

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 52 (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 - 0.8654 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) |

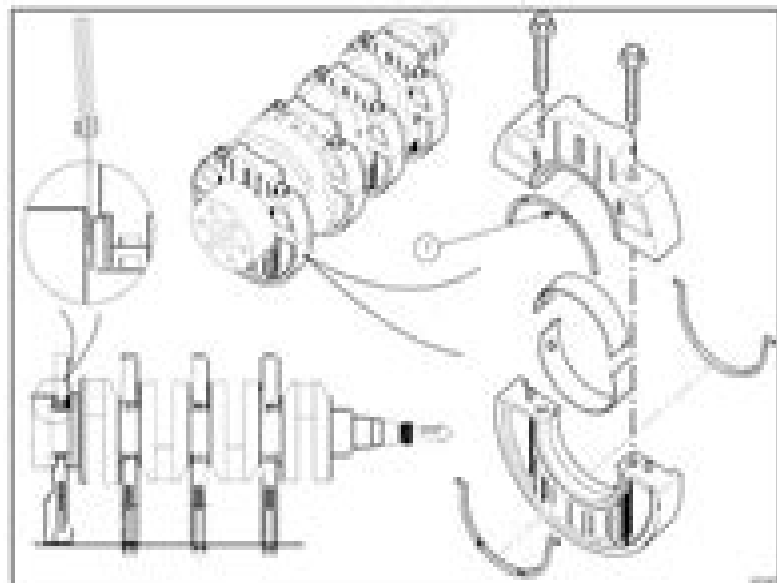
1. Identify the location of bearing carriers on the crankshaft and mark before removal.

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 - 0.00400 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 (1.8785 - 1.8785) |
| | 3 | 47.754 - 47.718 (1.8785 - 1.8785) |
| 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 (1.8785 - 1.8785) |
| | 1.2, 3 | 47.757 - 47.721 (1.8785 - 1.8785) |
| 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 (1.8785 - 1.8785) |
| | 1.2, 3, 4 | 47.757 - 47.721 (1.8785 - 1.8785) |

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KJ Lindholm-Leary



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 - 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
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 - Interactive Elements Perkins 404c 22 404c 22t Diesel Engine Full Service Repair Manual
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 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Perkins 404c 22 404c 22t Diesel Engine Full Service Repair Manual
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 - Benefits of a Digital Library
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 - 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

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- Utilizing eBooks for Skill Development
- Exploring Educational eBooks

14. Embracing eBook Trends

- Integration of Multimedia Elements
- Interactive and Gamified eBooks

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