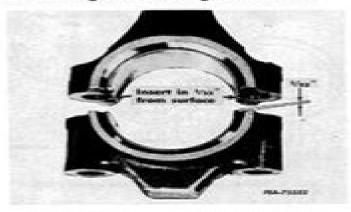
Connecting Rod Bearing Installation



Illust, 4. Correct connecting sad bearing installation,

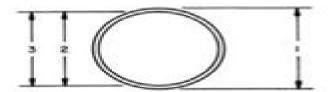
When correctly positioned, the connecting rod cap bearing half will stand out 1/32 inch on both sides above the cap surface and engage inside the rod half bore. See Illust. 4.

Install connecting rod assemblies in the engine so that the nibs on the connecting rod bearings face the camshaft, regardless of where the connecting rod number is stamped.

Camshaft Bearing Installation

When installing the front and rear bearings ensure that the edges marked 'FRONT'
are to the front of the engine and that the
holes in the bearings line up with the oil
passages in the crankcase. The holes in
the center bearing are equal distance from
either edge. There is no front marking,
but the oil holes must line up with the oil
passages.

Press the center bearing into position first, then the other bearings. The rear bearing must be pressed in flush with the front of the bore in the crankcase.



		BEARING	DIMENSIONS		
		76776-00046	REAR	CENTER	FREENT
T.	CLD	The second secon	1988-1988	1.752-1.75	HIS-MITH LINES
2	UD	Sidnet - Fritadise.	CHRIST-LINES	1.5468-1.571	1800 1804
3	LD.	LINE REAMED AFTER ASSEMBLY	1806-19025	KRITHS- LORGE	1005-000

PEA-75553

Illust, S. Dimensions of comularly bearing.

Bearings supplied for service are semifinished and are to be line-reamed after installation. See Illust. 5.

NOTE: For specified bearing clearances refer to "Specifications."

After rearning, thoroughly blow-out the casting and oil passages to ensure that there are no metal deposits present. Install the rear bearing expansion plug. Use a scaling compound on the plug and seat.

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L Reisser

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