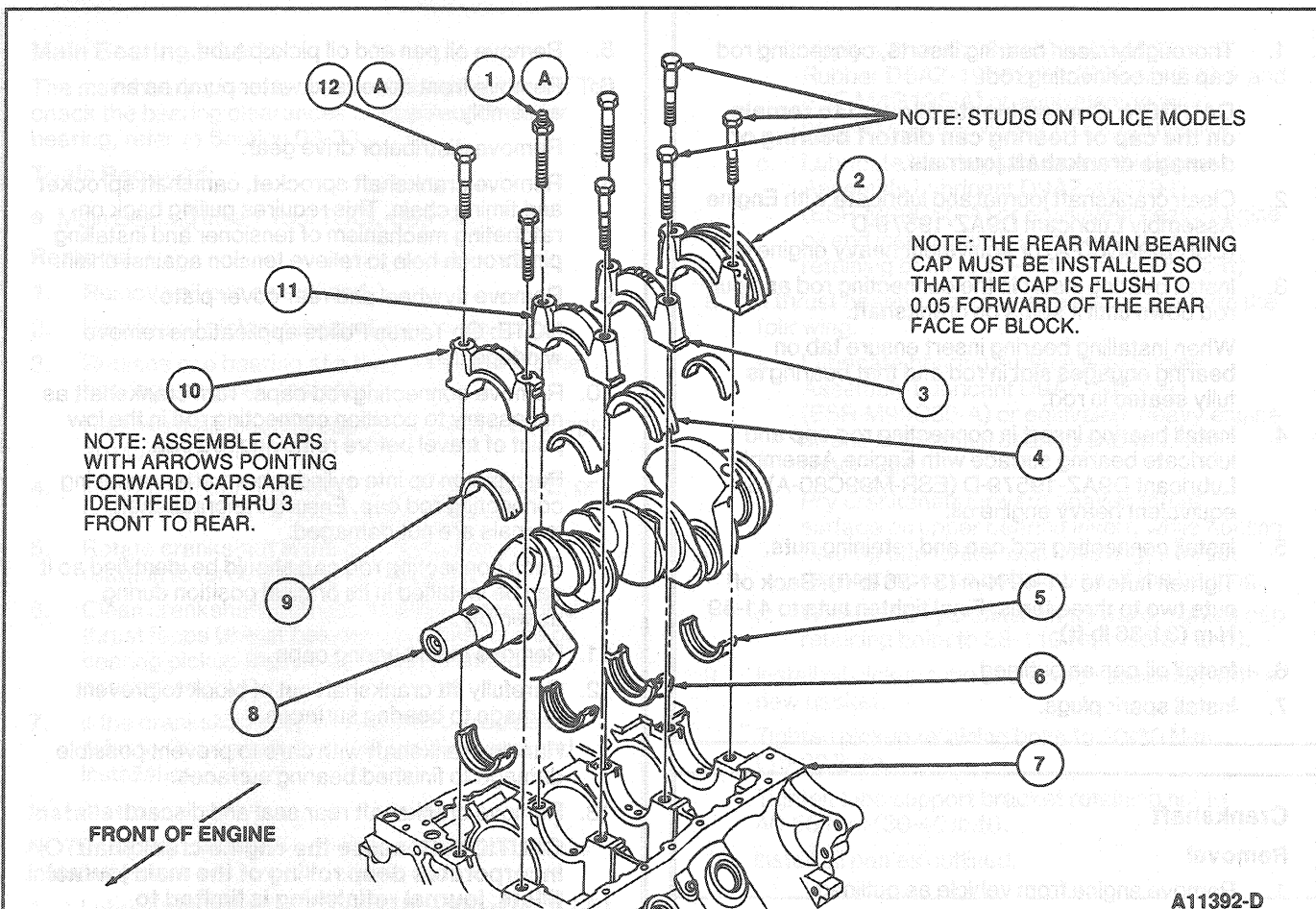


IN-VEHICLE SERVICE (Continued)



Item	Part Number	Description
1A	—	Stud
2	6325	Rear Cap
3	6327	Rear Intermediate Cap
4	6A339	Thrust Bearing-Lower
5	6333	Main Bearing-Upper (3 Req'd)
6	6337	Thrust Bearing-Upper

(Continued)

Item	Part Number	Description
7	6010	Cylinder Block Assy
8	6303	Crankshaft Assy
9	6A338	Main Bearing-Lower (3 Req'd)
10	6329	Front Cap
11	6334	Front Intermediate Cap
12A	—	Bolt (7 Req'd)
A	—	Tighten to 88-110 N-m (65-81 Lb-Ft)

Installation

NOTE: Lightly oil all bolts and stud bolt threads before installation.

CAUTION: Contaminants under a bearing will cause distortion. Contaminants on a bearing surface will cause damage to the crankshaft journals.

1. Ensure all crankshaft bearing surfaces and bearing inserts are clean.

2. If crankshaft main bearing journals have been refinished to a definite undersize, remove main bearing inserts from cylinder block and main bearing caps.
Loosen lower intake manifold attachments prior to installing bearings or measuring bearing clearance.
Install new bearings. Ensure tabs on insert assembly engage slots in the cap and block.
3. Ensure seal groove in cylinder block is clean.
4. Carefully lower crankshaft into position in cylinder block. Be careful not to damage thrust bearing.