

Main bearings

To dismantle and to assemble

Operation 5-4

Engine	Torque Nm (24.5) kgf m
400C-11	Bearing holder setcrew 29 (18) 0.23
400C-18, 404C-22 and 404C-22T	Bearing holder setcrew 57 (34) 0.3

End float

If the end float is greater than the service limit check the thrust washers for wear.

Note: Item (1) only used on 404C-22 and 404C-22T.

Engine	Standard clearance	Service limit
400C-11	0.10 - 0.30 mm (0.0040 - 0.0118 in)	0.80 mm (0.0315 in)
400C-18, 404C-22 and 404C-22T	0.10 - 0.40 mm (0.0040 - 0.0157 in)	0.80 mm (0.0315 in)

Engine	Thrust washer thickness	Service limit
400C-11	21.88 - 21.98 mm (0.8613 - 0.8693 in)	21.8 mm (0.8583 in)
400C-18, 404C-22 and 404C-22T	23.8 - 23.9 mm (0.937 - 0.941 in)	2.80 mm (0.1102 in)

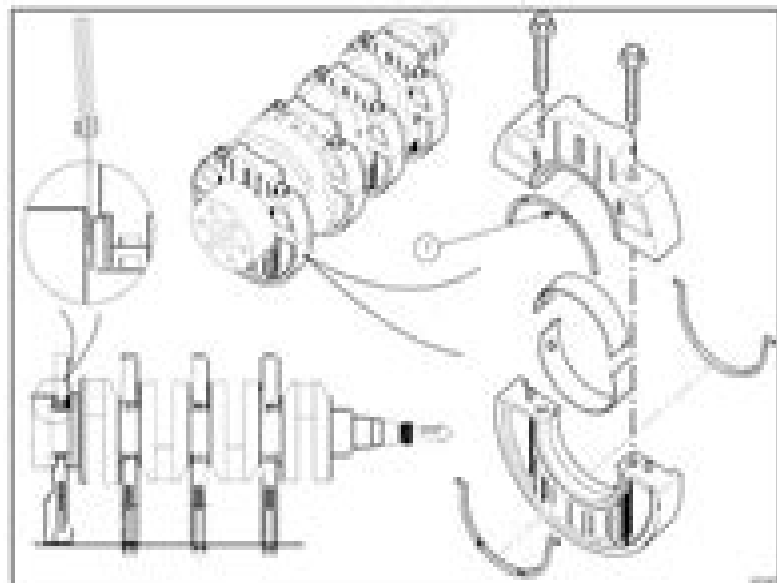
1. Identify the location of bearing carriers on the crankshaft and mark before removal.

2. Install bearing carriers on the crankshaft, ensure that the lubricating oil holes align with the feed holes in the cylinder block.

3. Check end float clearance.

Note: Ensure that the thrust washers are aligned correctly, fitted with their oil grooves towards the crankshaft.

4. Check the thrust washers for wear, poor contact or damage. If damaged renew.



Bearing holder

Centre bearing

1. Remove the bearing holder and inspect for peeling, melting, stepped wear and damage. If it is damaged renew.
2. Use Plastigauge #1 to measure the oil clearance (see Operation 4-10) between the crankshaft centre journal and the bearing. If the oil clearance is greater than the service limit, renew the bearings or reground the centre journal and use undersize bearings.

Engine	Standard oil clearance	Service limit
400C-11	0.038 - 0.108 mm (0.00150 - 0.00425 in)	0.20 mm (0.0079 in)
400C-18 404C-22 404C-22T	0.044 - 0.102 mm (0.00173 - 0.00402 in)	0.20 mm (0.0079 in)

