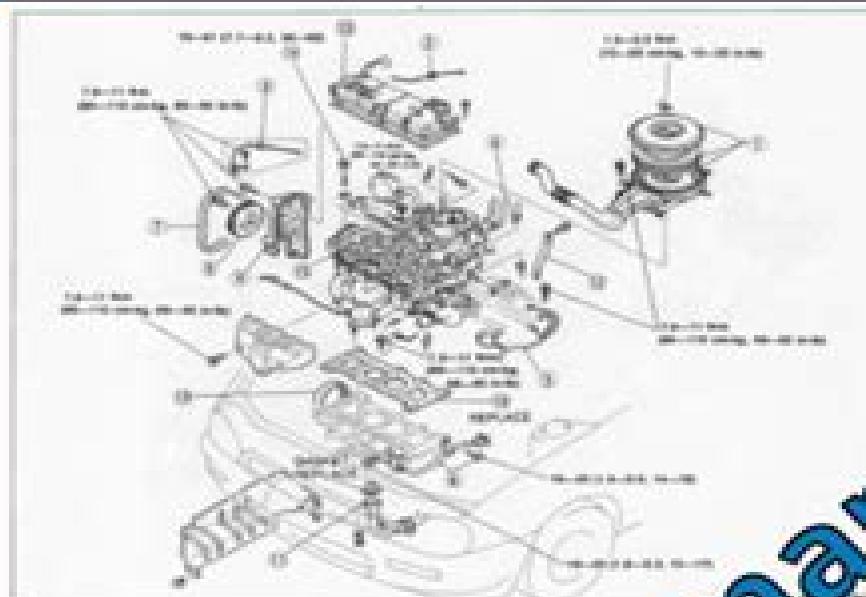


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CYLINDER BLOCK (EXTERNAL, PLATES)	
Torque Specifications	



1. Before installing the cylinder block, measure the oil clearance as follows.
- Oil clearance Inspection  
(1) Remove the cylinder block.
2. Measure the present oil clearance with a dial caliper. Then, measure the cylinder bore diameter with a bore gauge. Calculate the oil clearance.
- Caution:
  - Do not rotate the cylinder block.
3. Position the bearing cap with the journals in the same direction.
4. Install the lower main bearing and the main bearing cap according to the cap number and in order.
5. Tighten the main bearing cap bolts in two or three steps in the order shown in the figure.
6. Remove the main bearing cap, and measure the Piston gap at each journal at the lowest point for the smallest clearance and at the highest point for the largest clearance.
7. If the oil clearance exceeds specification, press the crankshaft and use cylinder main bearings.  
(Refer to page B-363.)
- Oil clearance: 0.016–0.030mm (0.0007–0.0014 in)  
Maximum: 0.16mm (0.006 in)
8. Apply a liberal amount of clean engine oil to the main bearing cap, main bearing, and main journals.
9. Install the crankshaft and the main bearing cap according to the cap number and in order.
10. Tighten the main bearing cap bolts in two or three steps in the order shown in the figure.

Tightening torque:  
50–60 Nm (3.6–4.2 kgf-m, 45–48 lbf-in)

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**Mazda Motor Corporation**

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