

12th—Draw cutter bar "I" out of case, remove front main bearing cap and take out front centering bushing "E."

13th—Fit new main bearings in the crankcase and bearing caps. The next step is to be sure that the caps are centralized. Fig. 18 illustrates a special tool for this purpose. This tool has three steps or diameters to fit each main bearing and should be placed in position, the bearing caps



Fig. 18—Main Bearing Cap Centralizer

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bolted down with four .002" shims on each side and the centralizer removed. This insures an equal amount of babbit being cut from the circumference of the bearing during the following operations.

14th—With the bearing caps bolted in position, place the expander shown in Fig. 19 in position. First expand the tool up and down and then across by tightening the nut on the end of the



Fig. 19—Main Bearing Cap Expander

expander shaft. Care should be taken during this operation as it is just as important to have the bearing fit the block and the cap as it is to have them fit the crankshaft.

15th—Run cutter bar "I" back in case through the bar supports "C," locating it so the holes for cutter tools will come just in front of bearing to be bored with crank end to the rear of motor.

16th—Fit in cutter tools "H," making sure that their seats are clean, so that they will pull up tight in place.

A special micrometer shown in Fig. 20, can be used to check the main bearing boring machine. This micrometer is of special design, having a "V" type base which will center or align itself with the boring bar, and the micrometer reading is worked out by using the bar diameter as a base; then the micrometer shows in direct reading as to the bore which will be obtained from cutter setting—in other words, if the micrometer shows a reading of 2.225", that is the diameter of the hole which cutter will bore. There is no other calculation to make as there would be with the use of standard micrometers.



Fig. 20—Main Bearing Bar Micrometer

Cutters marked "AC" are for the 1919, 1930 and 1931 six-cylinder engines—cutters for the 1932, 1933, 1934 and 1935 engines are marked "BA." They fit into the 1st, 3rd and 5th holes, counting from crank end of bar.

17th—Locate screw feed attachment parts K-R-N-L to front boring bar support and with feed nut turned to out position, clamp in place.

18th—Now assemble handle extension "J," through the clutch housing aligning bushing and on the boring bar. Attach handle "O," and turn clockwise slowly until cutters have passed through the bearings. (Use kerosene on cutters during boring operation.) Cutters should be passed through bearings the second time for best results.

When this reaming operation is completed, remove bearing caps, remove reamer and blow out all chips from the crankcase with compressed air.

Repair Manual For 1935 Chevy Engine

JL Elias



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