

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

TECHNICAL BULLETIN		Mfg: CHRYSLER
	June 2003 TB 2039R	Model: STEALTH
		Liter: 3.0L
		V I N: J
		Year: 93-95

Main Bolt Tightening Caution For
1992-1999 Mitsubishi 4G & 6G Series Engines

The AERA Technical Committee offers the following information for main bolt tightening caution on 1992-1995 Mitsubishi 4G & 6G series engines. Information previously published in the OEM service manuals was incorrect and the following specifications should be used. The information in TB 2039 has been updated and it should be destroyed, as it is no longer valid information.

To install non-elastic main bearing bolts, the following procedure is applicable to all vehicles/engine listed below.

Tighten the bolts on each main bearing cap equally until the specified torque is achieved. Use the bolt-tightening sequence shown in Figure 1 if applicable.

Years	Models	Engine	Torque
1992-95	Mirage	4G1/1.5L	38 ft/lbs (53 Nm)
1992-94	Eclipse	4G3/1.8L	38 ft/lbs (53 Nm)
1992	Galant, Expo & Truck	4G6/2.0&2.4L	38 ft/lbs (53 Nm) SOHC
1992	Eclipse, Galant	4G6/2.0L	49 ft/lbs (68 Nm) DOHC
1992-95	Truck, Montero, Galant, Diamante	6G7/3.0L	57 ft/lbs (79 Nm) SOHC
1993-95	Diamante Wagon	6G7/3.0L	57 ft/lbs (79 Nm) SOHC
1992-95	Diamante & 3000 GT Non/Turbo	6G7/3.0L	67 ft/lbs (93 Nm) DOHC
1992	3000 GT	2 bolt 6G7/3.0L	67 ft/lbs (93 Nm) DOHC Turbo
1993-95	3000 GT	4 bolt 6G7/3.0L	54 ft/lbs (74 Nm) DOHC Turbo
1994-95	Montero	6G7/3.5L	54 ft/lbs (74 Nm) DOHC Turbo

Elastic main bolt tightening (plastic-angle tightening method). Before reusing main

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bolts measure the shank lengths of ALL the main bearing bolts. If the measurement of 2.799" (71.100 MM) is exceeded or the bolt has visual damage REPLACE THE BOLTS. Measure from the tip to the shoulder under the bolt head (not to the shoulder of the washer) see figure 3.

To tighten elastic main bearing bolts using the plastic/angle tightening method; the following procedure is applicable to all the engines listed below.

1. Torque bolts (in sequence see figure 2) to specification 18 ft/lbs.
2. Using a breaker bar (not a torque wrench), tighten each bolt 90°.
3. Using a breaker bar (not a torque wrench), turn each bolt an additional 90°.

The following vehicles/engines use elastic main bearing bolts:

1993-95	Mirage	4G9/1.8L	18 ft/lbs (25 Nm) Plus 90°, +90°
1992-95	Expo LRV	4G9/1.8L	18 ft/lbs (25 Nm) Plus 90°, +90°
1993-95	Eclipse	4G6/2.0L	18 ft/lbs (25 Nm) Plus 90°, +90°
1993	Galant	4G6/2.0L	18 ft/lbs (25 Nm) Plus 90°, +90°
1993-95	Expo, Expo LRV, Truck	4G6/2.4L	18 ft/lbs (25 Nm) Plus 90°, +90°
1994-95	Galant	4G6/2.4L	18 ft/lbs (25 Nm) Plus 90°, +90°

The AERA Technical Committee

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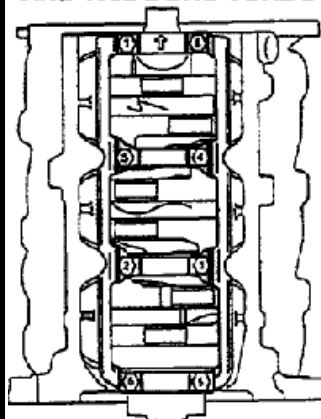
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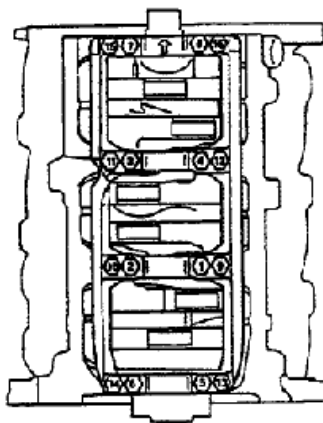
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Bulletin Diagram: 2.5, 3.0 & 3.5L MAIN BEARING BOLT TORQUE SEQUENCE - CYLINDER BLOCK

