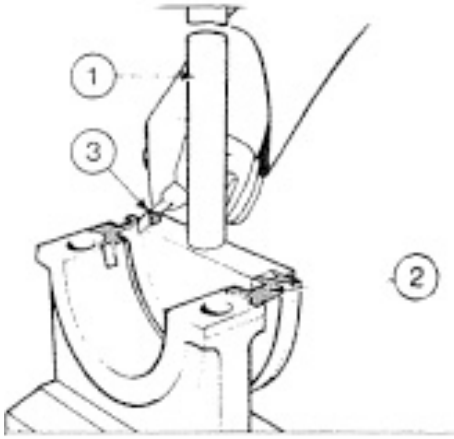


### CRANKSHAFT SEAL INSTALLATION

**13.** Install the graphited fiber rope type seal into the groove in the rear main bearing cap and the cylinder block. DO NOT use any sealer or adhesive. Tap the seal fully home into the respective grooves using Seal Installer 21-506 as shown in Fig. 47. With each half seal held with the installer, trim the ends of the seal with a sharp knife or scalpel to leave 0,635 to 0,762 mm (0,025 to 0,030 in) proud of the face. Trim off any frayed threads.



**Fig. 47 - Fitting Crankshaft Rear Oil Seal - (Main Bearing Cap Shown)**

1. Installer (21 -506)
2. Seal
3. Trim Seal

**14.** Ensure the main bearing housings and caps are perfectly clean and dry and fit the main bearing liners into their respective positions, with the locating tongues engaged in the slots.

**NOTE:** The liners with oil holes and a continuous oil groove fit into the block, those without oil holes fit into the caps. The centre and rear main bearing cap liners only, have a continuous oil groove.