



11. Use tooling (A), and remove the drive gear from the crankshaft.

Install Crankshaft And Gear

Tools Needed		A	B
Plastigage		*	
8S2326	Dial Indicator Test Group		1



1. Heat the crankshaft drive gear to a maximum temperature of 315° (600°F). Install drive gear (1) on the crankshaft with the "C" mark on the gear toward the pulley end of the crankshaft.



2. Clean the surfaces in the cylinder block for the main bearings. Install the upper main bearing halves (bearings with the oil hole) in the cylinder block.

NOTE: Install the main bearings dry when the clearance checks are made. Put clean oil on the main bearings for final assembly.

3. Fasten a nylon strap and a hoist on crankshaft (2), and put it in position in the cylinder block with the "C" marks on the camshaft drive gear and crankshaft drive gear in alignment.



4. Install a thrust plate (4) on each side of the No. 3 main bearing saddle. Put the side of the thrust plate which has the identification mark "BLOCK SIDE" toward the bearing saddle and the side with the oil grooves toward the crankshaft.

5. Put the clip and oil pickup tube support strip in position on the cylinder block as a unit, and install bolt (3) that holds them in place.

6. Clean the surfaces of the main bearing caps for the main bearings. Install the lower main bearing halves in the main bearing caps.

NOTE: Be sure the tabs on the back side of the main bearings fit in the grooves of the main bearing caps and cylinder block.

NOTE: For complete details concerning measuring bearing clearances, see Engine Bearings And Crankshafts, Form No. SE8D0531.

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