4. Remove the crankshaft cover. Measure the crankshaft journals to check the main bearing clearance. Replace bearings if clearance is not in specification.

Main Bearing Clearance
0.0008 - 0.0027 in (0.020 - 0.069 mm)

5. If replacement of the main bearings is required, refer to Main Bearing Selection and Installation in Cylinder Block Assembly.

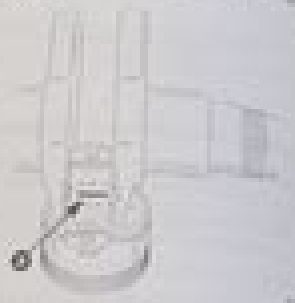
Checking Connecting Rod Bearing Clearance

IMPORTANT: Do not interchange used connecting rod bearings. Reinstall bearings in original position.

1. Clean all oil and dirt from the connecting rod bearing surfaces and connecting rod journals on the crankshaft.

NOTE: Refer to instructions in Cylinder Block Disassembly for selecting and installing connecting rod bearings.

2. Place a piece of plastigage on the connecting rod journals.



1 - Plastigage

IMPORTANT: Do not rotate connecting rod when checking clearance.

3. Install the connecting rod to the respective journal. Tighten connecting rod bolts in sequence and in two steps to the specified torque.

1 - Connecting Rod Bolts

Connecting Rod Bolt Torque
1st: 53 lb. in. (6 N·m) 2nd: 150 lb. in. (17 N·m)

4. Remove the connecting rod cap. Measure the compressed plastigage to check the connecting rod oil clearance. Replace bearings if oil clearance is not in specification.

1 - Plastigage

Connecting Rod Oil Clearance
0.0008 - 0.0026 in (0.020 - 0.066 mm)

Thermostat

1. Measure the lift of the thermostat at the operating water temperature listed.

Water Temperature	Valve Lift
78° - 82° F (26° - 62° C)	0 in. (0 mm)
Above 198° F (70° C)	Minimum 0.12 in. (3 mm)

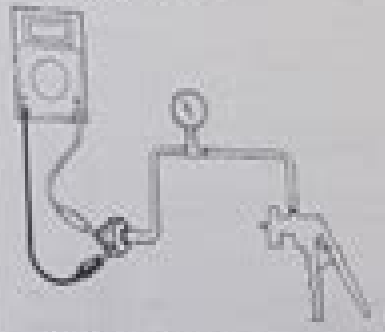
Temperature Switch

1. Check continuity of switch.

Temperature Switch Continuity Check	
Below 170° F (77° C)	No Continuity
Above 170° F (77° C)	Continuity

Oil Pressure Switch

1. Check continuity of switch.



Oil Switch Switch Continuity Check	
Below 2.9 PSI (20.0 kPa)	Continuity
Above 2.9 PSI (20.0 kPa)	No Continuity

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Judd E. Hollander

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