

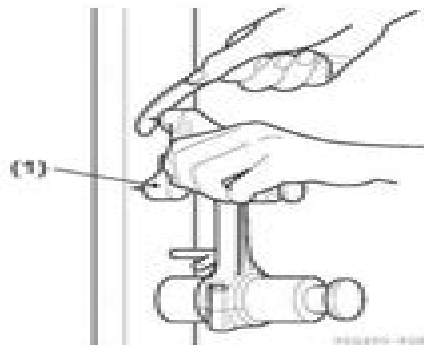


Figure 5-96

1 – Connecting Rod Alignment Tool

Check connecting rod side clearance.

1. Install the connecting rod to the crankshaft.
2. Check the side clearance as shown (Figure 5-97).

Item	Standard	Limit
Connecting Rod Side Clearance	0.20-0.40 mm (0.008-0.016 in.)	0.55 mm (0.022 in.)

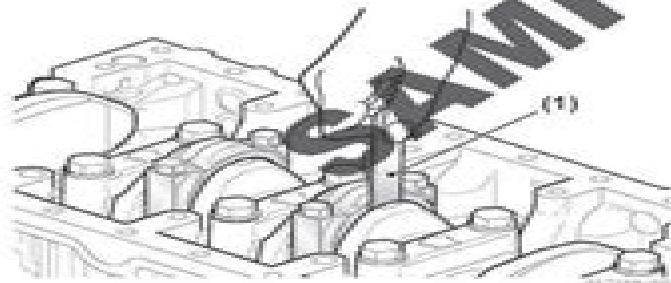


Figure 5-97

1 – Feeler Gauge**Inspecting Crank Pins**

Inspect each crank pin surface for flaking, melting or discoloration and measure each crank pin for proper oil clearance.

1. Measure the crankpin outside diameter.
2. Measure the inside diameter of the connecting rod crankshaft bearing.
3. Calculate the oil clearance by subtracting the measured values.
4. Replace the connecting rod if the oil clearance is greater than the allowable limit.
5. Correct the crankshaft by grinding to a uniform undersize standard dimension (if available).
Use an oversized bearing insert in the connecting rod, if available (Figure 5-98).

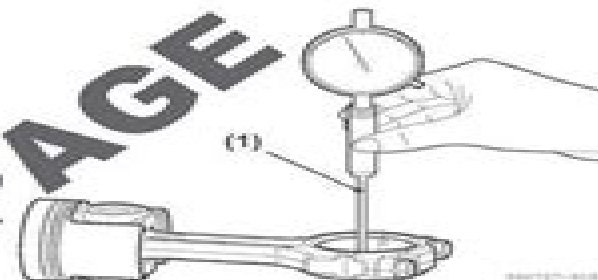


Figure 5-98

1 – Cylinder Gauge

NOTICE: When installing the connecting rod to the crankshaft, match the alignment marks on the rod cap and tighten the rod cap bolts to standard torque.

Rod Bolt Torque	44.1-49.1 N·m (4.50-5.01 lb-ft)
-----------------	------------------------------------

Item	Standard	Limit
Rod Bearing I.D.	48.000-48.026 mm (1.890-1.891 in.)	-
Crankpin O.D.	47.952-47.962 mm (1.888-1.889 in.)	47.902 mm (1.886 in.)
Bearing Thickness	1.492-1.500 mm (0.05874-0.05906 in.)	-
Clearance	0.038-0.074 mm (0.0015-0.0029 in.)	0.150 mm (0.0061 in.)

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