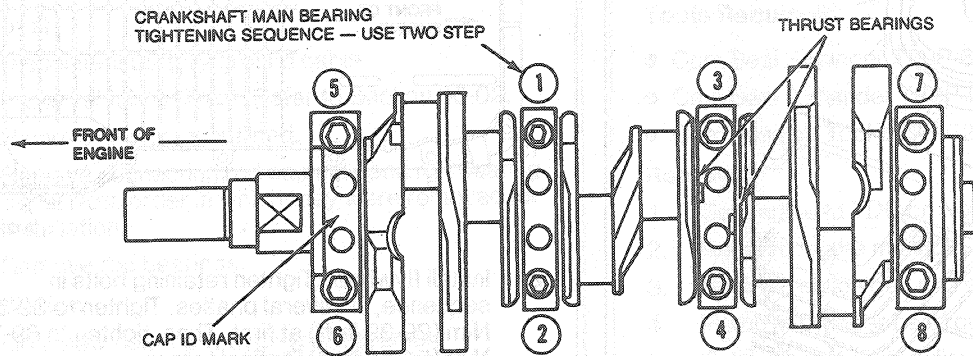


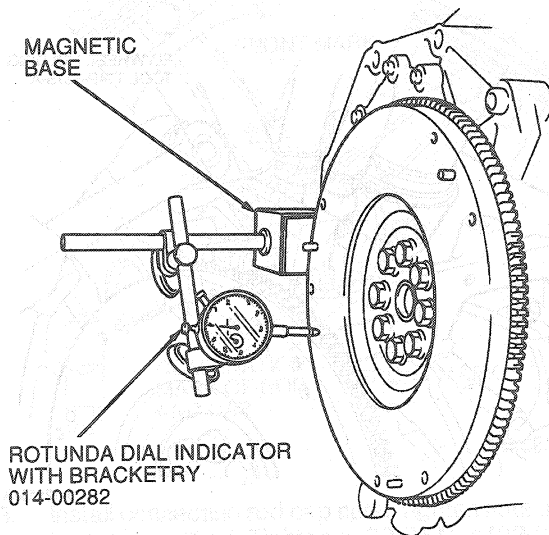
REMOVAL AND INSTALLATION (Continued)

8. Apply a coat of Engine Assembly Lubricant D9AZ-19579-D (ESR-M99C80-A) or equivalent to bearing cap bolts and tighten in sequence shown. Use two-step method. Tighten to 46-69 N-m (34-51 lb-ft), then, tighten to 78-88 N-m (58-65 lb-ft).



A12920-A

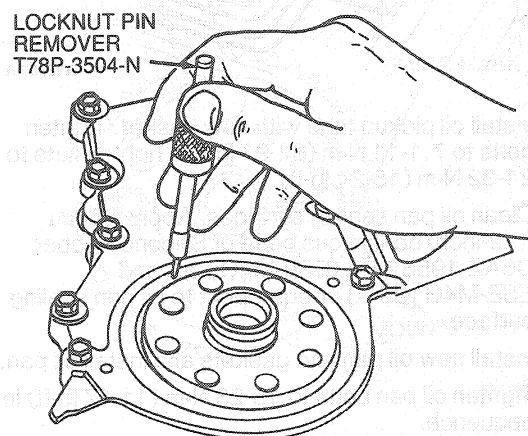
9. Ensure that the crank turns freely. Use caution so as not to contact or jam connecting rods against engine block.
10. With Rotunda Dial Indicator with Bracketry 014-00282 or equivalent, check crankshaft end play: 0.021-0.221mm (0.0008-0.0087 inch). If out of specification, determine if caused by excessive wear on crankshaft, block or both and replace as necessary.



MEASURING CRANKSHAFT ENDPLAY A12916-D

11. Install connecting rods and caps to crankshaft. Tighten retaining bolts using two step method. Tighten to 30-35 N-m (22-26 lb-ft), then to 45-50 N-m (33-37 lb-ft).

12. Install main bearing support beam. Tighten retaining bolts to 21-32 N-m (15-24 lb-ft).
13. Install oil seal carrier with new gasket. Tighten retaining bolts to 6.3-9.4 N-m (56-83 lb-in).
14. Install oil pump with new gasket. Tighten bolts to 15-23 N-m (11-17 lb-ft).
15. Replace front crankshaft oil seal as outlined.
16. Remove rear crankshaft oil seal using Locknut Pin Remover T78P-3504-N or equivalent. Install new rear crankshaft seal with Rear Crankshaft Seal Replacer T81P-6701-A and T88C-6701-BH, with Rear Seal Replacer Screw Set T89P-6701-C or equivalent.



A12906-B