

NOTE: When crankshaft is to be removed, mark front and rear main bearing caps marked until all connecting rod caps have been removed.

4. Check main bearing caps for arrows (A), mark in main bearing caps and numbers (B) stamped on cap and of pin set. Arrows point toward crankshaft side of engine and away from number stamped on pin set.

If there are no numbers, stamp corresponding numbers on cap and of pin set to ensure correct placement of bearing caps during assembly.

5. Remove main bearing caps. Visually inspect condition of bearing inserts as bearing caps are removed. Keep caps and inserts together and in correct order.



CHECK MAIN BEARING CLEARANCE

1. Place a strip of PLASTIGAGE in the center of the main bearing cap about three-fourths of the width of the bearing.

2. Use clean engine oil on PLASTIGAGE to prevent seizing.

3. Install cap and tighten cap screws to specified torque.

MAIN BEARING CAP TIGHTEN TORQUE SPECIFICATIONS

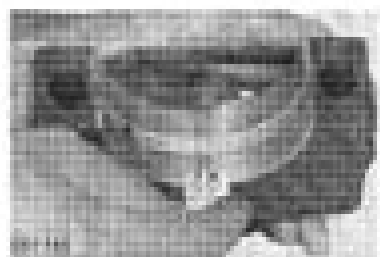
40 Cylinder and Overhaul Engines	
Crank No. 1—(OVERHOLE)	110 N·m (80 ft·lb)
Overhaul Engines	
Crank No. 1—(OVERHOLE)	110 N·m (80 ft·lb)

4. Remove cap and compare width of PLASTIGAGE with scale provided to determine clearance.

NOTE: The use of PLASTIGAGE will determine wear (crankshaft-to-bearing or clearance), but will not determine condition of other bearing or journal.

MAIN BEARING CLEARANCE SPECIFICATIONS

Main Bearing to Journal Clearance	0.025–0.030 mm (0.0009–0.0012 in.)
---	---------------------------------------



REMOVE AND INSTALL CRANKSHAFT GEAR (CRANKSHAFT INSTALLED IN ENGINE)

NOTE: Remove crankshaft gear for replacement only. It is not necessary to remove gear for crankshaft removal.

To Remove Crankshaft Gear

1. Lock engine at No. 1 TDC compression.
2. Remove timing gear cover (shown removed).
3. Remove oil pump gear (A).
4. Remove upper idler gear (B) and lower idler gear (C).
5. Remove lower idler gear shaft (D).

NOTE: On hydraulic engines it is not necessary to remove balance shafts, if equipped.

6. Install No. 1125 Pulley Attachment (E) onto crankshaft gear.

7. Using a die (F) to protect threads in nose of crankshaft, insert D102044 Push Puller (G) and No. 1125 D011644 Pulley Attachment. Remove crankshaft gear.

To Install Crankshaft Gear

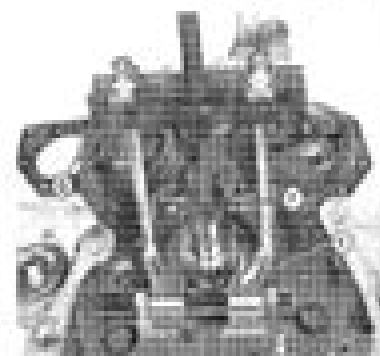
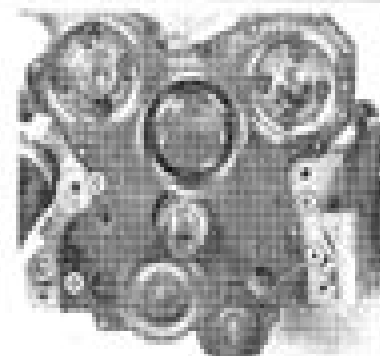
CAUTION: On fuels or oil can ignite above 150°C (300°F). Use a thermometer and do not exceed 100°C (200°F). Do not allow a heating element to be in direct contact with the oil. Heat the oil in a well-ventilated area. Plan a safe handling procedure to avoid burns.

NOTE: Chamfered side of gear should be installed toward engine.

1. Heat crankshaft gear to 140°C (300°F) using either heated oil or oven heat.

IMPORTANT: If flame heat is used, be sure gear is heated uniformly around circumference. **DO NOT OVERHEAT. SEE CAUTION.** Overheating may also destroy original heat treatment of gear.

2. Place gear on crankshaft flange. Be sure Woodruff key on crankshaft is properly aligned with keyway in gear.



- A—Oil pump gear
- B—Upper idler gear
- C—Lower idler gear
- D—Lower idler shaft
- E—No. 1125 Pulley Attachment
- F—Die
- G—D102044 Push Puller

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