Engine / Bearing size mm (in)	Journal	Centre crankshaft diameter mm (in)
400C-11		
Standard	1.2	47.985 - 47.976 (1.8890 - 1.8890)
	3	47.954 - 47.958 (1.8890 - 1.8894)
Undersize 0.20 (0.01)	1.2	47.716 - 47.728 (1.8780 - 1.8780)
	3	47.758 - 47.718 (1.8780 - 1.8780)
Undersize 0.80 (0.03)	1.2	47.484 - 47.476 (1.8690 - 1.8690)
	3	47.454 - 47.458 (1.8690 - 1.8690)
400C-18		
Standard	1.2, 3	47.987 - 47.979 (1.8890 - 1.8890)
	1.2, 3	47.957 - 47.959 (1.8890 - 1.8894)
Undersize 0.20 (0.01)	1.2, 3	47.717 - 47.729 (1.8780 - 1.8780)
	1.2, 3	47.757 - 47.717 (1.8780 - 1.8780)
404C-22 and 404C-22T		
Standard	1.2, 3, 4	47.987 - 47.979 (1.8890 - 1.8890)
	1.2, 3, 4	47.957 - 47.959 (1.8890 - 1.8894)
Undersize 0.20 (0.01)	1.2, 3, 4	47.717 - 47.729 (1.8780 - 1.8780)
	1.2, 3, 4	47.757 - 47.717 (1.8780 - 1.8780)

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Anthony S. Fauci



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Table of Contents Perkins 404c 22 404c 22t Diesel Engine Full Service Repair Manual

1. Understanding the eBook Perkins 404c 22 404c 22t Diesel Engine Full Service Repair Manual
 - The Rise of Digital Reading Perkins 404c 22 404c 22t Diesel Engine Full Service Repair Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying Perkins 404c 22 404c 22t Diesel Engine Full Service Repair Manual
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Perkins 404c 22 404c 22t Diesel Engine Full Service Repair Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from Perkins 404c 22 404c 22t Diesel Engine Full Service Repair Manual

- Personalized Recommendations
 - Perkins 404c 22 404c 22t Diesel Engine Full Service Repair Manual User Reviews and Ratings
 - Perkins 404c 22 404c 22t Diesel Engine Full Service Repair Manual and Bestseller Lists
5. Accessing Perkins 404c 22 404c 22t Diesel Engine Full Service Repair Manual Free and Paid eBooks
 - Perkins 404c 22 404c 22t Diesel Engine Full Service Repair Manual Public Domain eBooks
 - Perkins 404c 22 404c 22t Diesel Engine Full Service Repair Manual eBook Subscription Services
 - Perkins 404c 22 404c 22t Diesel Engine Full Service Repair Manual Budget-Friendly Options
 6. Navigating Perkins 404c 22 404c 22t Diesel Engine Full Service Repair Manual eBook Formats
 - ePub, PDF, MOBI, and More
 - Perkins 404c 22 404c 22t Diesel Engine Full Service Repair Manual Compatibility with Devices
 - Perkins 404c 22 404c 22t Diesel Engine Full Service Repair Manual Enhanced eBook Features
 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Perkins 404c 22 404c 22t Diesel Engine Full Service Repair Manual
 - Highlighting and Note-Taking Perkins 404c 22 404c 22t Diesel Engine Full Service Repair Manual
 - Interactive Elements Perkins 404c 22 404c 22t Diesel Engine Full Service Repair Manual
 8. Staying Engaged with Perkins 404c 22 404c 22t Diesel Engine Full Service Repair Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Perkins 404c 22 404c 22t Diesel Engine Full Service Repair Manual
 9. Balancing eBooks and Physical Books Perkins 404c 22 404c 22t Diesel Engine Full Service Repair Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Perkins 404c 22 404c 22t Diesel Engine Full Service Repair Manual
 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
 11. Cultivating a Reading Routine Perkins 404c 22 404c 22t Diesel Engine Full Service Repair Manual
 - Setting Reading Goals Perkins 404c 22 404c 22t Diesel Engine Full Service Repair Manual
 - Carving Out Dedicated Reading Time
 12. Sourcing Reliable Information of Perkins 404c 22 404c 22t Diesel Engine Full Service Repair Manual

- Fact-Checking eBook Content of Perkins 404c 22 404c 22t Diesel Engine Full Service Repair Manual
- Distinguishing Credible Sources

13. Promoting Lifelong Learning

- Utilizing eBooks for Skill Development
- Exploring Educational eBooks

14. Embracing eBook Trends

- Integration of Multimedia Elements
- Interactive and Gamified eBooks

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