

Measure Crankshaft Journals and Main Bearing ID

1. With crankshaft removed from engine, assemble main bearing caps with bearing inserts. Be sure inserts are installed correctly.
2. Tighten main bearing cap screws to 100 ft-in (100 N-m).
3. Measure and record main bearing assembled ID (A) at several points with an inside micrometer.



Measuring Main Bearing Cap ID Assembly

4. Measure and record crankshaft main journal OD (B) and rod journal OD (C) at several points around each journal.



Measuring Crankshaft Main Bearing Journal OD

NOTE: If an undersized crankshaft has been installed, measured dimensions will not meet specifications. However, bearing-to-journal oil clearance must be within specification. See CRANKSHAFT (CRANKING) (OVERHAUL) later in this group.

5. Compare measurements with specifications given below.

Specification	
Crankshaft Main Bearing-ID	76.821-76.822 in (2.1284-2.1275 in)
Crankshaft Main Journal-OD	76.821-76.822 in (2.1284-2.1275 in)
Crankshaft Rod Journal-OD	77.088-77.089 in (2.000-2.000 in)
Crankshaft Main Bearing-to-Journal-ID	
Oil Clearance	0.001-0.002 in (0.025-0.051 mm)
Crankshaft Main or Rod Journal-Minimum Taper	0.002 in (0.051 mm)
Crankshaft Main or Rod Journal-Maximum Out-of-Round	0.001 in (0.025 mm)

Replace or resurface crankshaft if it does not fall within above specifications.



Measuring Crankshaft Main Bearing Journal OD

Main Bearing ID
Main Journal OD
Rod Journal OD

Measure Main Thrust Journal Width and Thrust Bearing Width

NOTE: Oversized bearings were available for some early engines. If crankshaft has been previously resurfaced, thrust journal width may not be within specifications. However, oil pump clearance must be within specification.

1. Measure and record crankshaft main thrust journal width.

If crankshaft thrust journal width is not within specifications, install a new crankshaft.

2. Measure and record width of main thrust bearing, (B) (oil pump clearance between thrust bearing and thrust journal must be within specifications).



Measuring Main Thrust Journal Width



Measuring Main Thrust Bearing Width



Assembled Main Thrust Bearing

Specification	
Crankshaft Main Thrust Bearing Journal Width-Width	18.811-18.812 in (0.7406-0.7405 in)
Crankshaft Main Thrust Bearing-to-Journal Width	18.760-18.761 in (0.7377-0.7381 in)

John Deere Ctm104 Manual

Penton Staff



John Deere Ctm104 Manual:

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Table of Contents John Deere Ctm104 Manual

1. Understanding the eBook John Deere Ctm104 Manual
 - The Rise of Digital Reading John Deere Ctm104 Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying John Deere Ctm104 Manual
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an John Deere Ctm104 Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from John Deere Ctm104 Manual
 - Personalized Recommendations
 - John Deere Ctm104 Manual User Reviews and Ratings
 - John Deere Ctm104 Manual and Bestseller Lists

5. Accessing John Deere Ctm104 Manual Free and Paid eBooks
 - John Deere Ctm104 Manual Public Domain eBooks
 - John Deere Ctm104 Manual eBook Subscription Services
 - John Deere Ctm104 Manual Budget-Friendly Options
6. Navigating John Deere Ctm104 Manual eBook Formats
 - ePub, PDF, MOBI, and More
 - John Deere Ctm104 Manual Compatibility with Devices
 - John Deere Ctm104 Manual Enhanced eBook Features
7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of John Deere Ctm104 Manual
 - Highlighting and Note-Taking John Deere Ctm104 Manual
 - Interactive Elements John Deere Ctm104 Manual
8. Staying Engaged with John Deere Ctm104 Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers John Deere Ctm104 Manual
9. Balancing eBooks and Physical Books John Deere Ctm104 Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection John Deere Ctm104 Manual
10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
11. Cultivating a Reading Routine John Deere Ctm104 Manual
 - Setting Reading Goals John Deere Ctm104 Manual
 - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of John Deere Ctm104 Manual
 - Fact-Checking eBook Content of John Deere Ctm104 Manual
 - Distinguishing Credible Sources
13. Promoting Lifelong Learning

- Utilizing eBooks for Skill Development
- Exploring Educational eBooks

14. Embracing eBook Trends

- Integration of Multimedia Elements
- Interactive and Gamified eBooks

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