

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

TECHNICAL BULLETIN	
	February 2000 TB 1773
Mfg:	FORD
Model:	TAURUS
Liter:	3.0L
V I N:	S
Year:	96-06

Crankshaft & Main Bearing Installation For
1996-99 Ford 3.0L VIN S Engines

The AERA Technical Committee offers the following information on crankshaft and main bearing installation for 1996-99 Ford 3.0L VIN S engines. This engine uses a separate bedplate, which contains the lower main bearing supports. This plate is also attached to the outside of the block pan rail and houses and seals the oil pan. The installation of this multi-function bedplate requires specific procedures to ensure a durable engine life.

Crankshaft and main bearing installation:

1. Insure the block is thoroughly cleaned and install upper crankshaft main bearings into upper cylinder block. Lubricate the bearing surface and install crankshaft. Pry the crankshaft rearward, lubricate the upper thrust washer and install it by rolling thrust washer into machined groove between crankshaft and cylinder block.
2. Install the lower main bearing shells and lubricate bearing surfaces. Install the crankshaft thrust bearing onto lower cylinder block. Clean upper and lower cylinder block mating surfaces. Apply Black Silicone Rubber (F4AZ-19562-B) to specified areas on lower cylinder block. (See Figure 1)
3. Install lower cylinder block over alignment dowels and onto upper cylinder block. INSTALL NEW lower cylinder block to upper cylinder block to upper bolts numbers 1-16. (See Figure 2) Install remaining lower cylinder block to upper cylinder block bolts.
4. Ensure stud bolts are used in the correct locations for reassemble of oil pan baffle. (See Figure 3) Tighten lower cylinder block to upper cylinder block bolts in sequence to 27-44 in lbs. (3-5 Nm) (See Figure 2)
5. Pry crankshaft rearward, and seat crankshaft thrust washer forward. Tighten bolts numbers 1-8 to 16-21 ft lbs. (22-28 Nm), in sequence. (See Figure 2) Tighten bolts numbers 9-16 to 27-32 ft lbs. (37-43 Nm) in sequence. Tighten

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- bolts numbers 1-16 an additional 85-95 degrees of rotation in sequence.
Tighten bolts numbers 17-22 in sequence to 15-22 ft lbs. (20-30 Nm)
6. Ensure crankshaft rotates freely and end play is within specifications. If end play is not within specification, check crankshaft thrust face or replace thrust bearing.

The AERA Technical Committee

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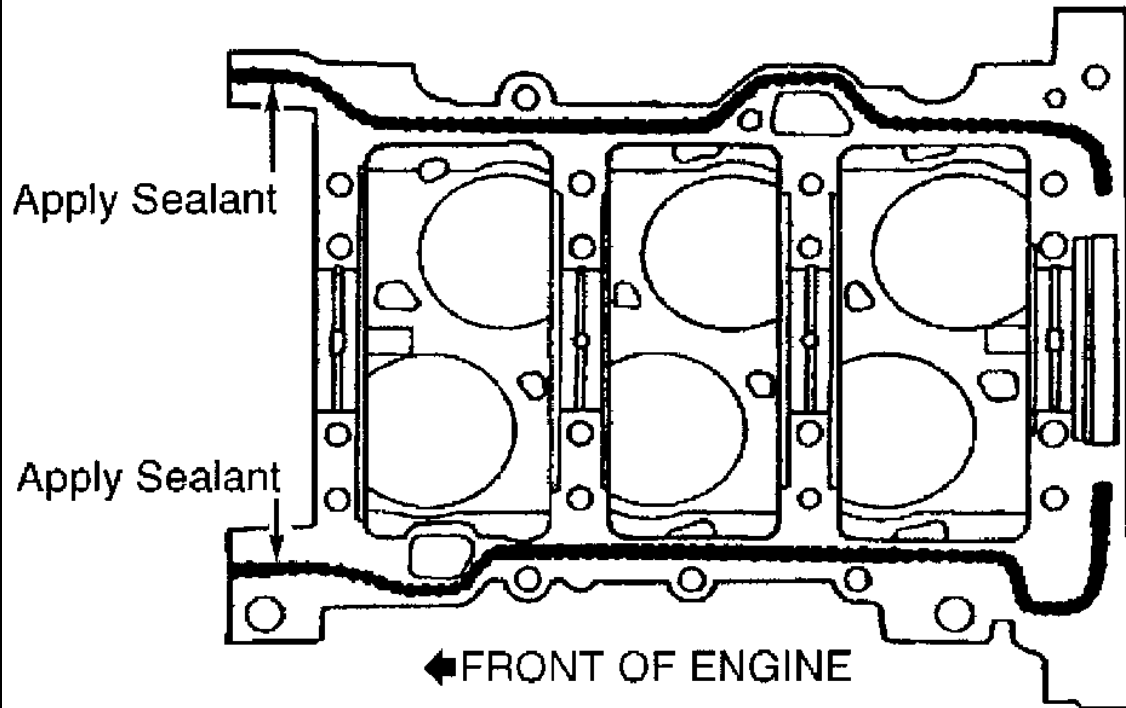
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Bulletin Diagram: TB 1733 Figure 1



