

To fit crankshaft

1. Ensure that all lubricating oil passages are free from restriction.
2. Check the main bearing setscrews for distortion and thread damage and renew them as necessary. Ensure that only the correct setscrews are used.
3. Clean the main bearing housings and fit the top half bearings in position with the location tags of the bearing in the slots of the housings. Lubricate the bearing surfaces with clean engine lubricating oil.
4. Put the crankshaft in position on the top half bearings.
5. Clean and lubricate the top half thrust washers and slide them into their recesses on both sides of the rear main bearing housing. The steel side must be towards the housing.
6. Renew the rear main bearing cap 'O' rings (lip seal crankshafts only).
7. Lightly apply Perkins POWERPART Hylomar jointing compound to the rear main bearing cap mounting faces, outside the grooves in the faces. The jointing compound must not go into the grooves (see fig. J7).
8. Fit the bottom half bearings to the main bearing caps with the location tags in their slots and lubricate the bearing surfaces. Put the main bearing caps in their correct positions and ensure that the bottom half thrust washers are correctly fitted to No. 4 cap (see fig. J7A). The inner caps are stamped 2 and 3 from the front of the engine. Each cap is stamped with a serial number and when fitted, this serial number must read in line with the serial number stamped on the cylinder block bottom face (see fig. J8).
9. Fit the main bearing cap setscrews and tighten them to the torque given on page C3.
10. Assemble the engine according to the instructions given in this workshop manual.
11. Tighten the crankshaft pulley setscrew to the torque given on page C3. With most applications, the pulley is fastened with a 38 mm (1.5 in) AF setscrew and a 8.9 mm (0.35 in) thick washer and this needs a higher torque than setscrews which use a 4.8 mm (3/16 in) thick washer.

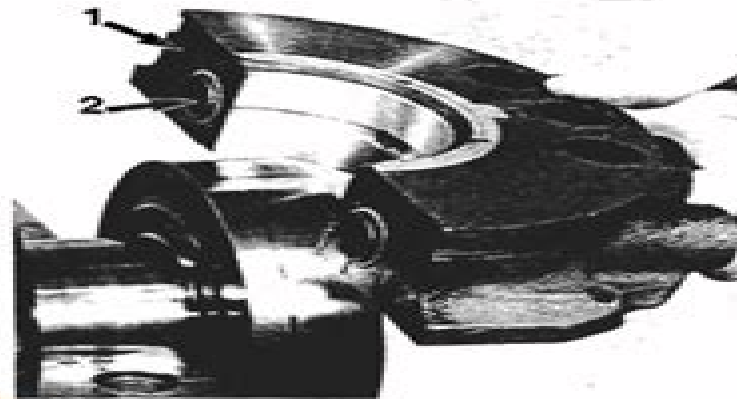


Fig. J7
1. Jointing Compound 2. 'O' Ring and Dowel



Fig. J7A

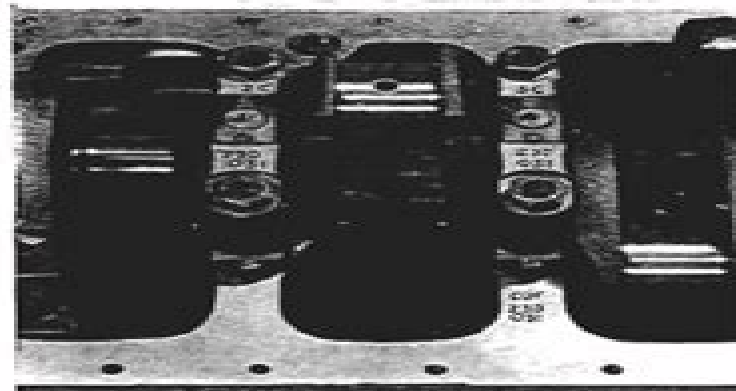


Fig. J8

Torque Perkins 1300 Series Parts Manual

H Kauffman



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Table of Contents Torque Perkins 1300 Series Parts Manual

1. Understanding the eBook Torque Perkins 1300 Series Parts Manual
 - The Rise of Digital Reading Torque Perkins 1300 Series Parts Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying Torque Perkins 1300 Series Parts Manual
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Torque Perkins 1300 Series Parts Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from Torque Perkins 1300 Series Parts Manual
 - Personalized Recommendations

- Torque Perkins 1300 Series Parts Manual User Reviews and Ratings
- Torque Perkins 1300 Series Parts Manual and Bestseller Lists
- 5. Accessing Torque Perkins 1300 Series Parts Manual Free and Paid eBooks
 - Torque Perkins 1300 Series Parts Manual Public Domain eBooks
 - Torque Perkins 1300 Series Parts Manual eBook Subscription Services
 - Torque Perkins 1300 Series Parts Manual Budget-Friendly Options
- 6. Navigating Torque Perkins 1300 Series Parts Manual eBook Formats
 - ePub, PDF, MOBI, and More
 - Torque Perkins 1300 Series Parts Manual Compatibility with Devices
 - Torque Perkins 1300 Series Parts Manual Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Torque Perkins 1300 Series Parts Manual
 - Highlighting and Note-Taking Torque Perkins 1300 Series Parts Manual
 - Interactive Elements Torque Perkins 1300 Series Parts Manual
- 8. Staying Engaged with Torque Perkins 1300 Series Parts Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Torque Perkins 1300 Series Parts Manual
- 9. Balancing eBooks and Physical Books Torque Perkins 1300 Series Parts Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Torque Perkins 1300 Series Parts Manual
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Torque Perkins 1300 Series Parts Manual
 - Setting Reading Goals Torque Perkins 1300 Series Parts Manual
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Torque Perkins 1300 Series Parts Manual
 - Fact-Checking eBook Content of Torque Perkins 1300 Series Parts Manual

- Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
- 14. Embracing eBook Trends
 - Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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