

Enginetech Inc
Tech Assistance 800-410-3664 ext. 340 or 237

TECHNICAL BULLETIN	
	December 1998 TB 1522
Mfg:	GM
Model:	C-SERIES
Liter:	6.5L
V I N:	F
Year:	92-00

Main Bearing Bolt Installation On
1992-97 GM 6.5L VIN F, S, & Y Engines

The AERA Technical Committee offers the following information on main bearing bolt installation on 1992-97 GM 6.5L VIN F, S & Y diesel engines. GM revised the outer, intermediate main bearing bolts beginning on March 13, 1997. At the above mentioned date the size of the 6 outer intermediate bolt holes was reduced from 12 mm, to 10 mm in size. With this revision, the installation procedure was also revised.

All main bearing caps should be located in their proper registers with a soft face mallet. Do not use bolts to pull down caps. All bolts should be clean and show no signs of stretch or thread damage. The bolts should also have a light coating of engine oil on the threads and bolt head underside.

Engines With 12mm & 10mm Main Bolts

1. Install main caps 1,2,4 & 5 and inner 12mm lubricated bolts, torque mounting bolts to 55 ft. lbs.
 2. Install number 3 main cap (thrust) and inner 12mm lubricated bolts, torque mounting bolts to 10 ft. lbs. Move the crankshaft rearward and then forward to align thrust bearing surfaces.
 3. Torque number 3 main cap inner bolts to 55 ft. lbs. Measure crankshaft end play in front of number 3 thrust bearing with crankshaft moved forward. Proper end clearance is .004-.010" (.10-.25mm).
 4. Re-torque inner 12mm bolts to 55 ft/lbs. Then, turn inner 12 mm bolts an additional 90 degree turn.
 5. Torque outer 12mm lubricated cap bolts (numbers 1 & 5) to 48 ft. lbs.
 6. Repeat step 5.
 7. Tighten the outer 12mm bolts (numbers 1 & 5) an additional 90 degree turn.
 8. Torque the outer 10mm lubricated cap bolts(numbers 2, 3 & 4) to 30 ft. lbs.
- CAUTION:** Do not rotate 10 mm bolts an additional 90 degree turn.

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Reference:	
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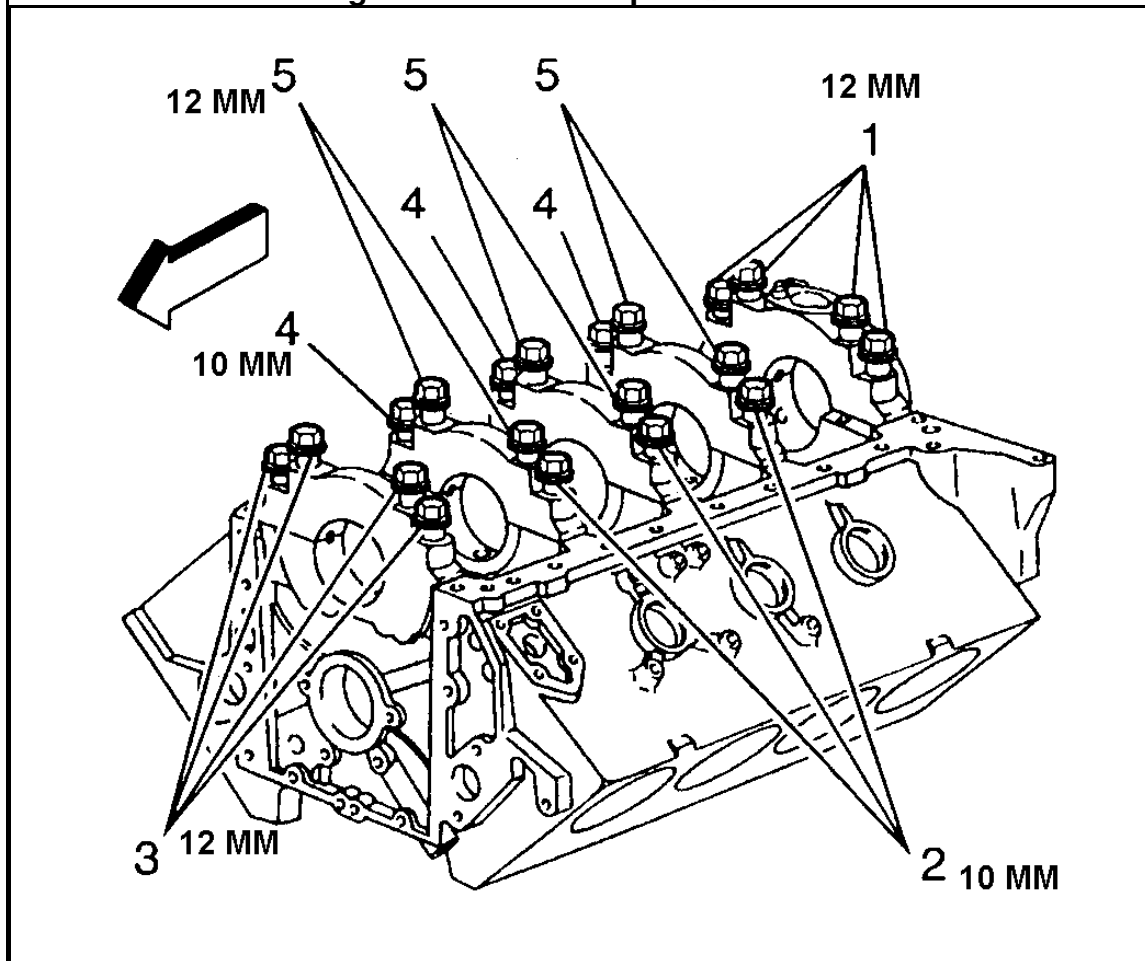
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Determining which bolts are being used before assembly is advised to prevent over torque of the 10 mm bolts. All GM replacement engines will have the two different size bolt cap and should use the revised procedure listed above.

The AERA Technical Committee

Bulletin Diagram: Untitled Graphic #2282 for TB 01522



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