

Main bearings

To dismantle and to assemble

Operation 5-4

Engine	Torque Nm (lbf ft)
400C-11	Bearing holder setcrew 29 (21) 5-13
400C-18, 404C-22 and 404C-22T	Bearing holder setcrew 57 (41) 5-13

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)

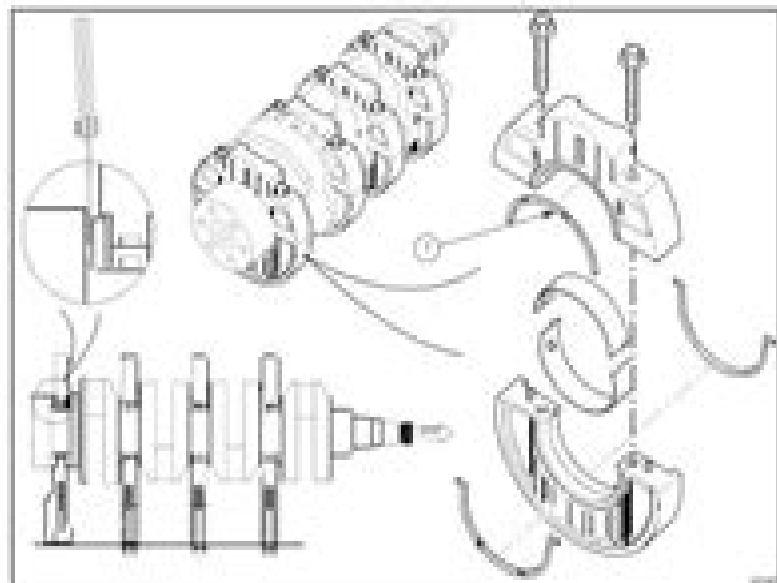
1. Identify the location of bearing carriers on the crankshaft and mark before removal.

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 - 0.00400 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 (1.8693 - 1.8693)
	3	47.454 - 47.458 (1.8693 - 1.8693)
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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Jianjun Gao



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