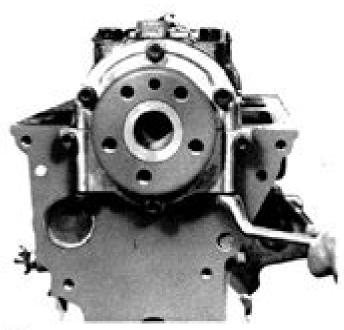
#### CRANKSHAFT AND MAIN BEARINGS-H.2



H3



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 sump and section pipe assembly.
- Stacken the setscrives which secure the main bearing caps.
- Remove completely one of the main bearing caps and remove the bearing shell from the cap.
- 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 crankshall as shown in Fig. H.1.
- Inspect the bearing shells and it replacements are necessary continue by lightly lubricating and in-



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- Hotate the bearing shell on the crankshaft until it locates correctly with the tag in the machined slot.
- Locate the lower half bearing shell in the main bearing cap, liberally lubricate and refit.
- Tighten the two securing setscrews to positively locate the bearing shells then stacken a turn or two.
- Repeat items 3—8 for the remaining two bearings. NOTE: To enable the rear main bearing cap to be removed, first remove the two oil seat housing setscrews as shown in Fig. H.3.
- Finally tighten the main bearings to the torque given on Page 8.2.



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