

Main bearings

To dismantle and to assemble

Operation 5-4

Engine	Torque Nm (lbf ft) kgf m
403C-11	Bearing holder screws 23 (17) 3: 2.3
403C-18, 404C-22 and 404C-22T	Bearing holder screws 12 (9) 3: 1.2

End float

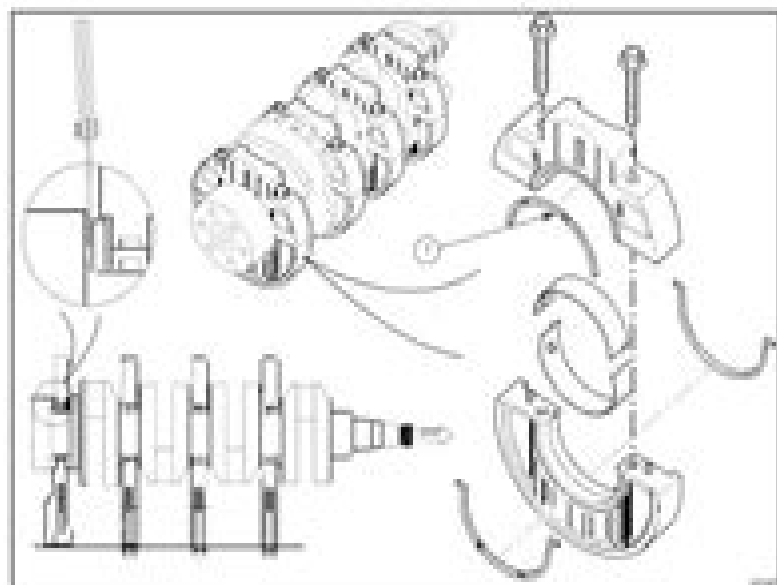
If the end float is greater than the service limit check the thrust washers for wear.

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

Engine	Standard clearance	Service limit
403C-11	0.10 - 0.30 mm (0.0040 - 0.0120 in)	0.50 mm (0.0197 in)
403C-18, 404C-22 and 404C-22T	0.10 - 0.40 mm (0.0040 - 0.0160 in)	0.50 mm (0.0197 in)

Engine	Thrust washer thickness	Service limit
403C-11	21.81 - 21.85 mm (0.8582 - 0.8601 in)	21.8 mm (0.8580 in)
403C-18, 404C-22 and 404C-22T	2.85 - 3.00 mm (0.1121 - 0.1181 in)	2.80 mm (0.1102 in)

- 1 Identify the location of bearing centers on the crankshaft and mark before removal.
 - 2 Install bearing centers 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 Plastigage #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 regrind the centre journal and use undersize bearings.

Engine	Standard oil clearance	Service limit
403C-11	0.028 - 0.100 mm (0.00110 - 0.00401 in)	0.20 mm (0.0079 in)
403C-18 404C-22 404C-22T	0.044 - 0.100 mm (0.00170 - 0.00400 in)	0.20 mm (0.0079 in)

Engine / Bearing size mm (in)	Journal	Centre crankshaft diameter mm (in)
403C-11		
Standard	1.2	47.959 - 47.976 (1.8830 - 1.8835)
	3	47.954 - 47.969 (1.8830 - 1.8834)
Undersize 0.20 (0.01)	1.2	47.719 - 47.738 (1.8780 - 1.8785)
	3	47.704 - 47.719 (1.8780 - 1.8784)
Undersize 0.50 (0.02)	1.2	47.464 - 47.479 (1.8670 - 1.8675)
	3	47.454 - 47.469 (1.8620 - 1.8625)
403C-18		
Standard	1.2, 3	47.957 - 47.976 (1.8790 - 1.8794)
	1.2, 3	47.707 - 47.726 (1.8690 - 1.8694)
Undersize 0.20 (0.01)	1.2, 3	47.467 - 47.476 (1.8690 - 1.8693)
	1.2, 3, 4	47.457 - 47.476 (1.8640 - 1.8644)
Undersize 0.50 (0.02)	1.2, 3, 4	47.207 - 47.226 (1.8540 - 1.8544)
	1.2, 3, 4	47.457 - 47.476 (1.8590 - 1.8593)

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dø is a german schleswig holstein rendsburg eckernförde on the coast of the approximately 30 km north west of the population is about 23 000 eckernförde is a popular destination in northern germany

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