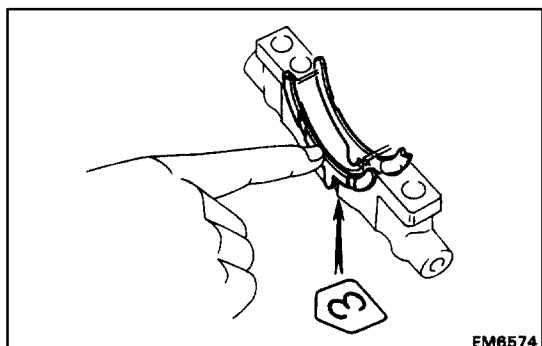


EM6445

3. PLACE CRANKSHAFT ON CYLINDER BLOCK

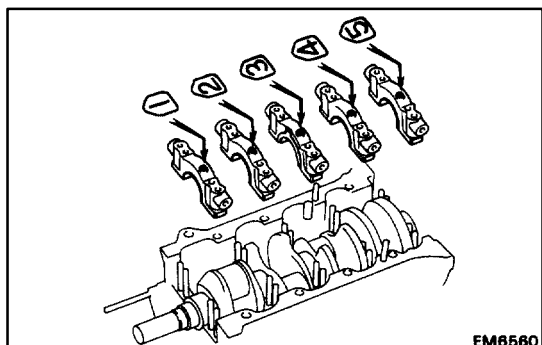


EM6574

4. INSTALL MAIN BEARING CAP AND LOWER THRUST WASHERS

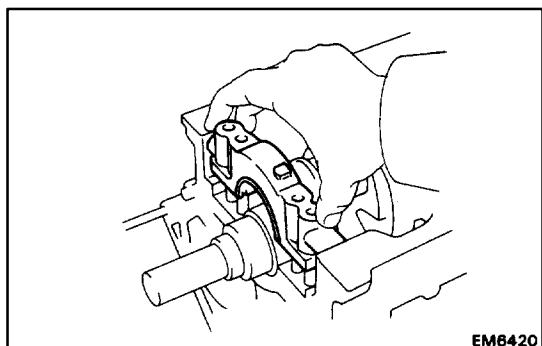
A. Place main bearing cap and lower thrust washers on cylinder block

- (a) Install the two thrust washers on the No.3 main bearing cap with the grooves facing outward.



EM6580

- (b) Install the main bearing caps in their proper location.



EM6420

- (c) Place the five bearing caps in position on cylinder block. HINT: Place the bearing caps level and let them return to their original position by their own weight.

NOTICE: Do not install the main bearing cap by tapping it.

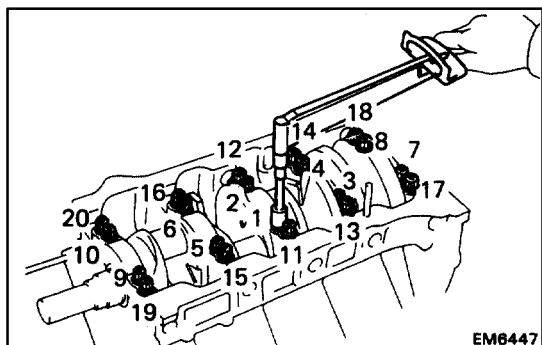
B. Install main bearing cap nuts

HINT:

