

SERVICE PROCEDURES (Continued)

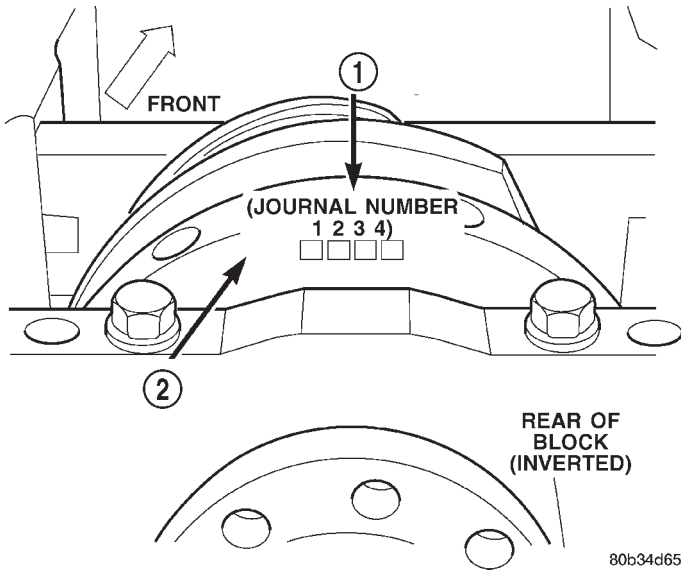


Fig. 29 Crankshaft Main Journal Grade Marking Location

CYLINDER BORE GRADE	CRANKSHAFT MAIN BORE GRADE
CYLINDER NUMBER	MAIN BORE NUMBER
123456 XXXXXX	1234 XXXX

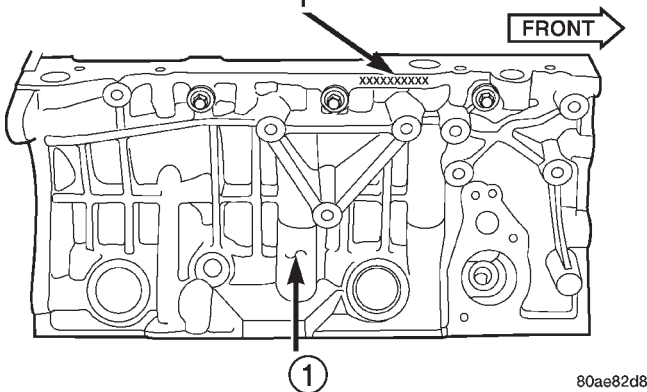


Fig. 30 Cylinder Block Main Bore Grade Marking Location

CRANKSHAFT END PLAY—CHECKING

- (1) Mount a dial indicator to a stationary point at front of engine. Locate the probe perpendicular against nose of crankshaft (Fig. 32).
- (2) Move crankshaft all the way to the rear of its travel.
- (3) Zero the dial indicator.
- (4) Move crankshaft all the way to the front and read the dial indicator. Refer to Engine Specifications.

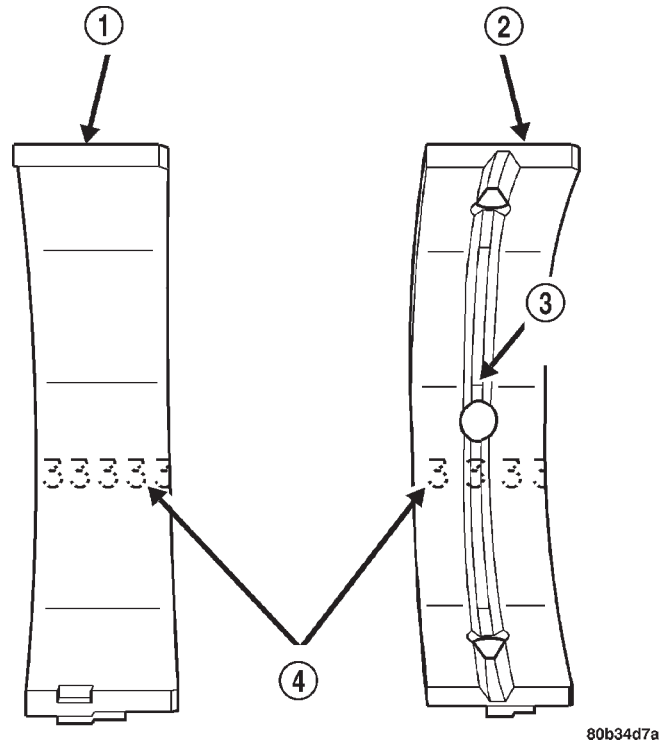


Fig. 31 Main Bearing Grade Marks

- 1 - LOWER MAIN BEARING
- 2 - UPPER MAIN BEARING
- 3 - OIL FEED HOLE AND GROOVE
- 4 - GRADE SELECTION INK MARKS

MAIN BEARING SELECTION CHART—2.7L

Main Bearing Bore Grade Mark			
	1	2	3
Crankshaft Main Journal Grade Mark	1	(3) standard +0.003 mm (+0.0002 in.)	(2) +0.006 mm (+0.0003 in.)
	2	(4) -0.003 mm (-0.0002)	(3) standard (2) +0.003 mm (+0.0002 in.)
	3	(5) -0.006 mm (-0.0003 in.)	(4) -0.003 mm (-0.0002 in.)

VALVE AND VALVE SEAT—REFACING

The intake and exhaust valves have a 44.5 to 45 degree face angle. The valve seats have a 45 to 45.5 degree face angle. The valve face and valve seat angles are shown in (Fig. 33).