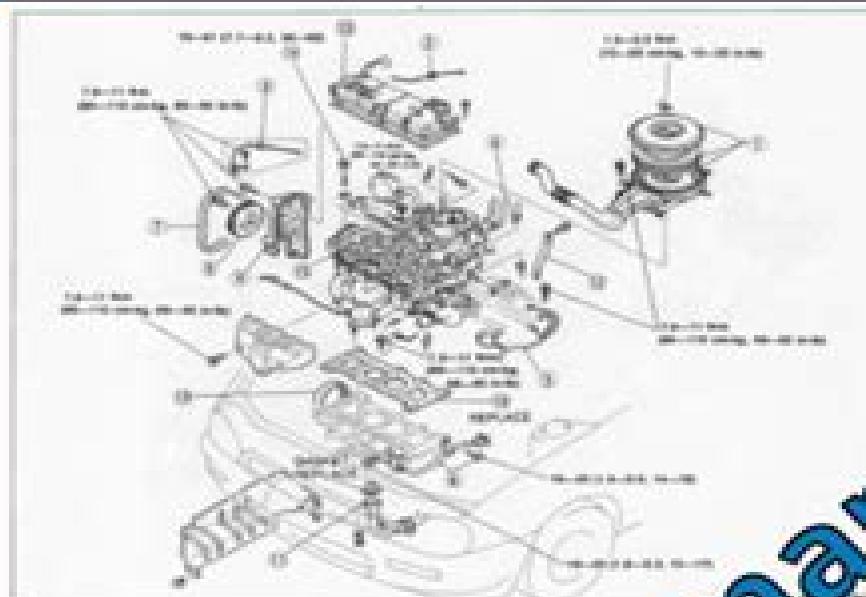


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CYLINDER BLOCK (EXTERNAL, PLATES)	
Torque Specifications	



1. Before installing the cylinder block, measure the oil clearance as follows.
2. Oil clearance Inspection
(1) Remove the cylinder block.
3. Measure the oil clearance of the main bearing caps.
4. Measure the oil clearance of the front bearing cap.
5. Measure the oil clearance of the rear bearing cap.
- Caution:
 - Do not rotate the cylinder block.
6. Position Flywheel and the journals in the same direction.
7. Install the lower main bearings and the main bearing caps according to the cap number and in order.
8. Tighten the main bearing cap bolts in two or three steps in the order shown in the figure.
9. Remove the main bearing caps, and measure the Flywheel at each journal at the radial position for the smallest clearance and at the opposite point for the largest clearance.
10. If the oil clearance exceeds specification, press the crankshaft and use cylinder main bearings.
(Refer to page B-363.)
11. Oil clearance: 0.0196-0.0200mm (0.0007-0.0004 in)
Maximum: 0.10mm (0.004 in)
12. Apply a liberal amount of clean engine oil to the main bearing caps, main bearings, and main journals.
13. Install the crankshaft and the main bearing caps according to the cap number and in order.
14. Tighten the main bearing cap bolts in two or three steps in the order shown in the figure.

Tightening torque:
50-60 Nm (3.6-4.2 kgf-m, 45-48 lbf-in)

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