

9. Clean the lower half of the thrust washers (7) and lubricate the lower half of thrust washers. Place the lower half of the thrust washers (7) on both sides of the crank main bearing cap (4). The grooves on the thrust washer must be located against the crankshaft.

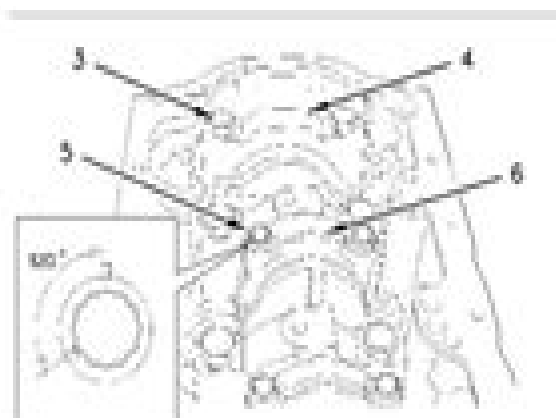


Illustration 3

p0071313

10. Install the main bearing caps (4) in the position that was marked during the removal process. All of the bearing tabs for the main bearings should be on the same side. Install the main bearing cap bolts (2). Tighten the bolts to a torque of 245 ± 10 N·m (180 ± 14 ft·lb).
11. Ensure that the upper connecting rod bearings are retained in the connecting rod. Install the lower connecting rod bearings in the connecting rod cap. Lubricate the bearing faces with clean engine oil.

Note: Do not reuse the old retainers (3) in order to secure the connecting rod cap (8).

Note: Ensure that the etched number on the connecting rod bearing cap matches the etched number on the connecting rod. Ensure that the etched numbers are on the same side.

12. Install the connecting rod caps (8). Install new retainers (3) in the connecting rod. Tighten the retainers evenly to a torque of 18 N·m (13 ft·lb).
13. Tighten the retainers evenly to a torque of 70 N·m (51 ft·lb).
14. Use Tooling (C) to achieve the correct final torque.
- Note:** If Tooling (C) is not used, place an index mark on each bolt.
15. Turn the retainers for an additional 120 degrees.
16. Rotate the crankshaft in order to ensure that there is no binding.



Illustration 1

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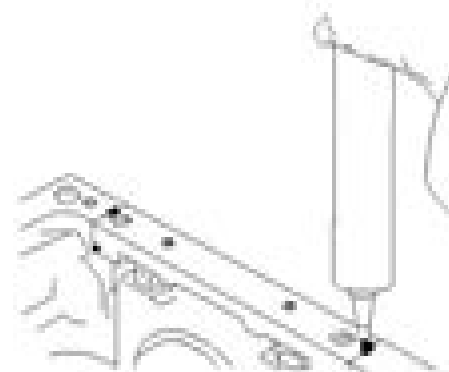


Illustration 4

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17. Clean the bridge and the face of the cylinder block. Apply a thin bead of Tooling (A) on the corners of the seat for the bridge. Also apply Tooling (A) around the threaded holes in the seat for the bridge. Use the following steps when you apply Tooling (A) to the cylinder block and the bridge.

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