

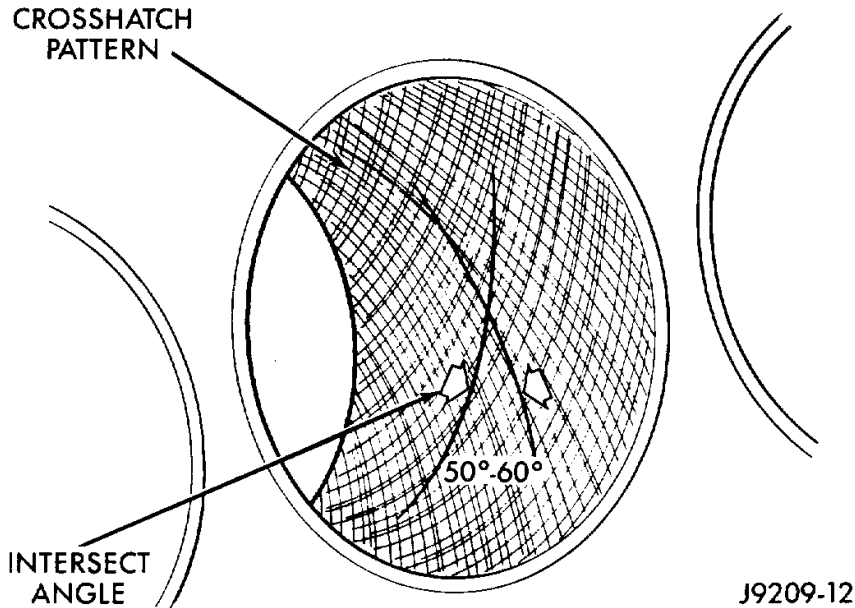
# Component Procedures: Cylinder Block Assembly

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# Component Procedures: Cylinder Block Assembly

## Honing Cylinder Bores (Article 2071437)



### Connecting Rod Bearing (Article 2049104)

Bearing Clearance .....  
0.025-0.076 mm (0.001-0.003 in)  
Preferred .....  
0.044-0.050 mm (0.0015-0.0020 in)  
Side Clearance .....  
0.25-0.48 mm (0.010-0.019 in)

### Connecting Rod Nut/Bolt (Article 2049105)

Connecting Rod  
Nuts ..... 45 Nm (33 Ft. lbs.)

### Connecting Rod, Engine (Article 2049106)

Non Standards  
- Rebuild Specifications (2049107)  
- Torque Specifications (2049120)

### Crankshaft Main Bearing (Article 2049108)

Non Standards  
- Rebuild Specifications (2049109)

### Crankshaft, Engine (Article 2049111)

End Play 0.0015 to 0.0065 in  
Main Bearing Journal 2.4996 to 2.5001 in  
Main Bearing Journal Width No.1 1.086 to 1.098 in  
Main Bearing Journal Width No.2 1.271 to 1.273 in  
Main Bearing Journal Width No. 3-4-5 1.182 to 1.188 in  
Main Bearing Clearance 0.001 to 0.0025 in

### Cylinder Block (Article 2049112)

Deck Height 9.320 in  
Deck Clearance 0.000 in  
Cylinder Bore Diameter-Standard 3.8759 to 3.8775 in  
Cylinder Bore Diameter-Taper (Max.) 0.001 in

Cylinder Bore Diameter - Out-Of-Round (Max.) 0.001 in  
Tappet Bore Diameter 0.9055 to 0.9065 in  
Flatness Per 1 Inch 0.001 in  
Flatness Per 6 Inches 0.002 in  
Flatness Max. For Total Length 0.008 in  
Main Bearing Bore Diameter 2.691 to 2.692 in

### **Piston Ring, Engine (Article 2049113)**

Ring Gap Clearance  
Top Compression Ring ..... 0.229 to 0.610 mm (0.0090 to 0.0240 in.)  
2nd Compression Ring ..... 0.483 to 0.965 mm (0.0190 to 0.0380 in.)  
Oil Control Steel Rails ..... 0.254 to 1.500 mm (0.010 to 0.060 in.)  
Ring Side Clearance  
Compression Rings ..... 0.042 to 0.084 mm (0.0017 to 0.033 in.)  
Oil Control Ring ..... 0.06 to 0.21 mm (0.0024 to 0.0083 in.)  
Piston Ring  
Groove Height  
Compression Rings ..... 1.540 to 1.555 mm (0.0602 to 0.0612 in.)  
Oil Control Ring ..... 4.035 to 4.060 mm (0.1589 to 0.1598 in.)  
Piston  
Ring Groove Diameter  
Compression Ring ..... 87.78 to 87.90 mm (3.456 to 3.461 in.)  
Oil Control Ring ..... 87.50 to 87.75 mm (3.445 to 3.455 in.)

### **Piston, Engine (Article 2049114)**

Non Standards  
- Dimensions (2049115)

### **Pulley, Crankshaft (Article 2049116)**

Torque Specification 108 Nm (80 ft.lbs.)

### **Torque Specifications (Article 2049121)**

Cylinder Block Drain Plugs 30 ft.lb  
Main Bearing Cap Bolts 80 ft.lb