

## Installation



1. Wipe all surfaces of the crankshaft bearing bores of crankcase and bearing caps free of oil, and place bearing halves in the bore of the crankcase and bearing caps. Be certain the bearings are fully seated, oil holes are in alignment, and locking tangs on the bearings fit into the recesses.

2. Apply a film of engine oil on the bearing surfaces and place the crankshaft into position.

**NOTE:** When installing the crankshaft, be certain to correctly index the timing marks on the crankshaft gear with the idler gear and camshaft gear.

3. Install the bearing caps over the crankshaft journals, being certain to install the caps in their correct positions and with the numbered side of the caps to the camshaft side of the engine.

4. Check the main bearing clearances as follows:

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

(b) Place a piece of "Plastigage" or virgin lead, the full width of the bearing insert, on the crankshaft journal.

(c) Reinstall the bearing cap and tighten the cap screws to 55 foot-pounds torque.