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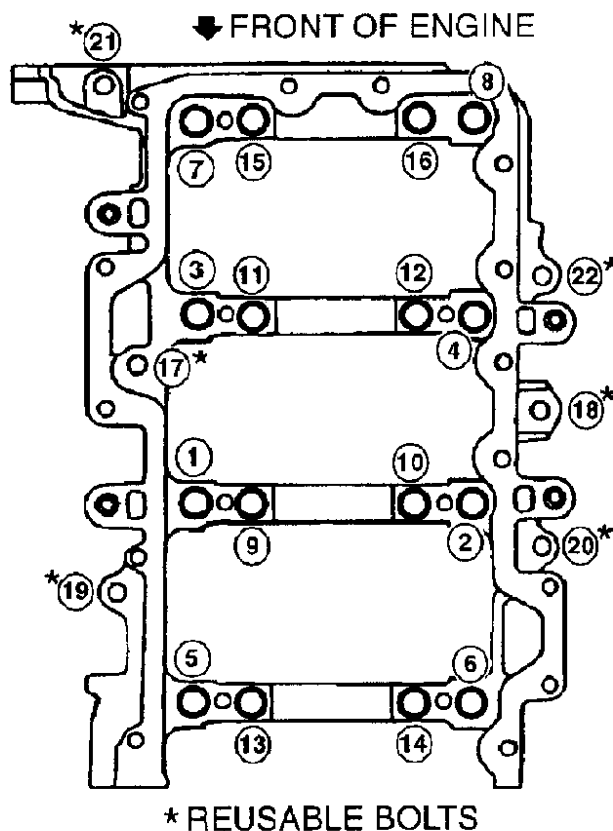
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Bulletin Diagram: TB 1773 Figure 2



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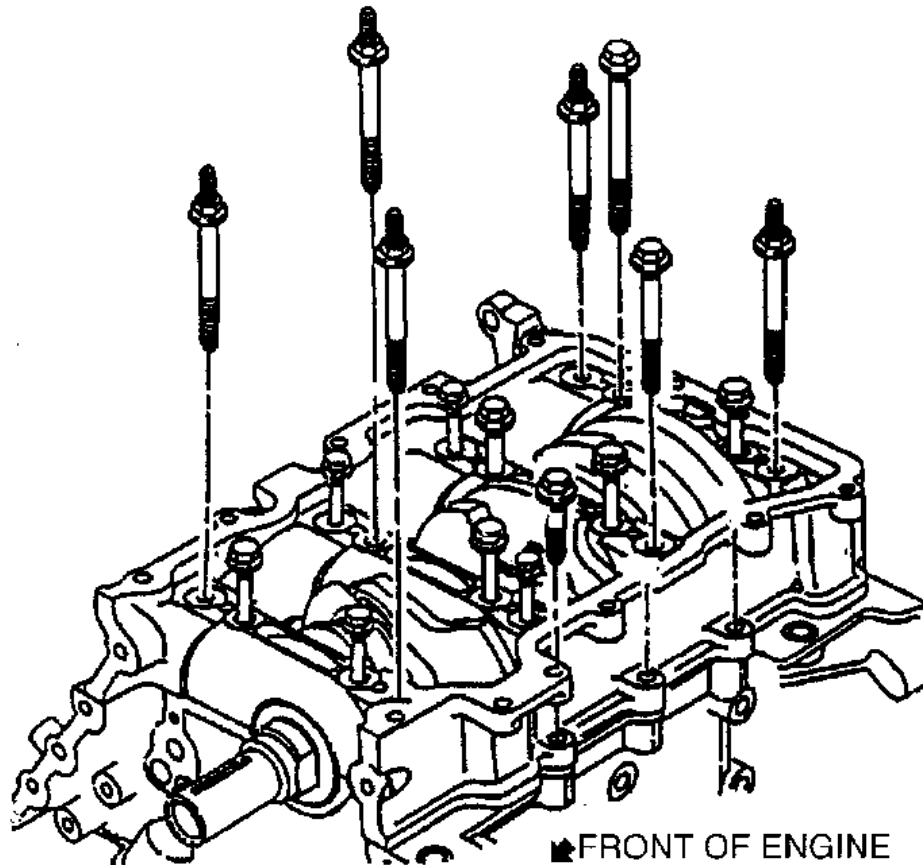
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Bulletin Diagram: TB 1773 Figure 3



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