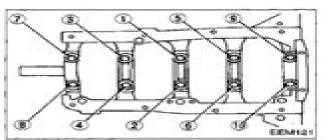
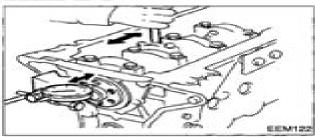
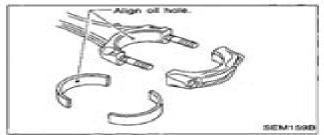
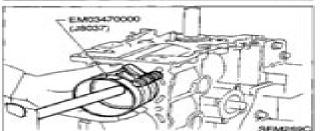
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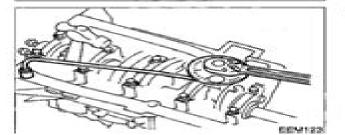
Assembly (Cont'd)











- Install crankshaft and main bearing beam and tighten bolts to the specified torque.
- Prior to tightening bearing cap bolts, place bearing cap in its proper position by shifting crankshaft in the axial direction.
- Tighten bearing cap bolts gradually in two or three stages. Start with center bearing and move outward sequentially.
- After securing bearing cap bolts, make sure crankshaft turns smoothly by hand.
- 3. Measure crankshaft end play.

Crankshaft end play: Standard 0.05 - 0.18 mm (0.0020 - 0.0071 in)

Limit

0.3 mm (0.012 in)

If beyond the limit, replace bearing with a new one.

- Install connecting rod bearings in connecting rods and connecting rod caps.
- Confirm that correct bearings are used.

Refer to "Inspection".

- Install bearings so that oil hole in connecting rod aligns with oil hole of bearing.
- 5. Install pistons with connecting rods.
- a. Install them into corresponding cylinders with Tool.
- Be careful not to scratch cylinder wall by connecting rod.
- Arrange so that front mark on piston head faces toward front of engine.
- Install connecting rod bearing caps.
 Tighten connecting rod bearing cap nuts to the specified torque.

Connecting rod bearing nut:

- (1) Tighten to 14 to 16 N·m (1.4 to 1.6 kg-m, 10 to 12 ft-lb).
- (2) Tighten bolts 60 to 65 degrees clockwise with an angle wrench, or if an angle wrench is not available, tighten them to 38 to 44 N·m (3.9 to 4.5 kg-m, 28 to 33 ft-lb).

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Jeremy Churchill

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- 1. Understanding the eBook 1995 Nissan Navara4x4 Repair Manua
 - The Rise of Digital Reading 1995 Nissan Navara4x4 Repair Manua
 - Advantages of eBooks Over Traditional Books
- 2. Identifying 1995 Nissan Navara4x4 Repair Manua
 - 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 1995 Nissan Navara4x4 Repair Manua
 - User-Friendly Interface
- 4. Exploring eBook Recommendations from 1995 Nissan Navara4x4 Repair Manua
 - Personalized Recommendations
 - 1995 Nissan Navara4x4 Repair Manua User Reviews and Ratings

- 1995 Nissan Navara4x4 Repair Manua and Bestseller Lists
- 5. Accessing 1995 Nissan Navara4x4 Repair Manua Free and Paid eBooks
 - o 1995 Nissan Navara4x4 Repair Manua Public Domain eBooks
 - 1995 Nissan Navara4x4 Repair Manua eBook Subscription Services
 - o 1995 Nissan Navara4x4 Repair Manua Budget-Friendly Options
- 6. Navigating 1995 Nissan Navara4x4 Repair Manua eBook Formats
 - ePub, PDF, MOBI, and More
 - 1995 Nissan Navara4x4 Repair Manua Compatibility with Devices
 - o 1995 Nissan Navara4x4 Repair Manua Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - o Adjustable Fonts and Text Sizes of 1995 Nissan Navara4x4 Repair Manua
 - o Highlighting and Note-Taking 1995 Nissan Navara4x4 Repair Manua
 - o Interactive Elements 1995 Nissan Navara4x4 Repair Manua
- 8. Staying Engaged with 1995 Nissan Navara4x4 Repair Manua
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - o Following Authors and Publishers 1995 Nissan Navara4x4 Repair Manua
- 9. Balancing eBooks and Physical Books 1995 Nissan Navara4x4 Repair Manua
 - o Benefits of a Digital Library
 - o Creating a Diverse Reading Collection 1995 Nissan Navara4x4 Repair Manua
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine 1995 Nissan Navara4x4 Repair Manua
 - Setting Reading Goals 1995 Nissan Navara4x4 Repair Manua
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of 1995 Nissan Navara4x4 Repair Manua
 - Fact-Checking eBook Content of 1995 Nissan Navara4x4 Repair Manua
 - 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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