

B-6331 MODEL B MAIN BEARING INSTRUCTIONS

CRANKSHAFT SIZE

STANDARD 1.9990/1.9985

010 UNDERSIZE 1.9890/1.9885

020 UNDERSIZE 1.9790/1.9785

030 UNDERSIZE 1.9690/1.9685

040 UNDERSIZE 1.9590/1.9585

BEARINGS IN STOCK STANDARD THRU .040 UNDER SIZE

THE BLOCK AND CAPS WILL REQUIRE ALIGN BORING

HOUSING BORE IN BLOCK 2.1350/2.1345

FINISH 60-90 MICO INCHES RA.

CUT SLOTS IN BLOCK AND CAPS FOR ALIGNING LUGS

SOME BLOCKS THE OIL HOLES MAY NOT BE CONSISTENT. IF OIL HOLE IN BLOCK IS NOT IN LINE WITH OIL HOLE IN BEARING ELONGATE HOLE IN BEARING AND REMOVE ANY BURRS. OIL GROOVES IN BEARINGS WILL PROVIDE AMPLE OIL FOR BEARINGS WITHOUT ALTERING OIL PUMP OR SYSTEM.

THE BACK OF THE REAR MAIN BEARING BLOCK AND CAP IS TO BE COUNTER BORED .125 DEEP AND 2.875 DIAMETER

THE REAR THRUST WASHERS ARE HELD IN PLACE BY COUNTER BORE AND CRANKSHAFT. THE BLOCK THRUST WASHER IS TO BE DOWELED TO BLOCK TO PREVENT ROTATING. THRUST WASHERS ARE NOT TO BE ATTACHED OR SECURED AS THIS CAN CAUSE END LOADING AND ABNORMAL WEAR.

THE FRONT OF THE REAR MAIN BEARING BLOCK ONLY IS COUNTER BORED .125 DEEP AND 2.875 DIAMETER

THE FRONT THRUST WASHER IS HELD IN PLACE BY COUNTER BORE AND CRANKSHAFT. THE CAP NOT COUNTER BORED WILL PREVENT THE THRUST WASHER FROM ROTATING. AGAIN THE THRUST WASHER IS NOT SECURED TO BLOCK.

WE RECOMMEND THE USE OF LINED BEARINGS WITH THE MODEL B CRANKSHAFT. THRUST WASHERS ARE AVAILABLE THRU YOUR BEARING SUPPLIER.