



Figure 17—Honing or re-honing the Main Bearing bores

## CLEANING, INSPECTION, AND REPAIR

A solvent tank, large enough to hold the main engine parts, will be required along with various brush brushes and a grease scraper. A source of compressed air will be helpful in the cleaning operations.

Thorough cleaning is vital for the success of the inspection procedure. Clean include: main engine, cylinder head, piston, and connecting rod. The inspection must be performed with the engine washed and parts in good condition. The visual inspection must be performed in a clean area. If parts are damaged, replace the parts and reinspect.

### BLOCK

#### 1. Clean

1. Wash in solvent.
2. Blow dried surface.
3. Cylinder bores.
4. Oil galleries and passages.
5. Remove dirt or galling plate.
6. Scrape deposits from the crank passages.

#### 2. Inspect

1. All clearance gaps for bore to fit in bearing.
2. Blow the bores for deep scratches and large deposits.
3. Check for cracks.
4. Cylinder walls.
5. Crank pin.
6. Main bearing walls.
7. Main bearing bores and main bearing pins.
8. All main bearing bores should be checked and polished at 1200 grit bearing stones.

The area where the main bearing bores should be checked for main bearing bores should be checked.

If a main bearing bore is damaged and requires replacement, replace it.

1. Check bores for flatness. Use a straightedge and feeler gauge. Bores irregularities may be easily noticed. If more than 0.02 mm (0.0008 in) is shown, replace the bore.

2. If oil seal and timing cover attaching area is damaged, replace the cover.

3. Inspect main bearing surface.

#### 3. Inspect

1. If the main bearing case including surface is not flat, a bearing stone may be used.

### CRANK SHAFT

#### 1. Inspect

1. Check bores for scoring or other damage.

#### 2. Measure

1. Check bore wear and out of round. Use a bore gauge. Measure mechanical, etc. etc.

1. Check bore diameter and out of round. Use a bore gauge. Measure mechanical, etc. etc.

## PISTON AND CONNECTING ROD ASSEMBLIES

Refer to GENERAL ENGINE MECHANICAL, etc. etc. and perform the following:

### 1. Disassemble

1. Components as required.

### 2. Clean

1. Components as required.

### 3. Inspect

1. Components as required.

### 4. Measure

1. Piston pin diameter and clearance.

2. Piston to bore clearance, and fit in cylinder.

3. Remove rings from the piston to be used.

4. It is not necessary to remove the connecting rods from the piston.

5. If the connecting rod is damaged or cannot be used, replace it. A ridge at the top of the cylinder cannot be repaired by grinding.

6. Check the piston and cylinder clear. Place a piston pin and assembly for the bore to be used and measure it clear into the bore with the top of the piston skirt.

7. The piston should slide freely through the bore. If it does not, the piston is not damaged when it slides through the bore. If the piston does not slide through the bore, it is too tight and another piston should be selected. Check the proper piston and bore for assembly.

8. After a piston has been selected, which will slide freely through the bore, measure it to fit the bore.

9. Place a feeler gauge (0.005 mm) for used pistons. (0.002 mm) for new pistons. It must be at least 100 mm long and not over 12 mm wide. Insert into the bore with the selected piston. Hold the feeler gauge to the top of the bore.

10. Position the selected piston into the bore (the skirt) into the bore. It is 10 to 20 mm from the top of the bore. The feeler gauge must be 10 mm from the piston pin. If the piston fits into the bore, the piston is correctly fitted in the bore. If the piston does not fit into the bore, it is too small and a larger piston is required. Check the proper piston and bore for assembly.

11. When checking bore and pin hole, it is possible that a piston that does not fit and ring will be used.

### 12. Assemble

1. Components as required.



Figure 18—Checking Main Bearing Flange Alignment

### 1. Important

1. Each connecting rod and bearing cap should be marked, beginning at the base of the engine. Cylinders 1, 4 and 5 are at the top back and 1, 4 and 5 are the right back. The numbers on the connecting rod and bearing cap must be on the same side when inserted in the cylinder bore. If a connecting rod is not marked from start to finish, it is possible that the connecting rod bearings should be used and the connecting rod should be replaced to correspond with the new cylinder number.

### 2. Measure

1. Ring and gap and ring clearance.

### 3. Inspect

1. Ring fit.

## INTAKE AND EXHAUST MANIFOLDS

### 1. Clean

1. All parts of gasket from the gasket surface.
2. Excessive carbon buildup in the intake passages of the intake manifold.
3. Scrape and remove from the exhaust passages of the exhaust manifold.
4. All passages of excessive carbon deposits.

### 2. Inspect (Figure 19)

1. Manifold for cracks, broken flanges, and gasket surface damage.
2. Alignment of manifold flanges. Use a straight edge and feeler gauge. If the flanges are out of alignment by more than 0.1 mm (0.004 in), the manifold is cracked and should be replaced.

# Chevrolet Truck Repair Manual

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