface.

Main bearing caps are positioned according to the position of the crankshaft and are secured by the main bearing screws. These can only be replaced with the same.

### Checking crankshaft

After the crankshaft has been thoroughly cleaned, check it as follows:

Ascertain that the main and big end journals are round and secure. Otherwise it will be necessary to grind again. If the crankshaft is cracked it must be replaced.

Using a micrometer gauge make sure the main journals are not below the specifications given in the manual. If a regrinding should be performed.

### Checking crankshaft journal out-of-round taper

Using a micrometer gauge, measure a round crankshaft journal and out-of-roundness. If readings exceed the allowances specified, grind again.

### Checking the shells

Clean shells carefully and then examine the journal surfaces. Polishing, scoring, scratching or evident wear. If any, replace the main bearings.

Check shell inside diameters with an internal micrometer. If diameters are found in excess of the maximum, the main bearings shall be replaced.

The shells are supplied as spare parts either with or without gaskets.



Clearance should be the tolerance is 1 mm (0.039 inch) and the tolerance is 0.1 mm (0.0039 inch). The tolerance is 0.1 mm (0.0039 inch) and the tolerance is 0.1 mm (0.0039 inch).

### Checking crankshaft and cylinder block internal passages

Clearing of the lubricating oil passages should be made after all crankshaft and cylinder block overhauling operations have been completed. This clearing can be carried out by using compressed air or compressed oil forced into the passages.

### Checking crankshaft end play

End play is checked by using a magnetic base comparator and measuring as follows:

Place the magnetic base to the crankshaft and put the comparator feeler in contact with one of the crankshaft ends.

Use a lever to move the crankshaft axially towards the comparator side until the comparator reading indicator stops moving.

Zero the comparator and push the crankshaft with the lever towards the opposite side and then take the end play reading from the comparator dial.

The reading should be between 0.10 to 0.27 mm. If higher than specified, it should be replaced. The tolerance is 0.1 mm (0.0039 inch) and the tolerance is 0.1 mm (0.0039 inch).

Regular section gaskets should protrude as shown in the figure.

The rear portion of the crankshaft is provided with a 3x30° chamfer. Before the surface contacting the sealing ring has undergone the grinding process. For this reason, the sealing ring can now be mounted without using no. 5.0000 520.0 equipment.

The front pulley leading hub is provided with a 3x30° chamfer and the sealing ring working surface is polished.



Fig. 36 - Checking crankshaft end play



Fig. 37 - Main bearing cap gasket installation



Fig. 38 - Polishing the main bearing shell

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