

Illustration 1

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3. Install the upper main bearings (4) in the cylinder block. Ensure that the tab on the back side of the bearing engages with the groove in the cylinder block. Apply clean engine oil on the upper main bearing. Do not put engine oil on the back side of the bearing surfaces.

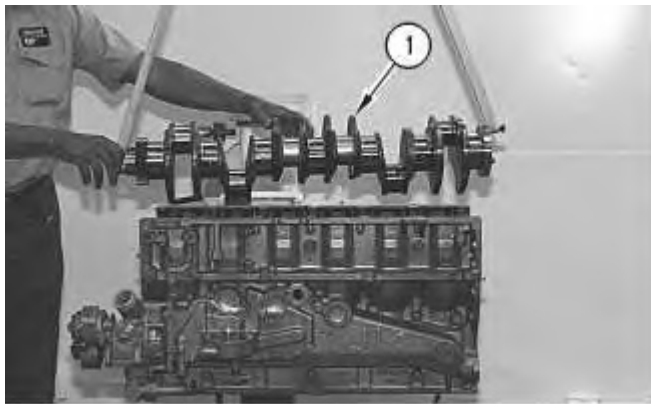


Illustration 2

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Typical example

4. Put clean engine oil on the journals of the crankshaft bearing. Fasten lifting straps and a hoist to crankshaft (1) . Carefully install the crankshaft in the cylinder block.
5. Clean the bearing surface of the main bearing caps.



Illustration 3

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6. Install the lower main bearings (5) in the crankshaft main bearing caps (3) . Ensure that the tab on the back side of the bearing engages with the groove in the main bearing cap. Apply clean engine oil on the lower main bearing. Do not put engine oil on the back side of the bearing surfaces.
7. Install crankshaft main bearing caps with the bearing tabs on the same side. Ensure that crankshaft main bearing caps have numbers 1 through 7. The numbers should start at the front of the engine. Place clean engine oil or Molylube on the bolt threads and the washers.

**Note:** When the bolts for the rear main bearing cap are tightened, slide the main bearing cap as far forward as possible until the cap is against the bolts. Hold the main bearing cap in this position and tighten the bolts.

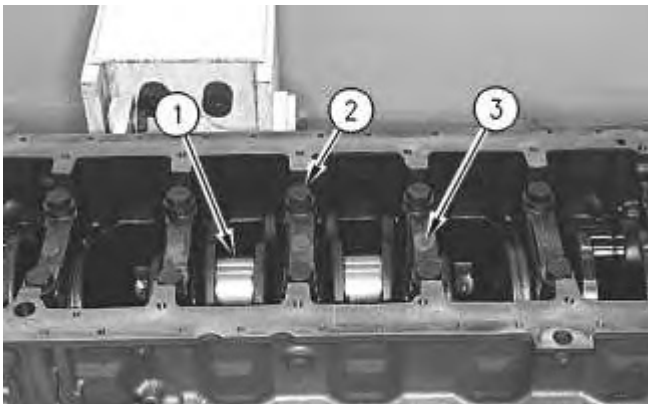


Illustration 4

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Typical example

8. Install bolts (2) and the washers for main bearing caps (3) . Tighten bolts (2) to a torque of  $54 \pm 7$  N·m ( $40 \pm 5$  lb ft).
9. Turn bolts (2) for an additional  $90 \pm 5$  degrees ( $1/4$  turn).

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