

bearing on both upper and lower thrust faces. See Illustr. 36.



Illustr. 36 - Checking crankshaft end clearance.

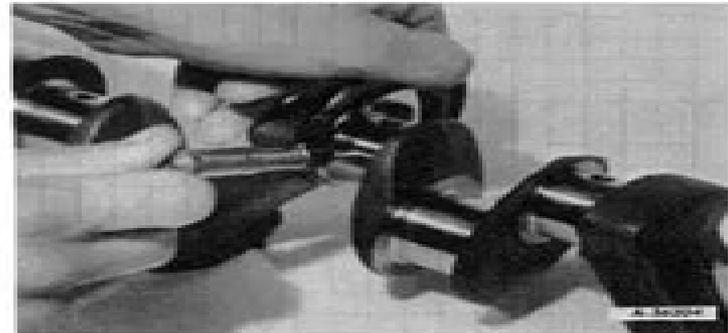
While making this check be sure the crankshaft is held against the rear thrust face of the bearing to show total clearance at front side.

When installing center main bearing cap, hold crankshaft against the rear thrust face of the upper half of the bearing. Tighten center cap bolts lightly and tap cap toward the rear before final tightening of cap bolts. This lines up the upper and lower thrust surfaces of the bearing halves and prevents binding the shaft on the thrust surfaces.

8. Remove the crankshaft and check both crankshaft and connecting rod journals for out-of-round condition. Use a micrometer and take measurements at least three places around the journals. See Illustr. 37.

9. If crankshaft is to be used for further

service, clean oil passages by using a rifle barrel brush, solvent and air blow gun.



Illustr. 37 - Checking connecting rod journal with micrometer.

10. Inspect flywheel ring gear for damaged teeth.

11. Discard front and rear crankshaft oil seals.

12. Check clutch pilot bushing for damage or excessive wear. If necessary, a new bushing can be pressed into the rear of the crankshaft and burnished to size by using a polished driver .6265-in. diameter. This should leave a bushing inside diameter of .626 - .627-in. All burrs must be removed from the edge of the crankshaft bore to prevent shaving the bushing upon installation.

13. Check oil seal surfaces for roughness.

14. Discard all excessively worn or damaged parts.

15. Thoroughly clean all parts to be used for further service and wrap or cover to keep clean until reassembly.

# Long445 Tractor Engine Manual

**Peipei Pang**



## **Long445 Tractor Engine Manual:**

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