



24.11 Lay the Plastigage strips (arrow) on the main bearing journals, parallel to the crankshaft centerline



24.15 Compare the width of the crushed Plastigage to the scale on the envelope to determine the main bearing oil clearance (always take the measurement at the widest point of the Plastigage); be sure to use the correct scale - standard and metric ones are included

and, inspected and repaired or reconditioned.

- Position the engine with the bottom facing up.
- Remove the main bearing cap bolts and lift out the caps. Lay them out in the proper order to ensure correct installation.
- If they're still in place, remove the original bearing inserts from the block and the main bearing caps. Wipe the bearing surfaces of the block and caps with a clean, lint-free cloth. They must be kept spotless.

Main bearing oil clearance check

Note: Don't touch the faces of the new bearing inserts with your fingers. Oil and acids from your skin can etch the bearings.

- Clean the back sides of the new main bearing inserts and lay one in each main bearing saddle in the block. If one of the bearing inserts has a large groove in it, make sure the grooved insert is seated in the block. Lay the other bearing from each set in the corresponding main bearing cap. Make sure the tab on the bearing insert fits into the recess in the block or cap. **Caution:** The oil holes in the block must line up with the oil holes in the bearing inserts. Do not hammer the bearing into place and don't nick or gouge the bearing faces. Lubrication should be used at this time.
- The flanged thrust bearing must be installed in the number two rear saddle (counting from the front of the engine) on 2.6L engines. On the 2.3L and 2.5L, the thrust bearing must be installed in the number three (center) cap and saddle.
- Clean the faces of the bearings in the block and the crankshaft bearing journals with a clean, lint-free cloth.
- Check or clean the oil holes in the crankshaft, as any dirt here can quickly get away - straight through the new bearings.
- Check to be certain the crankshaft is clean, carefully lay it in position in the main bearings.
- Since the crankshaft can be permanently installed, the main bearing oil clearance must be checked.
- Use several pieces of the appropriate-size Plastigage (they should be slightly shorter than the width of the main bearings) and place one piece on each crankshaft main bearing journal, parallel with the journal axis (see illustration).
- Clean the faces of the bearings in the caps and install the caps in their original locations (don't mix them up) with the arrows pointing toward the front of the engine. Don't disturb the Plastigage.
- Tighten the center main and working out toward the ends, main bearing cap bolts, in three steps, to the torque figure listed in this Chapter's Specifications. Don't rotate the crankshaft at this time.
- Remove the bolts and carefully lift off the main bearing caps. Be sure to do so in order. Don't disturb the Plastigage or rotate the crankshaft. If any of the main bearing caps are difficult to remove, tap them

- gently from side-to-side with a soft-face hammer to loosen them.
- Compare the width of the crushed Plastigage on each journal to the scale printed on the Plastigage envelope to obtain the main bearing oil clearance (see illustration). Check the Specifications to make sure it's correct.
- If the clearance is not as specified, the bearing inserts may be the wrong size (which means different ones will be required). Before deciding different inserts are needed, make sure no dirt or oil was between the bearing inserts and the caps or block when the clearance was measured. If the Plastigage was wider at one end than the other, the journal may be tapered (see Section 20).
- Carefully scrape all traces of the Plastigage material off the main bearing journals and/or the bearing faces. Use your fingernail or the edge of a credit card - don't nick or scratch the bearing faces.

Final crankshaft installation

- Carefully lift the crankshaft out of the engine.
- Clean the bearing faces in the block, then apply a thin, uniform layer of engine assembly lube to each of the bearing surfaces. Be sure to coat the thrust faces as well as the journal face of the thrust bearing.
- Make sure the crankshaft journals are clean, then lay the crankshaft back in place in the block.
- Clean the faces of the bearings in the caps, then apply lubricant to them.
- Install the caps in their original locations with the arrows pointing toward the front of the engine.
- Install the bolts.
- Tighten all except the thrust bearing cap bolts to the torque listed in this Chapter's Specifications (work from the center out and approach the final torque in three steps).
- Tighten the thrust bearing cap bolts to 10-to-12 ft-lbs.
- Tap the ends of the crankshaft forward and backward with a lead or brass hammer to line up the main bearing and crankshaft thrust surfaces.
- Retighten all main bearing cap bolts to the torque specified in this Chapter's Specifications, starting with the center main and working out toward the ends.
- Rotate the crankshaft a number of times by hand to check for any obvious binding.
- The final step is to check the crankshaft endplay with feeler gauges or a dial indicator as described in Section 15. The endplay should be correct if the crankshaft thrust faces aren't worn or damaged and new bearings have been installed.
- Refer to Section 25 and locate...

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