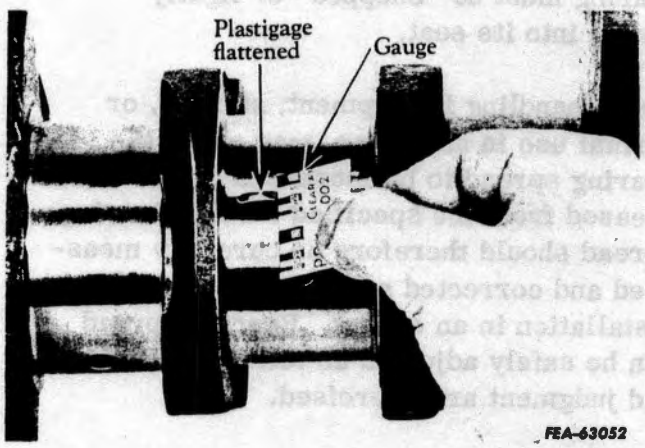
4. BEARING CLEARANCE: When installing bearings in an engine, the proper clearance between bearing surface should be checked closely. Specified bearing clearance is .002 to .003 inch. To get an accurate measurement of this clearance, the "Plastigage" method, or virgin lead, can be used. The following instructions can be used when measuring with "Plastigage":



(a) Remove bearing cap and wipe bearing surface and exposed half of crankshaft journal free of oil.

(b) Place a piece of "Plastigage" the full width of bearing insert.

(c) Reinstall the bearing cap and tighten the self-locking cap screws to 16 foot-pounds torque.

(d) Remove the bearing cap. The flattened plastic material will be found adhering to either the bearing shell or the crankshaft.

(e) To determine the bearing clearance, compare the width of the flattened plastic material at its widest point with the graduations on the envelope. The number within the graduation on the envelope indicates the clearance in thousandths of an inch.

(f) If using virgin lead, carefully remove the flattened lead and measure its thickness with a micrometer.

NOTE: Do not turn crankshaft during the above procedure.

Should the readings not fall within the specified limits, and the torque wrench is known to be accurate in its measurement, remove the bearing from the connecting rod and replace it with a new one. However, with the precision bearings used, no difficulty should be encountered providing the crankshaft and/or connecting rod are in proper condition.