

REMOVAL AND INSTALLATION (Continued)

(4) Pry out the front seal with a flat bar screwdriver. Cover the end of the screwdriver with a shop towel.

CAUTION: Be careful not to nick or damage crankshaft flange surface or oil pump housing bore.

INSTALLATION

(1) Install front crankshaft seal and oil pump bearing using Special Tool M93-09817 (Fig. 74).



Fig. 74 Front Crankshaft Oil Seal

- (2) Install crankshaft key and sprocket.
- (3) Install timing belt and covers. Refer to procedure in this section.
- (4) Install crankshaft damper. Refer to procedure in this section.

CRANKSHAFT

The crankshaft is supported in five main bearings. All upper bearing shells in the crankcase bore of grooves. All lower bearing shells installed in the modified main bearing cap are plain. Crankshaft end play is controlled by thrust washers on the rear for three main bearing joints.

REMOVAL

(1) Remove engine assembly from vehicle. Refer to

(4) Mount engine on a suitable support stand.

- (2) Remove oil pan.
- (3) Remove front mounted oil pump assembly (Fig. 75) and (Fig. 76).
- (7) Mark position of each connecting rod and cap. Remove connecting rod bearing caps.

(8) Remove assembled main bearing cap bolts evenly. Remove lower bearing shells and identify for reassembly.

(9) Lift out crankshaft and remove upper thrust washers from each side of number three main bearing in the crankcase (Fig. 75).

INSTALLATION

(1) Install upper main bearing shells making sure top of shells are in alignment, and bearing tabs rest in block ribs. All upper bearings have oil grooves (Fig. 76).

(2) **THRUST BEARINGS.** Crankshaft thrust bearings (washers) are installed in journal #3 opposite from the radial bearings. Thrust bearings are different, one has oil and positioning tabs, while the other is plain. One pair of each thrust washers are installed into the block and one pair into the main bearing cap (Fig. 75).

(3) Apply a thin film of grease to plain side of thrust washers and position them on each side of number three main bearing. Grooved surface towards crankshaft.

(4) Oil the bearings and journals and install crankshaft.

(5) Install lower main bearing shells (without oil grooves) in crankshaft cap.

- (6) Install one pair of thrust washers in cap.
- (7) Carefully install bearing cap with screws (Fig. 76) toward timing belt end.
- (8) Oil the bearing cap bolt threads, install and tighten bolts progressively in sequence shown in (Fig. 76) to 4 N·m (30 ft. lb.).
- (9) Check crankshaft end play by performing the following:

(a) Mount a dial indicator to front of engine bearing probe on base of crankshaft (Fig. 80).

(b) Move crankshaft all the way to the rear end of its travel.

(c) Zero the dial indicator.

(d) Move crankshaft all the way to the front end and read the dial indicator. Refer to Crankshaft Specifications Chart.

(10) Lubricate connecting rod bearings with engine

REMOVAL AND INSTALLATION (Continued)

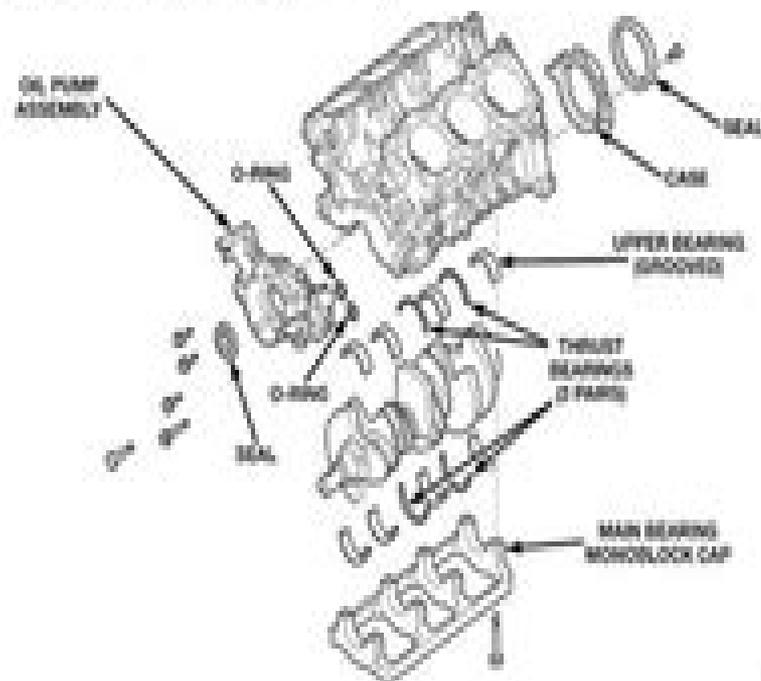


Fig. 75 Crankshaft and Cylinder Block

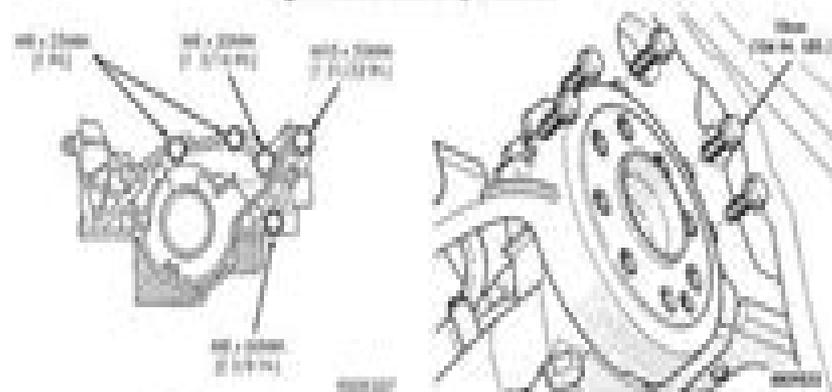


Fig. 76 Oil Pump



Fig. 77 Rear Seal Assembly

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H Kauffman



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