

Install Crankshaft



Installing Main Bearing Assembly

A—JDG996 Main Bearing Cap Puller/Installer B—D01300AA Slide Hammer

CAUTION: Crankshaft is heavy. Plan a proper lifting procedure to avoid injuries.

NOTE: If crankshaft is being replaced, vibration damper should be replaced also.

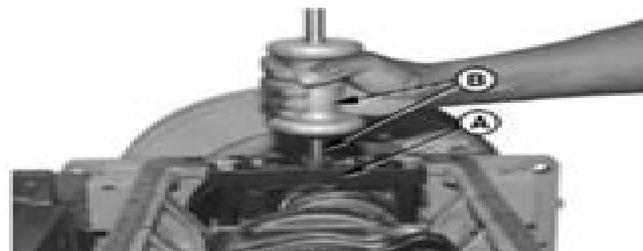
1. Carefully position crankshaft onto main bearing inserts using a hoist and lift sling.
2. Dip all main bearing cap screws in clean engine oil. Apply a liberal amount of oil to bearing inserts in caps.

NOTE: Make sure main bearing caps are installed on the bearing bosses from which they were removed. The numbers stamped on the caps should be on the same side as the numbers on the block. Arrow on cap must point towards front of the engine. If bearing caps have been rebored, make sure bearing caps have numbers stamped on them.

3. Install each bearing cap and bearings with the recesses and tabs aligned in matching order using JDG996 Main Bearing Cap Puller/Installer (A) and D01300AA Slide Hammer (B). Make sure bearing tabs also match up before tightening cap screws.

NOTE: Main bearing caps may also be installed by evenly tightening both main bearing cap screws.

NOTE: ALWAYS use NEW cap screws when installing Crankshaft. Cap screws may be used only one time.



Seating Main Bearing Cap

IMPORTANT: Do not use pneumatic wrench to install main bearing cap screws, as damage may occur to threads.

4. Before tightening cap screws on main bearing caps, align upper and lower thrust flanges on main thrust bearings. Using a soft-face hammer, tap crankshaft to the rear and then to the front to line up thrust bearing flanges.
5. Tighten No. 1, 2, 3, 4, 6, and 7 main bearing cap screws to the following specification.

Specification

Crankshaft Main Bearing
Cap Screws—Initial
Torque _____ 100 N·m (144 lb-ft)

Hand-tighten No. 5 main thrust bearing cap screws.

NOTE: DO NOT PRY crankshaft on No. 5 main thrust bearing.

6. Gently pry crankshaft rearward and then forward to align thrust washers on No. 5 main thrust bearing.
7. Tighten No. 5 main thrust bearing cap screws to the following specification.

Specification

Crankshaft Main Bearing
Cap Screws—Initial
Torque _____ 100 N·m (144 lb-ft)

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