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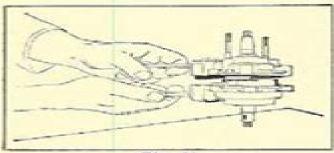


Fig. 44 Splitting the crankouse

should be attempted. This operation calls for special equipment which is normally possessed only by the Factory Service Department. An exchange crankshaft scheme is in operation, which provides guaranteed Factory Rebuilt units at an economical price.

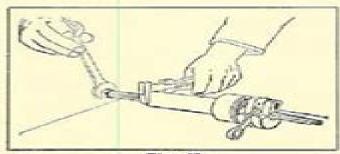


Fig. 48 Removing main bearing from crankshaft

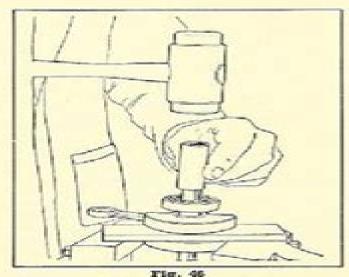
REASSEMBLING CRANKCASE

If a new or replacement crankshaft is to be fitted, the end float of the shaft must be checked and adjusted, if necessary. The most convenient way of doing this is to obtain a pair of dummy bearings which are a sliding fit on the shaft and in the crankcase, but are of the exact width of the orthodox bearings. These are

obtainable from our Spare Parts Department. Mount the crankshaft in the crankcase using the dummy bearings and fit shims between the crankwebs and bearings until the required end float is obtained, i.e., -004" approximately.

Do not forget to allow for the thickness of the crankcase gasket and, if possible, distribute the shims to ensure equal thickness at each side.

When the end float has been adjusted, the main bearings may be assembled on to the crankshaft in the following manner. Place a piece of metal it thick between the crankwebs and support the metal on a vice as shown in Fig. 46. Check that the correct shims are in place and use a piece of tube about it inside dia, to drive the bearings on to the shaft. Force should only be applied to the inner race of the bearing. Take care to fit the bear-



Fitting a main bearing

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