

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

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 (overhaul) (OVERHAUL) later in this group.

5. Compare measurements with specifications given below.

Specification	
Crankshaft Main Bearing-ID	75.001–75.002 in. (1.9154–1.9153 in.)
Crankshaft Rod Journal-ID	75.001–75.002 in. (1.9154–1.9153 in.)
Crankshaft Rod Journal-ID	75.001–75.002 in. (1.9154–1.9153 in.)
Crankshaft Main Bearing-to-Journal-ID	
Oil Clearance	0.001–0.002 in. (0.0254–0.0508 mm)
Crankshaft Main or Rod Journal-to-Bushing Taper	0.002 in. (0.0508 mm)
Crankshaft Main or Rod Journal-to-Bushing Runout	0.001 in. (0.0254 mm)

Radial or rotational crankshaft fit does not fall within above specifications.



Measuring Main Bearing Cap ID Assembly



Measuring Crankshaft Main Bearing Journal OD



Measuring Crankshaft Main Bearing Journal ID

Bushing Bearing ID
Bushing Journal ID
Cranked Journal ID

100

100

Measure Main Thrust Journal Width and Thrust Bearing Width

NOTE: Oversized bearings were available for some early engines. If crankshaft has been previously reconditioned, 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.

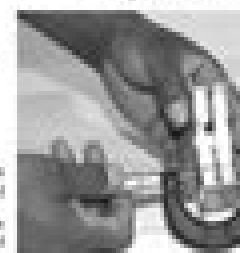
If crankshaft thrust journal width is not within specifications, install a new crankshaft.

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

Specification	
Crankshaft Main Thrust Bearing Journal Width-ID	75.001–75.002 in. (1.9154–1.9153 in.)
Crankshaft Main Thrust Bearing Journal Width	75.001–75.002 in. (1.9154–1.9153 in.)



Measuring Main Thrust Journal Width



Measuring Main Thrust Bearing Width



Assembled Main Thrust Bearing

100

John Deere Ctm104 Manual

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