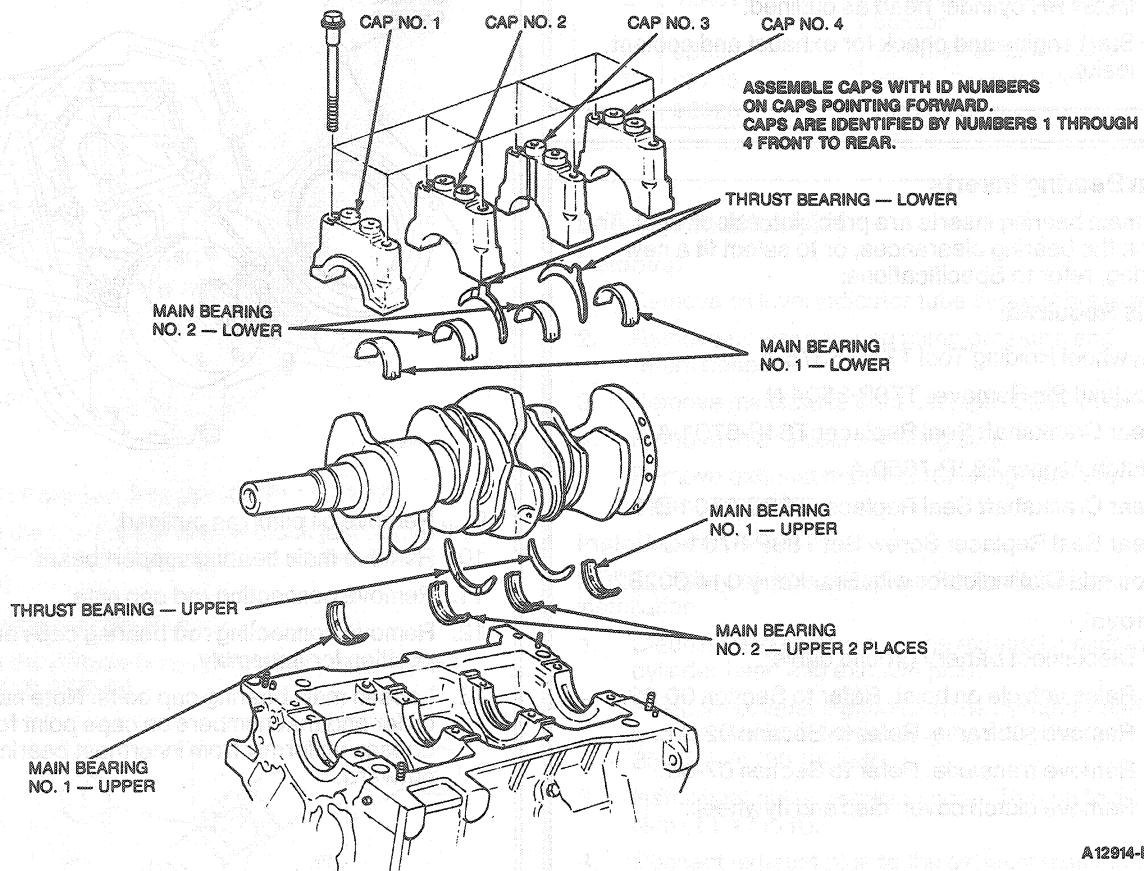


REMOVAL AND INSTALLATION (Continued)

14. Remove all but one bearing cap. With an assistant, support crankshaft and remove remaining bearing cap. Lower crankshaft from engine.

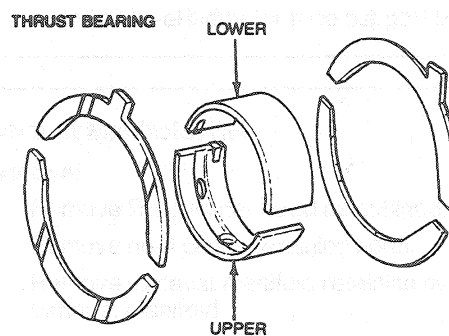


Installation

1. Inspect bearing journals and bearing faces for any damage prior to assembly.
2. Press bearing upper halves into block. Ensure they seat completely.
3. Lubricate bearing surfaces with Engine Assembly Lubricant D9AZ-19579-D (ESR-M99C80-A) or equivalent. Install bearings into lower main caps.
4. With an assistant, position crankshaft in block and loosely install No. 1 and 4 bearings caps. Note numbers point forward.

CAUTION: Oil groove on thrust bearing must face crankshaft.

5. Install upper thrust bearings on the front and rear of the No. 3 journal by moving crankshaft back and forth.



6. Install lower thrust bearings with No. 3 main cap.
7. Install No. 2 main cap.