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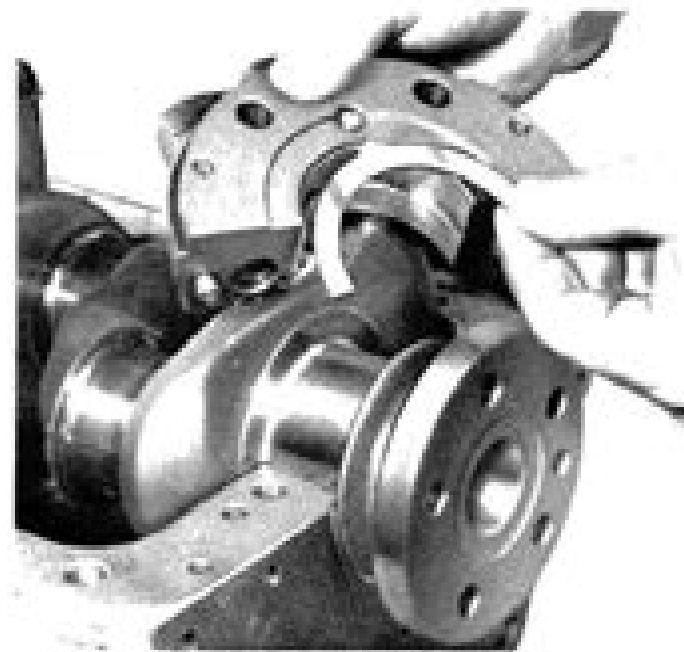
To Renew Main Bearings and Thrust Washers

Removal of the main bearings and thrust washers can be carried out without removing the crankshaft by the following procedure—

1. Remove the engine from its application.
2. Remove the pump and suction pipe assembly.
3. Slacken the setscrews which secure the main bearing caps.
4. Remove completely one of the main bearing caps and remove the bearing shell from the cap.
5. Remove the top half of the bearing shell by pushing it, on the opposite side to the one having the locating tag, with a suitable strip of wood and rotating it on the crankshaft as shown in Fig. H.1.
6. Inspect the bearing shells and if replacements are necessary continue by lightly lubricating and in-
7. Rotate the bearing shell on the crankshaft until it locates correctly with the tag in the machined slot.
8. Locate the lower half bearing shell in the main bearing cap, liberally lubricate and refit.
9. Tighten the two securing setscrews to positively locate the bearing shells then slacken a turn or two.
10. Repeat items 3—8 for the remaining two bearings.

NOTE: To enable the rear main bearing cap to be removed, first remove the two oil seal housing setscrews as shown in Fig. H.3.

11. Finally tighten the main bearings to the torque given on Page B.2.



H4

Perkins 2400 Service Manual

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