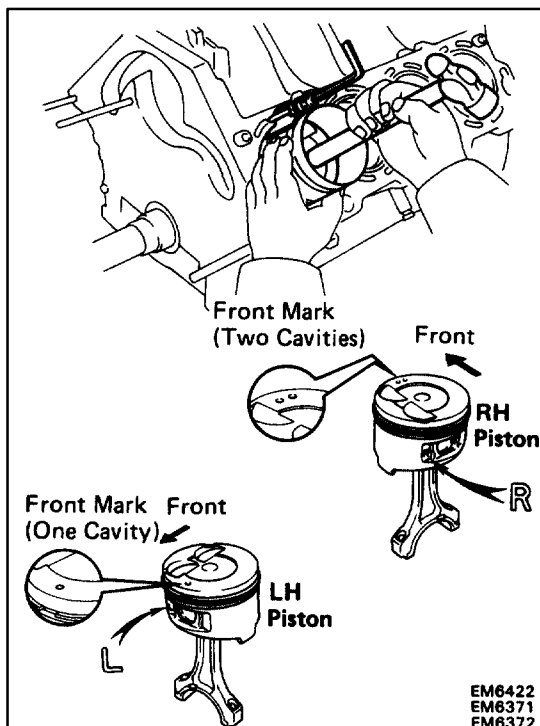
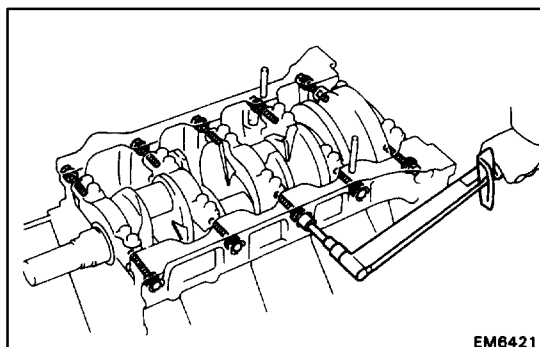
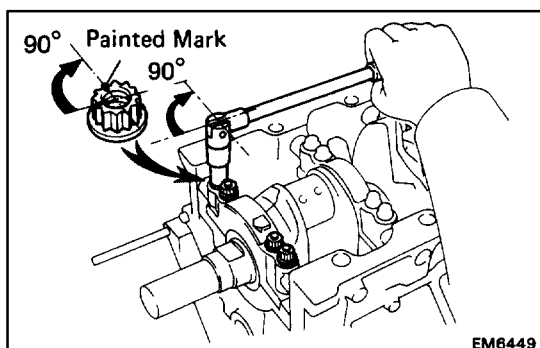
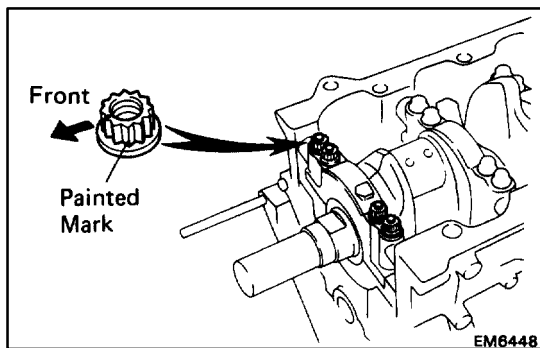
- The main bearing cap nuts are tightened in two progressive steps (steps (b) and (d)).
 - If any main bearing cap stud bolt is broken or deformed, replace it.
- (a) Apply a light coat of engine oil on the threads and under the nuts of the main bearing caps.
- (b) Install and uniformly tighten the twenty main bearing cap nuts in several passes in the sequence shown.

Torque: 275 kg-cm (20 ft-lb, 27 N-m)

If any one of the main bearing cap nuts does not meet the torque specification, replace the main bearing cap stud bolt.



EM6447



(c) Mark the front of the main bearing cap nut with paint.

(d) Retighten the main bearing cap nuts 905 in the numerical order shown.

(e) Check that the painted mark is now at a 90° angle to the front.

(f) Check that the crankshaft turns smoothly.

(g) Check the crankshaft thrust clearance.
(See step 5 on page [EM-97](#))

C. Install main bearing cap bolts

(a) Install a new seal washer to the main bearing cap bolt.

(b) Install the ten main bearing cap bolts.

Torque: 500 kg-cm (36 ft-lb, 49 N-m)

5. INSTALL PISTON AND CONNECTING ROD ASSEMBLIES

Using a piston ring compressor, push the correctly numbered piston and connecting rod assemblies into each cylinder with the front mark of the piston facing forward.

NOTICE: The shape of the piston varies for the RH and LH banks. The RH piston is marked with "R", the LH piston with "L".