**6G7 (2.5 L, 3.0L), SOHC
AND 1992 DOHC TURBO***



6G7 (3.0L, 3.5L) DOHC



*
REFER TO THE ENGINE OVERHAUL
MANUAL FOR INFORMATION
CONCERNING THE BEARING
CAP STAYS USED ON THE 1992
DOHC TURBO ENGINE

NOTE: THE ENGINES SHOWN
HERE USE A BEARING CAP
ASSEMBLY, INSTEAD OF
INDIVIDUAL BEARING CAPS

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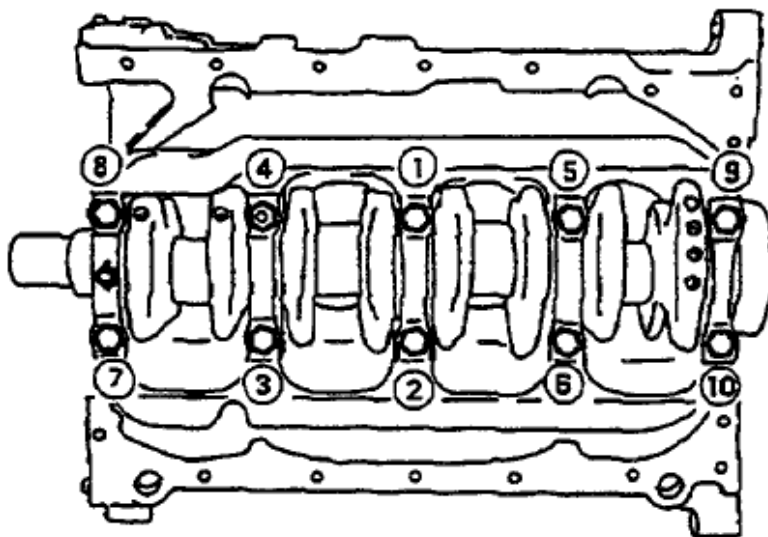
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Bulletin Diagram: 4G6 & 4G9 MAIN BEARING BOLT TORQUE SEQUENCE - CYLINDER BLOCK

4G6 (FROM 1993) AND 4G9 ENGINES



NOTE: 4G6 ENGINE IS SHOWN, HOWEVER, 4G9 ENGINE UTILIZES THE SAME TIGHTENING SEQUENCE.

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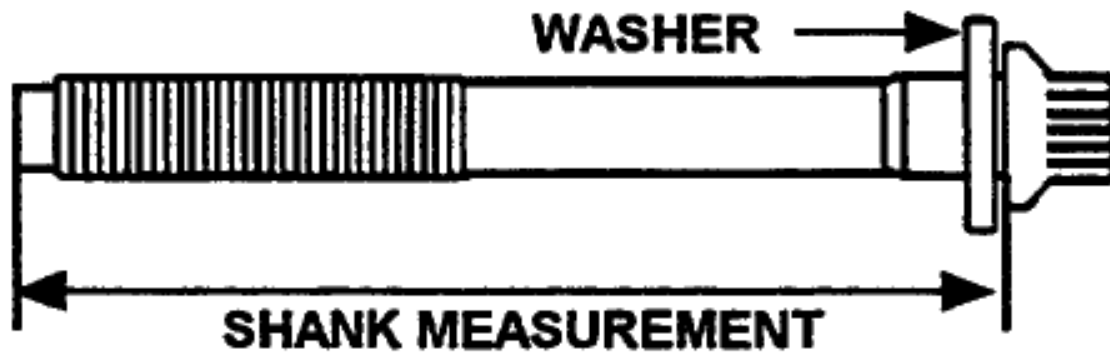


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Bulletin Diagram: BOLT SHANK MEASUREMENT LOCATIONS - CYLINDER BLOCK



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