

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.



Measuring Main Bearing Cap ID Assembly

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



Measuring Crankshaft Main Bearing Journal OD

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 (CRANKING) (CHECK) and/or (REPAIR) in the group.

5. Compare measurements with specifications given below.

Specification	
Crankshaft Main Bearing-ID	76.621–76.625 mm (3.016–3.017 in.)
Crankshaft Main Journal-OD	76.626–76.630 mm (3.018–3.019 in.)
Crankshaft Rod Journal-OD	77.026–77.030 mm (3.034–3.035 in.)
Crankshaft Main Bearing-to-Journal-ID	
Oil Clearance	0.001–0.100 mm (0.000–0.004 in.)
Crankshaft Main or Rod Journal-to-Bearing Taper	0.002 mm (0.000 in.)
Crankshaft Main or Rod Journal-to-Bearing Runout	0.001 mm (0.000 in.)

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



Measuring Crankshaft Main Bearing Journal OD

Number Bearing ID
Bearing Journal OD
Rod Journal OD

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).



Measuring Main Thrust Journal Width



Measuring Main Thrust Bearing Width



Assembled Main Thrust Bearing

Specification	
Crankshaft Main Thrust Bearing Journal Width-OD	10.001–10.005 mm (0.394–0.396 in.)
Crankshaft Main Thrust Bearing Width-OD	10.001–10.005 mm (0.394–0.396 in.)

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C Cleary



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