

To fit crankshaft

1. Ensure that all lubricating oil passages are free from restriction.
2. Check the main bearing setscrews for distortion and thread damage and renew them as necessary. Ensure that only the correct setscrews are used.
3. Clean the main bearing housings and fit the top half bearings in position with the location tags of the bearing in the slots of the housings. Lubricate the bearing surfaces with clean engine lubricating oil.
4. Put the crankshaft in position on the top half bearings.
5. Clean and lubricate the top half thrust washers and slide them into their recesses on both sides of the rear main bearing housing. The steel side must be towards the housing.
6. Renew the rear main bearing cap 'O' rings (lip seal crankshafts only).
7. Lightly apply Perkins POWERPART Hylomar jointing compound to the rear main bearing cap mounting faces, outside the grooves in the faces. The jointing compound must not go into the grooves (see fig. J7).
8. Fit the bottom half bearings to the main bearing caps with the location tags in their slots and lubricate the bearing surfaces. Put the main bearing caps in their correct positions and ensure that the bottom half thrust washers are correctly fitted to No. 4 cap (see fig. J7A). The inner caps are stamped 2 and 3 from the front of the engine. Each cap is stamped with a serial number and when fitted, this serial number must read in line with the serial number stamped on the cylinder block bottom face (see fig. J8).
9. Fit the main bearing cap setscrews and tighten them to the torque given on page C3.
10. Assemble the engine according to the instructions given in this workshop manual.
11. Tighten the crankshaft pulley setscrew to the torque given on page C3. With most applications, the pulley is fastened with a 38 mm (1.5 in) AF setscrew and a 8.9 mm (0.35 in) thick washer and this needs a higher torque than setscrews which use a 4.8 mm (3/16 in) thick washer.

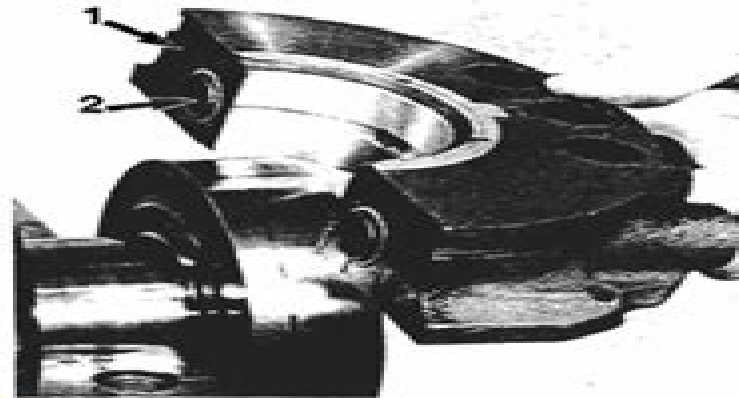


Fig. J7
1. Jointing Compound 2. 'O' Ring and Dowel



Fig. J7A

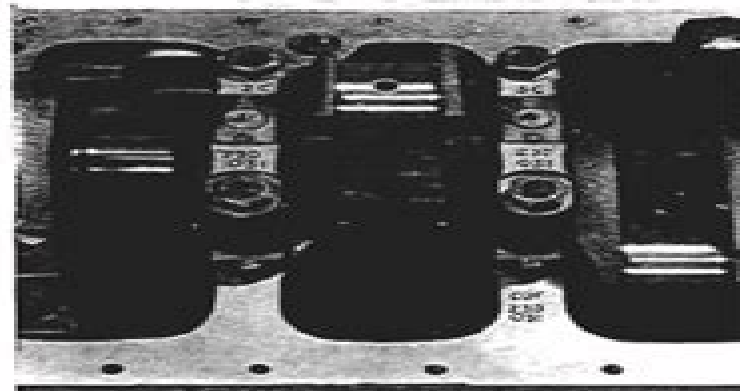


Fig. J8

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