

1.25. RIFF-76

Thickness of Thrust Semi-Rings

Normal Thickness (Inches)	Oversized Values		
	1st .003"	2nd .004"	3rd .005"
From .09291"	.09566"	.09685"	.09763"
To .09094"	.09370"	.09488"	.09566"

Crankshaft Mounting Clearances

<u>PARTS</u>	<u>CLEARANCES IN INCHES</u>
Main pin and crank pin permissible ovalization	.0011"
Between main pins and bearings (radial clearance)	.0025" - .0033"
Between thrust rings and crank- shaft (axial clearance)	.003" - .007"
Between crank pins and bearings (radial clearance)	.0023" - .0031"
Between two flanked connecting rods and crank pin shoulders (axial clearance)	.0078" - .0118"

NOTE:

Check carefully the condition of the Silicone type oil seal before installing it.

Lubricate seal lip with oil and check retainer for eventual damaged spots.

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