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ain Searings Inspection

Engine Mechanical: 10:45

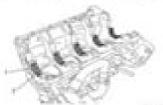
process of the same of

Service main bearings are available in standard size and 0.25 men (0.000fm) undersize, and each of them has 5 kinds of stanings offlering in statements.

Upper that of bearing (1) has of groove (2) as shown in figure.

metal this half with oil grouve to cylinder block.

Linear half of bearing does not have an oil grouve.



.....

ment brougers being

lands bearings for pilling, excelcives, wear or demage, any maniposition is found, replace both upper and are haves. Never replace other full without replacing a other half.

side (Fecaritring Christians) in

BACKETS.

Do not rotate crankshaft after peopling plants; in installed

heck clearance by using gauging plastic according to a following procedure

- 2 Remove bearing says.
- 1) Chiese belanings, and main journals.
- Place a perior of gauging plants: (1) the full width of beauting (barrelet to crarketset) on journel, according on loan.



- Tightlers mann bearing sage No. 1 boths (1) (10) and mann bearing cap No. 2 boths (11) – (20) gradually as
- a) Tighten bols: (1) (10) to 30 film: (3.2 kgf.m; 22-2 k-f) according to numerical order in figure.
- iii the same marrier as in Dep al, bytten them to 50 form (5.0 kg/m, 36.5 kg/m).
- c) If the same manner as in Step at, relighten them to 407.
- Egrows boths (111) (232) to 23 for (2.3 fogf-in), 10.3 fo-fit according to numerical arriter in figure.

Talkbening torque

Main bearing cap bit. 1 both (1) - (10): Tuphers 30 ft on CLS legt or, 22.5 fb. fb. 50 Noncl. 8 legt on, 24.5 fb. fb) and 60° by the specified procedure.

Main bearing cap No.2 boll (11) = (20); Tightes 25 time (2.5 kgf os, 16.8 ti-8) by the apended procedure

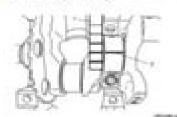


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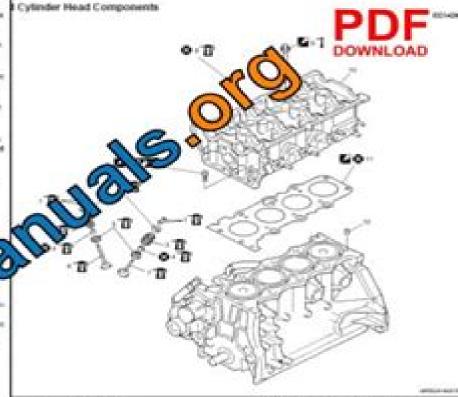
the part of 0.25 new underside

miling new bearing, recheck clearance.

Construct E-074 - 0-344 man (0.0000 - 0.0016 m.)



Engine Mechanical: 10-31



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