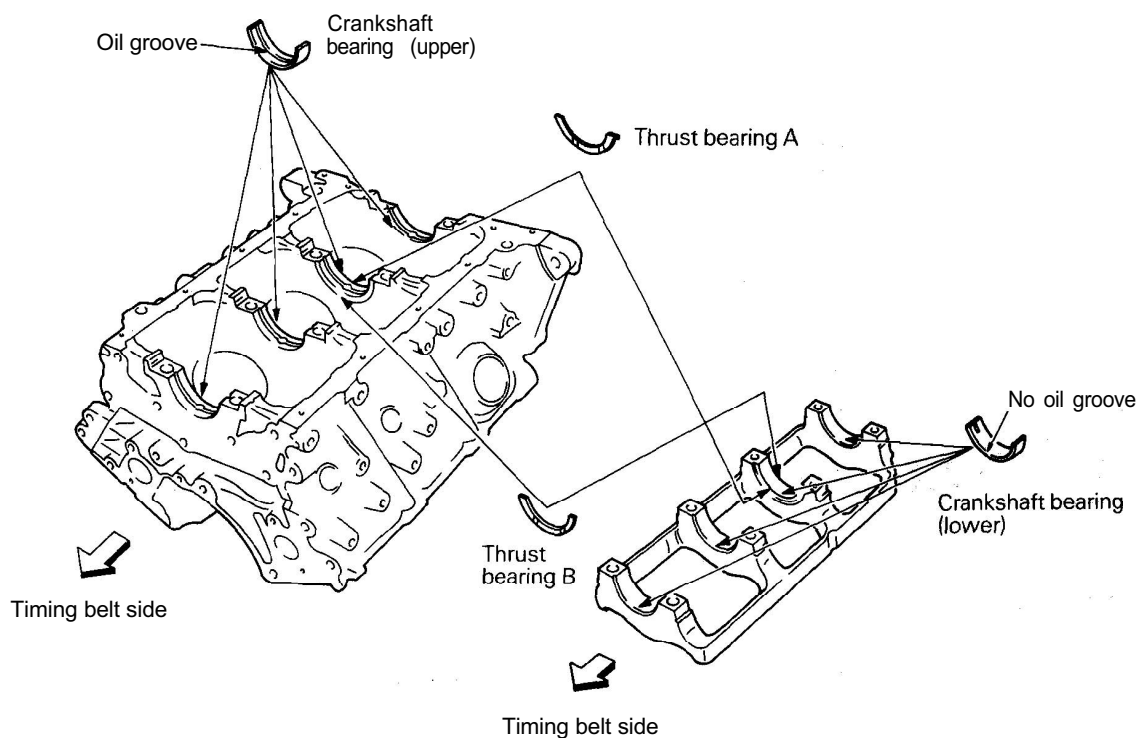


**❖B❖ CRANKSHAFT BEARING (UPPER) /  
THRUST BEARING A / THRUST BEARING B /  
CRANKSHAFT BEARING (LOWER) INSTALLATION**

- (1) Classify the crankshaft bearings (upper and lower) by whether there is an oil groove or not. Then, assemble as shown in the illustration.
- (2) Assemble the thrust bearings (A and B) on the No.3 journal area as shown.

