

- C. Measure the distance from the outer race to the inner race at three (3) different locations — approximately 120° apart. Then take the average value for that bearing. (See Figure 9.)
- D. Repeat Steps A through C on the second bearing to obtain the "end difference" value for that bearing.
- E. Add the two (2) "end difference" values (obtained in Steps C and D) together and record this measurement as dimension "D." Then proceed to either Step F or G below, whichever applies.
- F. If dimension "D" is .006" (0.152 mm) or less, make bearing spacer (W) the same length as bearing spacer (X) using dimension "C" as found in Step 12.
- G. If dimension "D" is greater than .006" (0.152 mm), add dimension "D" to dimension "C" (found in Step 12) and subtract .006" (0.152 mm). Record this measurement as dimension "E." This is the required length for bearing spacer (W). (See Figure 8, page 12.)
14. Using a precision measuring device, measure the actual length of bearing spacer (W). Record this measurement as dimension "F."
15. Compare dimension "F" to dimension "E." In order to provide the recommended bearing endplay,

16. Fit the bearings into the flywheel bore. Begin by measuring the outside diameter of each of the bearings and the inside diameter of the flywheel bore. Then compare the largest outside bearing diameter measurement to the inside diameter of the flywheel. If the bearing fit is tighter than .0007" (0.0178 mm), the flywheel bore must be honed.
17. Install inner and outer bearings (U and V), bearing spacers (W and X) in the flywheel bore. The bearings should be installed such that the "retaining ring side" of each bearing is facing inward.
- NOTE:** Make certain the bearings are installed properly. The inner bearing (U) has a larger inside diameter.

**NOTE:** The effective length of the bearing spacer may be increased by welding or brazing several "spots" on one end of the spacer — minimum of one per every inch of circumference — and then grinding any excess material off the "spotted areas" to obtain the correct overall length.

(See NOTE below.)

bearing spacer (W) must be equal in length to dimension "E." Therefore, if dimension "F" is greater than dimension "E," bearing spacer (W) must be ground to the correct length. Conversely, if dimension "F" is less than dimension "E," bearing spacer (W) must either be replaced or lengthened.

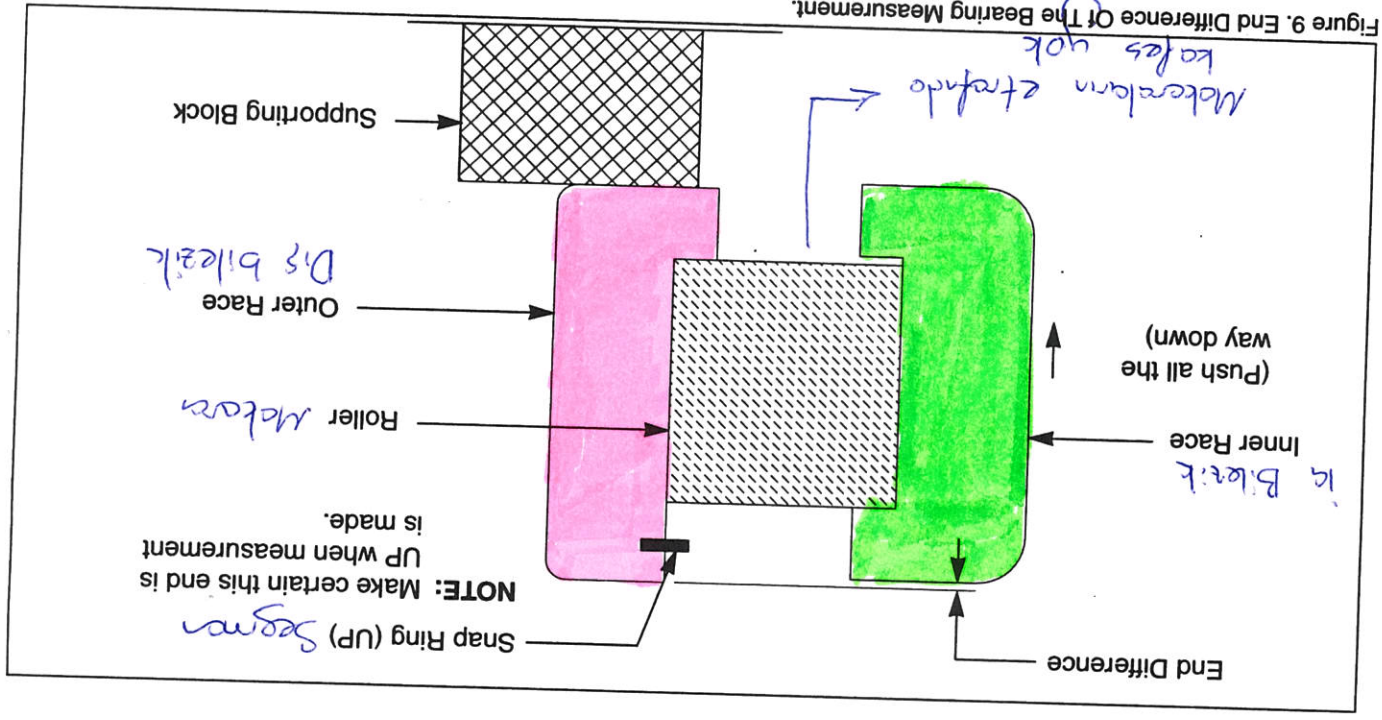


Figure 9. End Difference Of The Bearing Measurement.

1c Cap 130 mm  
 Dis Cap 230 mm  
 Radial 40 mm  
 2 odet