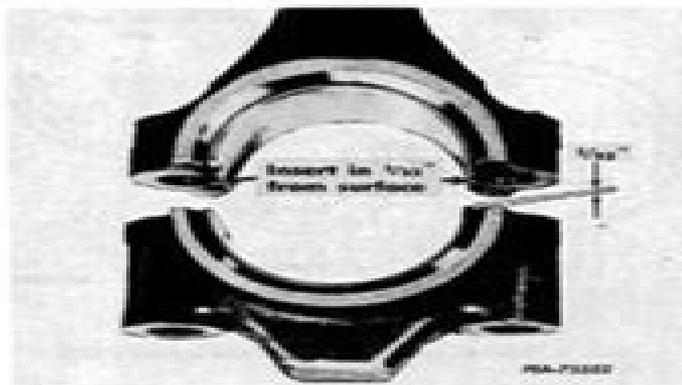


## Connecting Rod Bearing Installation



Illust. 4. Correct connecting rod bearing installation.

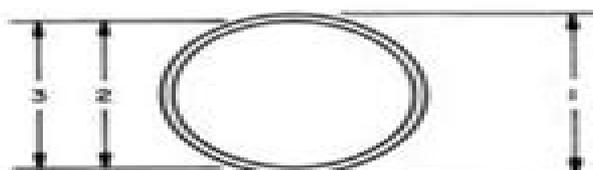
When correctly positioned, the connecting rod cap bearing half will stand out 1/32 inch on both sides above the cap surface and engage inside the rod half bore. See Illust. 4.

Install connecting rod assemblies in the engine so that the ribs on the connecting rod bearings face the camshaft, regardless of where the connecting rod number is stamped.

## Camshaft Bearing Installation

When installing the front and rear bearings ensure that the edges marked 'FRONT' are to the front of the engine and that the holes in the bearings line up with the oil passages in the crankcase. The holes in the center bearing are equal distance from either edge. There is no front marking, but the oil holes must line up with the oil passages.

Press the center bearing into position first, then the other bearings. The rear bearing must be pressed in flush with the front of the bore in the crankcase.



BEARING DIMENSIONS				
		REAR	CENTER	FRONT
1	OD	1.554-1.557	1.712-1.715	1.847-1.850
2	ID	1.490-1.493	1.568-1.571	1.803-1.806
3	ID	LINE REAMED AFTER ASSEMBLY	1.5700-1.5800	1.805-1.810

FEA-75553

Illust. 5. Dimensions of camshaft bearing.

Bearings supplied for service are semi-finished and are to be line-reamed after installation. See Illust. 5.

**NOTE:** For specified bearing clearances refer to "Specifications."

After reaming, thoroughly blow-out the casting and oil passages to ensure that there are no metal deposits present. Install the rear bearing expansion plug. Use a sealing compound on the plug and seat.

# 354 International Harvester Maintenance Manual

**Richard Bailey**



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