



## CONNECTING ROD SELECTION

### Connecting rod bearing grade number:

These numbers are punched in either Arabic or Roman numerals.

Crank pin grade number	Connecting rod bearing grade number
0	0
1	1
2	2

### Identification color:

Grade 0; No color

Grade 1; Black

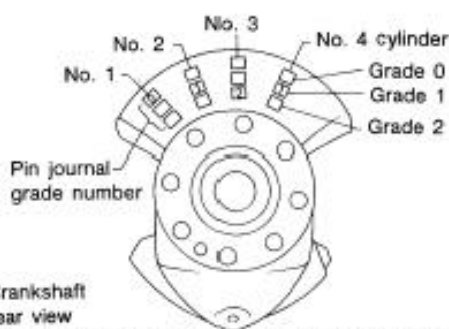
Grade 2; Brown

Connecting rod bearing clearance =

Standard: 0.020 - 0.045 mm (0.0008 - 0.0018 in)

Limit: 0.065 mm (0.0026 in)

**ALWAYS MEASURE FINAL CLEARANCE**



Crankshaft rear view

(OR SEE TYPE 1 BELOW IF NOT SHOWN AS ABOVE)

## MAIN BEARING SELECTION

Calculate main bearing clearance.

Main bearing clearance =

Standard: 0.004 - 0.022 mm (0.0002 - 0.0009 in)

Limit: 0.050 mm (0.0020 in)

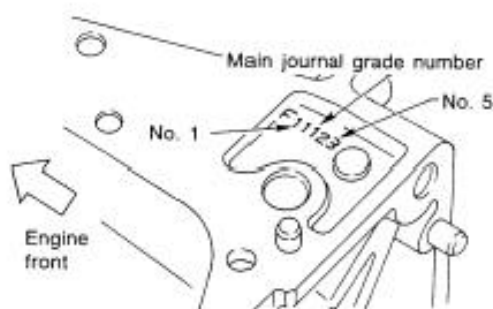
For example:

Cylinder block main journal grade number: 1

Crankshaft main journal grade number: 2

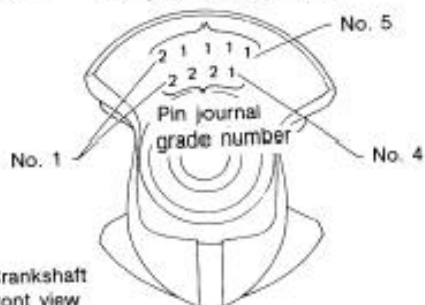
Main bearing grade number =

$1 + 2 = 3$  (D, Yellow)



Type I

Main journal grade number



Crankshaft front view

Type II

Main journal grade number



Crankshaft front view

### How to Select Main Bearings (Identification mark and color)

Crankshaft main journal grade number	Cylinder block main journal grade number			
	0	1 or I	2 or II	3 or III
0	0 (A, Black)	1 (B, Brown)	2 (C, Green)	3 (D, Yellow)
1 or I	1 (B, Brown)	2 (C, Green)	3 (D, Yellow)	4 (E, Blue)
2 or II	2 (C, Green)	3 (D, Yellow)	4 (E, Blue)	5 (F, Pink)
3 or III	3 (D, Yellow)	4 (E, Blue)	5 (F, Pink)	6 (G, No color)