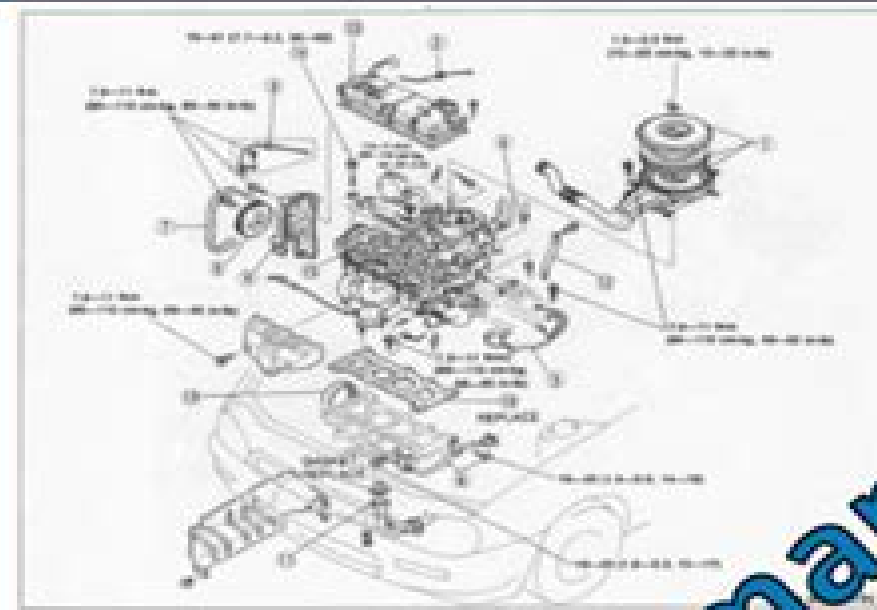
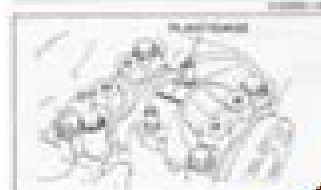


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1. Air cleaner assembly	10. Timing belt
2. Accessory cable	11. Front softener
3. Throttle cable	12. Intake manifold
4. Hoses	13. Cylinder head
5. Fan	14. Crankshaft
6. Water pump pulley	15. Timing belt cover, upper
7. Alternator drive belt	16. Timing belt cover, lower
8. Water pump pulley	17. Timing belt cover, lower
9. Timing belt cover, upper	18. Timing belt cover, lower

## CYLINDER BLOCK (EXTERNAL PARTS) Torque Specifications



- Before installing the cover, check the clearance as follows:
    - Oil clearance inspection:
      - (a) Remove oil scraper bearings.
      - (b) Grind the crankshaft and the main bearing caps.
      - (c) Grind the crankshaft and the main bearing caps.
      - (d) Grind the crankshaft and the main bearing caps.
  - Caution:
    - Do not rotate the crankshaft.
  - (a) Position the paper and the journals in the end position.
  - (b) Install the lower main bearings and the main bearing caps according to the cap number and "I" mark.
  - (c) Tighten the main bearing cap bolts in two or three steps in the order shown in the figure.
- Tightening torque:**  
54-59 Nm (5.0-6.2 m.kg, 40-43 ft.lbs)
- (f) Remove the main bearing caps, and measure the Plastigage at each journal at the widest point for the smallest clearance and at the narrowest point for the largest clearance.
  - (g) If the oil clearance exceeds specification, grind the crankshaft and use vibration main bearings. (Refer to page 9-58.)
- Oil clearance:** 0.015-0.020mm (0.0007-0.0014 in)  
**Maximum:** 0.10mm (0.004 in)
- Apply a liberal amount of clean engine oil to the main bearings, thrust bearings, and main journals.
  - Install the crankshaft and the main bearing caps according to the cap number and "I" mark.
  - Tighten the main bearing cap bolts in two or three steps in the order shown in the figure.
- Tightening torque:**  
54-59 Nm (5.0-6.2 m.kg, 40-43 ft.lbs)



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**Yi-Tong Ma**



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