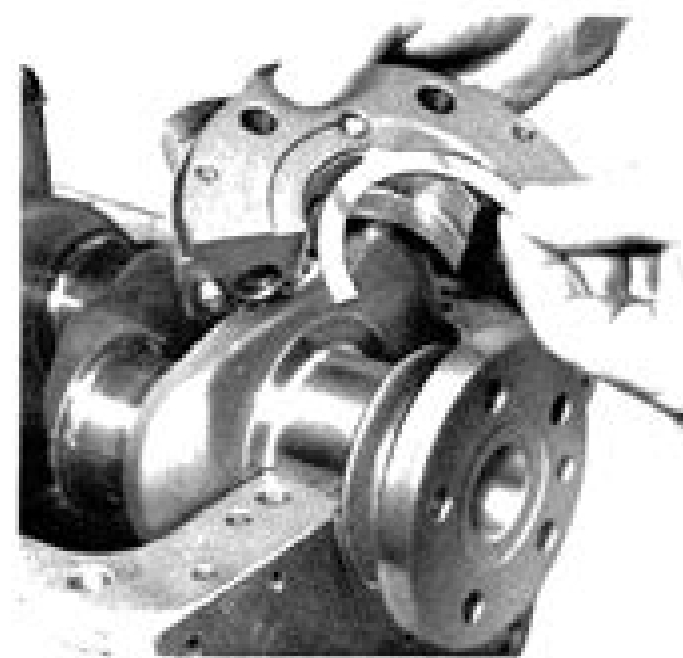


H3

### To Renew Main Bearings and Thrust Washers

Removal of the main bearings and thrust washers can be carried out without removing the crankshaft by the following procedure—

1. Remove the engine from its application.
2. Remove the pump and suction pipe assembly.
3. Slacken the setscrews which secure the main bearing caps.
4. Remove completely one of the main bearing caps and remove the bearing shell from the cap.
5. Remove the top half of the bearing shell by pushing it, on the opposite side to the one having the locating tag, with a suitable strip of wood and rotating it on the crankshaft as shown in Fig. H.1.
6. Inspect the bearing shells and if replacements are necessary continue by lightly lubricating and in-
7. Rotate the bearing shell on the crankshaft until it locates correctly with the tag in the machined slot.
8. Locate the lower half bearing shell in the main bearing cap, liberally lubricate and refit.
9. Tighten the two securing setscrews to positively locate the bearing shells then slacken a turn or two.
10. Repeat items 3—8 for the remaining two bearings.



H4

- NOTE: To enable the rear main bearing cap to be removed, first remove the two oil seal housing setscrews as shown in Fig. H.3.
11. Finally tighten the main bearings to the torque given on Page B.2.

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**L Towne**



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## **Table of Contents Perkins 2500 Workshop Manual**

1. Understanding the eBook Perkins 2500 Workshop Manual
  - The Rise of Digital Reading Perkins 2500 Workshop Manual
  - Advantages of eBooks Over Traditional Books
2. Identifying Perkins 2500 Workshop 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 2500 Workshop Manual
  - User-Friendly Interface
4. Exploring eBook Recommendations from Perkins 2500 Workshop Manual
  - Personalized Recommendations
  - Perkins 2500 Workshop Manual User Reviews and Ratings
  - Perkins 2500 Workshop Manual and Bestseller Lists

5. Accessing Perkins 2500 Workshop Manual Free and Paid eBooks
  - Perkins 2500 Workshop Manual Public Domain eBooks
  - Perkins 2500 Workshop Manual eBook Subscription Services
  - Perkins 2500 Workshop Manual Budget-Friendly Options
6. Navigating Perkins 2500 Workshop Manual eBook Formats
  - ePub, PDF, MOBI, and More
  - Perkins 2500 Workshop Manual Compatibility with Devices
  - Perkins 2500 Workshop Manual Enhanced eBook Features
7. Enhancing Your Reading Experience
  - Adjustable Fonts and Text Sizes of Perkins 2500 Workshop Manual
  - Highlighting and Note-Taking Perkins 2500 Workshop Manual
  - Interactive Elements Perkins 2500 Workshop Manual
8. Staying Engaged with Perkins 2500 Workshop Manual
  - Joining Online Reading Communities
  - Participating in Virtual Book Clubs
  - Following Authors and Publishers Perkins 2500 Workshop Manual
9. Balancing eBooks and Physical Books Perkins 2500 Workshop Manual
  - Benefits of a Digital Library
  - Creating a Diverse Reading Collection Perkins 2500 Workshop Manual
10. Overcoming Reading Challenges
  - Dealing with Digital Eye Strain
  - Minimizing Distractions
  - Managing Screen Time
11. Cultivating a Reading Routine Perkins 2500 Workshop Manual
  - Setting Reading Goals Perkins 2500 Workshop Manual
  - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of Perkins 2500 Workshop Manual
  - Fact-Checking eBook Content of Perkins 2500 Workshop 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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