

Connecting Rod Bearing Installation



Illust. 4. Correct connecting rod 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 ribs 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				
		REAR	CENTER	FRONT
1	OD	1.634-1.637	1.712-1.715	1.847-1.850
2	ID	1.490-1.493	1.568-1.571	1.603-1.606
3	ID	LINE REAMED AFTER ASSEMBLY	1.670-1.680	1.835-1.845

FEA-75553

Illust. 5. Dimensions of camshaft bearing.

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

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

After reaming, 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 sealing compound on the plug and seat.

354 International Harvester Maintenance Manual

Mike Jess



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Table of Contents 354 International Harvester Maintenance Manual

1. Understanding the eBook 354 International Harvester Maintenance Manual
 - The Rise of Digital Reading 354 International Harvester Maintenance Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying 354 International Harvester Maintenance 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 354 International Harvester Maintenance Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from 354 International Harvester Maintenance Manual
 - Personalized Recommendations
 - 354 International Harvester Maintenance Manual User Reviews and Ratings
 - 354 International Harvester Maintenance Manual and Bestseller Lists

5. Accessing 354 International Harvester Maintenance Manual Free and Paid eBooks
 - 354 International Harvester Maintenance Manual Public Domain eBooks
 - 354 International Harvester Maintenance Manual eBook Subscription Services
 - 354 International Harvester Maintenance Manual Budget-Friendly Options
6. Navigating 354 International Harvester Maintenance Manual eBook Formats
 - ePub, PDF, MOBI, and More
 - 354 International Harvester Maintenance Manual Compatibility with Devices
 - 354 International Harvester Maintenance Manual Enhanced eBook Features
7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of 354 International Harvester Maintenance Manual
 - Highlighting and Note-Taking 354 International Harvester Maintenance Manual
 - Interactive Elements 354 International Harvester Maintenance Manual
8. Staying Engaged with 354 International Harvester Maintenance Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers 354 International Harvester Maintenance Manual
9. Balancing eBooks and Physical Books 354 International Harvester Maintenance Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection 354 International Harvester Maintenance Manual
10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
11. Cultivating a Reading Routine 354 International Harvester Maintenance Manual
 - Setting Reading Goals 354 International Harvester Maintenance Manual
 - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of 354 International Harvester Maintenance Manual
 - Fact-Checking eBook Content of 354 International Harvester Maintenance 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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