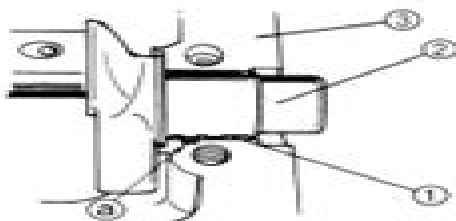




3. Install half of the main bearings ① and the crankshaft ② into the cylinder block ③.

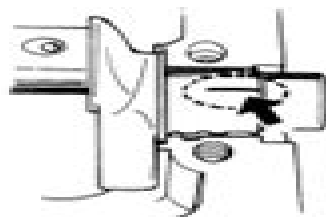


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NOTE:

- Install the main bearings in their original positions.
- Insert the projection (a) of each bearing into the slots in the cylinder block.

4. Put a piece of Plastigauge (PG-1) on each crankshaft journal parallel to the crankshaft.



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NOTE:

Be sure not to put the Plastigauge (PG-1) over the oil hole in each main journal of the crankshaft.

5. Install the remaining half of the main bearings into the crankcase.

NOTE:

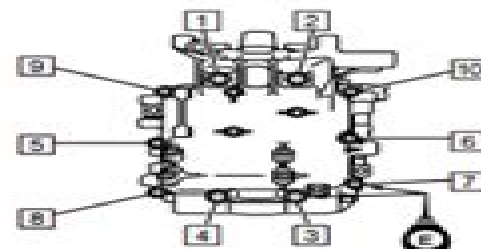
- Install the main bearings in their original positions.
- Insert the projection of each bearing into the slots in the crankcase.

6. Install the crankcase onto the cylinder block.

NOTE:

Apply engine oil to the threads of the crankcase bolts.

7. Tighten the crankcase bolts to the specified torques in 2 stages and in the sequence shown.



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NOTE:

Do not turn the crankshaft until the crankshaft journal oil clearance measurement has been completed.



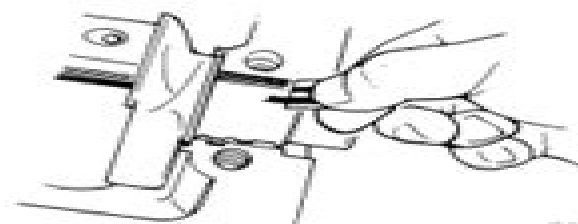
Crankcase bolt ①-④ (M8):

1st: 14 N·m (1.4 kgf·m, 10.3 ft·lb)
2nd: 27 N·m (2.7 kgf·m, 19.9 ft·lb)

Crankcase bolt ⑤-⑩ (M6):

1st: 6 N·m (0.6 kgf·m, 4.4 ft·lb)
2nd: 12 N·m (1.2 kgf·m, 8.9 ft·lb)

8. Gently remove the crankcase, and then measure the width of the compressed Plastigauge (PG-1) on each crankshaft journal. Replace the main bearings if out of specification.



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97 F20b Service Manual

Ford Motor Company



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Honda Service Manual 97-90, 92 VT1100C. ,1991 Del Sol 1997 Service Manual Supplement Honda Giken Kōgyō Kabushiki Kaisha,1996 **Element ... Service Manual** ,2003 **Explorer Repair Manual** Ford Motor Company of Australia,19?? *Wrangler 1997 Service Manual* ,1996 **1997-99 Honda Service Manual GL1500C/CT/CF Valkyrie/Valkyrie Tourer/Valkyrie Interstate** ,1998 Honda Service Manual ,1993 1997 Ford F-150 Service Manual Ford Motor Company,1996 **Workshop Manual for Ford Zephyr** Andy Hugh,1975 *1997 F-150 Service Manual* Ford Motor Company. Technical Publications Department,1995 **Honda BF 75, BF 100 (outboard Motor Service Manual).** Honda Giken Kōgyō Kabushiki Kaisha,1979 *Wrangler 1997 Service Manual Supplement* ,1996 **Chilton's 1997 Automotive Service Manual - 1993-1997** Chilton Book Company,1996 Covers domestic vehicles 1993 1997 *Cherokee 1997 Service Manual* ,1996 1997 Ford F-150 Service Manual Ford Motor Company,1996 *Grand Cherokee 1997 Service Manual* ,1996 *1997 Ford Probe* Ford Motor Company,1996 **1997 Chrysler Jeep Wrangler** Chrysler Corporation,1996 Buell M2 Cyclone Service Manual, 1997-1998 Buell Distribution Corporation,1997 VE" Series Valiant Service Manual Supplement Chrysler Australia. Service Division,

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