**Caution**

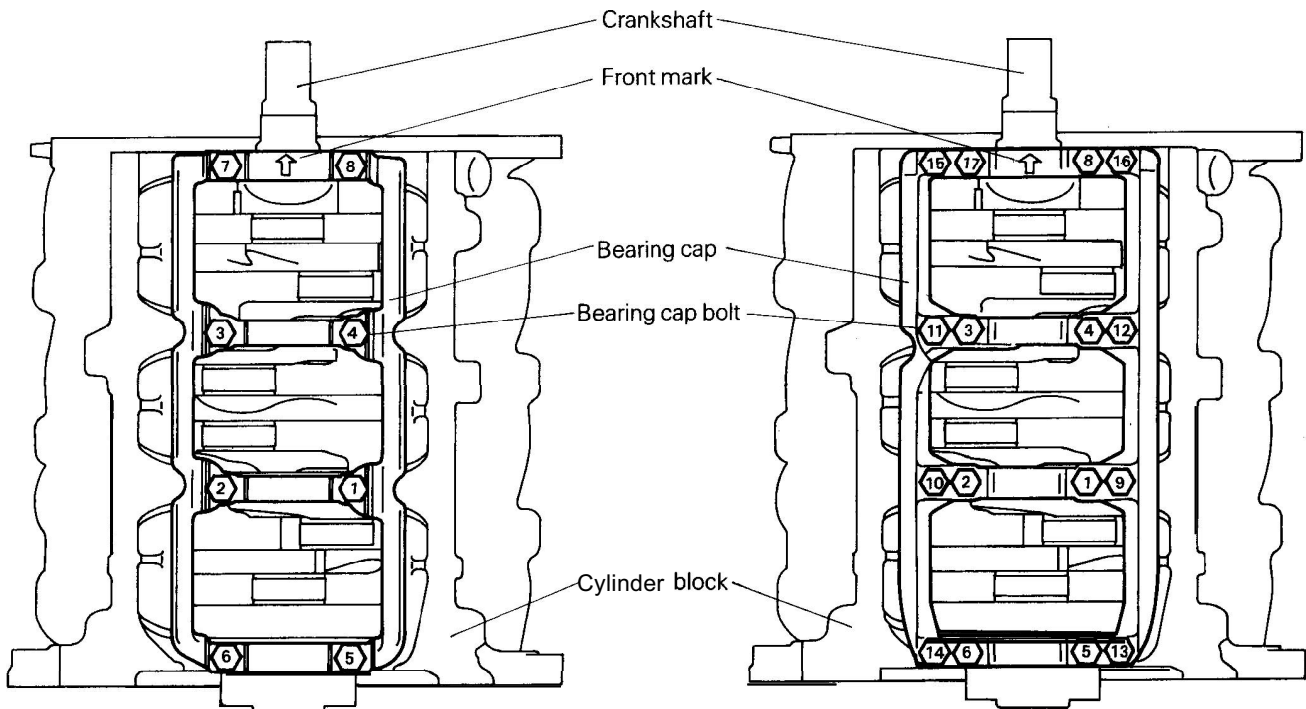
**Install them with the groove side facing outward.**



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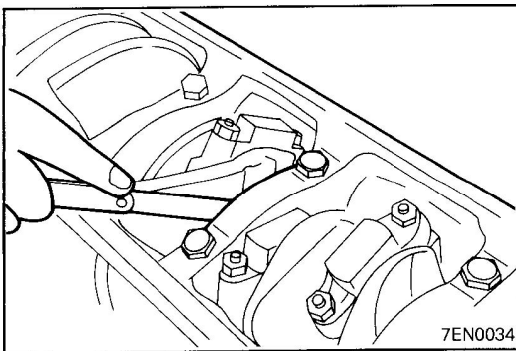
**BEARING CAP / BEARING BOLT INSTALLATION**

- (1) Attach the bearing cap on the cylinder block as shown in the illustration.
- (2) Tighten the bearing cap bolts to the specified torque in the sequence shown in the illustration.
- (3) Check that the crankshaft rotates smoothly.



- (4) Check the end plate. If it exceeds the limit value, replace the thrust bearing.

**Standard value : 0.05 – 0.25 mm (.0020 – .0098 in.)**  
**Limit: 0.3 mm (.012 in.)**

**BEARING CAP STAY INSTALLATION – DOHC TURBO**

- (1) Apply engine oil to the thread and bearing surface of each bolt.
- (2) Temporarily tighten the bolts on the cylinder block side.
- (3) Tighten the bolts on the bearing cap side to the specified torque.
- (4) Finally, tighten the bolts on the cylinder block side to the specified torque.

**NOTE**

The bearing cap stays A and B differ in shape. Install correct ones on correct sides.

