

absolutely clean and dry, then chill the sleeves and press fully into place by hand. Top edge of sleeve should extend 0.762-0.889 mm (0.030-0.035 inch) above gasket face of cylinder block. Inside diameter of installed sleeve should be 98.476-98.501 mm (3.877-3.878 inches).

PISTON PINS

All Gasoline Models

31. The full floating piston pins are retained in piston bosses by snap rings and are available in standard size only. The renewable connecting rod bushing must be final sized after installation to 25.41143-25.43048 mm (1.00045-1.00120 inches). Be sure the predrilled oil hole in bushing is properly aligned with hole in top of connecting rod and install bushing from chamfered side of bore.

Piston pin diameter is 25.395-25.400 mm (0.9998-1.0000 inch). Piston pin should have 0.0114-0.0355 mm (0.00045-0.00140 inch) clearance in rod bushing and 0.0-0.010 mm (0.0-0.0004 inch) clearance in piston.

NOTE: Heating piston to 40°-50° C (100°-120° F) in hot water or oil will make installation of piston pin in piston easier.

CONNECTING RODS AND BEARINGS

All Gasoline Models

32. Connecting rod bearings are precision type, renewable from below after removing oil pan, balance unit and rod bearing caps. When renewing bearing shells, be sure the projection engages the milled slot in rod and cap and that correlation marks are in register and face away from camshaft side of engine.

Connecting rod bearings should have a diametral clearance of 0.0038-0.076 mm (0.0015-0.0030 inch) on the 63.475-63.487 mm (2.4990-2.4995 inch) diameter crankpin. Recommended connecting rod side clearance is 0.216-0.368 mm (0.0085-0.0145 inch). Renew the self-locking connecting rod nuts and tighten to a torque of 102-108 N·m (75-80 ft.-lbs.).

CRANKSHAFT AND BEARINGS

All Gasoline Models

33. The crankshaft is supported in five precision type main bearings. To remove the rear main bearing cap, it is first necessary to remove engine, clutch, flywheel and rear oil seal. All other main bearing caps can be removed after removing oil pan and engine balancer.

Upper and lower main bearing inserts are not interchangeable. The upper (block) half is slotted to provide pressure lubrication to crankshaft and connecting rods. Inserts are interchangeable in pairs for all journals except center main bearing. The center journal controls crankshaft end thrust and renewable thrust washers are installed at front and rear of cap and block bearing bore. Lower half of insert is anchored by a tab to bearing cap; upper half can be rolled out and renewed after cap is removed.

Main bearing inserts are available in undersizes of 0.25, 0.50 and 0.75 mm (0.010, 0.020 and 0.030 inch) as well as standard. Thrust washers are available in standard size and 0.19 mm (0.0075 inch) oversize. Oversize thrust washers may be installed on one side in combination with standard washers on the other side for an adjustment of 0.19 mm (0.0075 inch), or they can be installed on both sides for an adjustment of 0.38 mm (0.015 inch). Recommended crankshaft end play is 0.05-0.38 mm (0.002-0.015 inch).

Note that main bearing caps are not interchangeable. Caps are numbered 1 through 5 from front to rear and are also marked with a cylinder block identification number that must match number stamped on bottom of cylinder block. Recommended tightening torque for main bearing cap screws is 230-244 N·m (170-180 ft.-lbs.). Refer to paragraph 37 for installation procedure for rear seal



Fig. 37—Crankshaft end play should be within limits of 0.05-0.38 mm (0.002-0.015 inch).

Fig. 38—Installed view of engine balancer with timing marks aligned. Refer to text for installation procedure.



and oil pan bridge piece. Refer to the following specifications when checking crankshaft.

Main Journal

Standard Diameter 76.162-76.175 mm (2.9985-2.9990 in.)

Maximum Allowable Out-of-Round or Taper 0.025 mm (0.001 in.)

Bearing Diametral Clearance

..... 0.064-0.114 mm (0.0025-0.0045 in.)

Center Main Journal Width

Standard 44.145-44.221 mm (1.738-1.741 in.)

Maximum Allowable 44.678 mm (1.759 in.)

Crankpin

Standard Diameter 63.475-63.487 mm (2.4990-2.4995 in.)

Bearing Diametral Clearance 0.038-0.076 mm (0.0015-0.0030 in.)

Crankshaft End Play

..... 0.05-0.38 mm (0.002-0.015 in.)

ENGINE BALANCER

All Gasoline Models

34. **OPERATION.** The Lanchester type engine balancer consists of two unbalanced shafts which rotate in opposite directions at twice crankshaft speed. The inertia of the shaft weights is timed to cancel out natural engine vibration, thus producing a smoother running engine. The balancer is correctly timed when the balance weights are at their lowest point when pistons are at TDC and BDC of their stroke.

The balancer unit is driven by the crankshaft timing gear through an idler gear attached to balancer frame. The engine oil pump is mounted at rear of balancer frame and driven by the balancer shaft. Refer to Figs. 38 through 40.

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