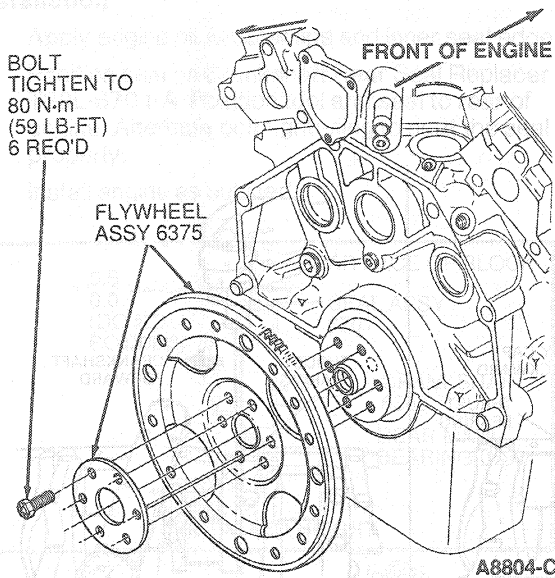


REMOVAL AND INSTALLATION (Continued)

1. Position flywheel on the crankshaft and install retaining bolts. Tighten bolts to 80 N·m (59 lb-ft) using the standard cross-tightening sequence.



2. Install transaxle.

Crankshaft

Removal

1. With engine removed from vehicle and placed on a workstand, remove 6K drive belt as outlined in Section 03-05.
2. Remove oil pan and discard gasket.
3. Remove timing cover assembly as outlined in this section.
4. Check timing chain deflection as outlined in this section. Remove timing chain and sprockets.
5. Invert engine on the work stand. Remove flywheel. Remove oil pump inlet and oil pump assembly.
6. Ensure all bearing caps (main and connecting rod) are marked so that they can be installed in their original positions. Turn crankshaft until connecting rod from which the cap is being removed is up. Remove connecting rod cap. Push connecting rod and piston assembly up in the cylinder. Repeat procedure for the remaining connecting rod assemblies.

7. Remove main bearing caps.

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

8. Carefully lift the crankshaft out of the block so that the upper thrust bearing surfaces are not damaged.

Installation

NOTE: If bearings are to be reused they should be identified to ensure that they are installed in their original positions.

1. Remove main bearing inserts from block and bearing caps.
2. Remove connecting rod bearing inserts from the connecting rods and caps.
3. Inspect all machined surfaces on the crankshaft for nicks, scratches, scores, etc., which could cause premature bearing wear. Lightly stone all such surfaces.
4. If the crankshaft main bearing journals have been refinished to a definite undersize, install the correct undersize bearings.

CAUTION: Ensure bearing inserts and bearing bores are clean. Foreign material under the inserts will distort the bearing and cause a failure.

5. Place upper main bearing inserts in position in the bores with the tang fitted in the slot provided.
6. Install lower main bearing inserts in bearing caps.
7. Carefully lower crankshaft into place.
8. Check the clearance of each main bearing. Select fit the bearings for proper clearance. Refer to Section 03-00.

NOTE: Ensure main bearing caps are installed in their original positions and orientation.

9. After bearings have been fitted, apply a light coat of Engine Assembly Lubricant D9AZ-19579-D (ESR-M99C80-A) or equivalent to the journals bearings and rear seal surface. Install all bearing caps. Apply Anaerobic Sealer E1FZ-19562-A or equivalent to gap between rear main bearing and block. Take care to keep RTV from parting surfaces between block and cap.