

## OVERHAUL (Continued)

**Fitting Main or Connecting Rod Bearings with Plastigage****Tools Required:**

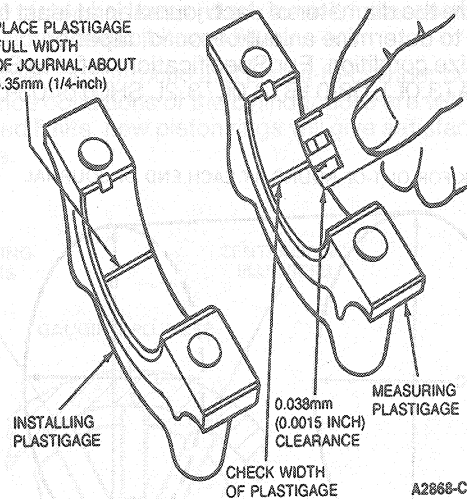
- Plastigage D81L-6002-B

1. Clean crankshaft journals. Inspect journals and thrust faces (thrust bearing) for nicks, burrs or bearing pickup that would cause premature bearing wear. **When replacing standard bearings with new bearings, it is good practice to fit the bearing to minimum specified clearance.** If the desired clearance cannot be obtained with a standard bearing, try one-half of a 0.025mm (0.001 inch) or 0.050mm (0.002 inch) undersize in combination with a standard bearing to obtain the proper clearance.

**CAUTION: Do not position jack under crankshaft pulley. Crankshaft post damage will result.**

2. If fitting a main bearing in the vehicle, position a jack under counterweight adjoining bearing which is being checked. Support crankshaft with jack so its weight will not compress Plastigage D81L-6002-B or equivalent, and provide an erroneous reading.
3. Place a piece of Plastigage D81L-6002-B or equivalent on bearing surface across full width of bearing cup and about 6.35mm (1/4 inch) off center.
4. Install cap and tighten bolts. For specifications, refer to the appropriate engine Section. Do not turn crankshaft while Plastigage is in place.
5. Remove cap. Using Plastigage scale, check width of Plastigage at widest point to get minimum clearance. Check at narrowest point to get maximum clearance. Difference between readings is taper of journals.

PLACE PLASTIGAGE FULL WIDTH OF JOURNAL ABOUT 6.35mm (1/4-inch)



6. If bearing clearance exceeds the specified limits, try using one of the various combinations of undersize bearings as directed by the accompanying table. Use of any other bearing combination is not recommended. Bearing clearance must be within specified limits. Refer to appropriate Section under Specifications, for main and connecting rod bearing clearance limits. If use of these bearing combinations do not bring clearance to the desired limits, refinish the crank journal to 0.254mm (0.010 inch) undersize, and use the appropriate undersize bearing.
7. After bearing has been fitted, apply light coat of engine oil to journal and bearings. Install bearing cap. Tighten cap bolts to specification. Refer to Section 03-01A (3.0L), 03-01B (3.0L / 3.2L SHO) or 03-01C (3.8L).
8. Repeat procedure for remaining bearings that require replacement.

FOR THIS AMOUNT OF BEARING CLEARANCE EXCESS		USE THIS BEARING SIZE			
		UPPER BEARING		LOWER BEARING	
mm	Inch	mm	Inch	mm	Inch
0.0-0.013	0.0-0.0005	0.025	0.001 U.S.	STANDARD	STANDARD
0.013-0.026	0.0005-0.0010	0.025	0.001 U.S.	0.025	0.001 U.S.
0.026-0.039	0.0010-0.0015	0.050	0.002 U.S.	0.025	0.001 U.S.
0.039-0.052	0.0015-0.0020	0.050	0.002 U.S.	0.050	0.002 U.S.

CA9330-A

**Crankshaft****Cleaning**

**CAUTION: Handle the crankshaft with care to avoid possible fractures or damage to the finished surfaces.**

Clean the crankshaft with solvent, then blow out all oil passages with compressed air.