

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

TECHNICAL BULLETIN	
	October 2004 TB 2202
Mfg:	FORD
Model:	F-SERIES
Liter:	6.0L
V I N:	P
Year:	02-07

Main Bearing Bedplate Installation For
2003-2005 Ford 6.0L Diesel Engines

The AERA Technical Committee offers the following information regarding main bearing bedplate installation for 2003-2005 Ford 6.0L diesel engines. This engine utilizes a bedplate to secure the lower main bearings to the cylinder block. This bedplate becomes sandwiched between the oil pan and block improving the overall rigidity of the engine.

With acceptable bearing clearance verified, install the lower crankcase as follows:

1. Install new lower crankcase seals.
2. Apply clean engine oil to lower bearing inserts, crankshaft journals and lower crankcase bolts.

M14 Bolts

NOTE: To prevent engine damage, make sure that the longer main cap bolts (M14 x 2 x 127) are installed inboard and the shorter bolts (M14 x 2 x 114) are installed outboard.

3. Install all 20 lower crankcase main bearing mounting bolts. Tighten mounting bolts to special torque within the following sequence:
 - a. Torque bolts 1-20 to 110 ft/lbs (149 Nm) in the numerical sequence shown below in Figure 1.
 - b. Torque bolts 1-20 again to 130 ft/lbs (176 Nm) in the numerical sequence shown below in Figure 1.
 - c. Torque bolts 1-20 finally to 170 ft/lbs (231 Nm) in the numerical sequence shown below in Figure 1.

FIGURE 1. Main Bearing Bolt Torque Sequence.

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M8 Bolts

4. Install eight M8 x 30 bolts around outside of lower crankcase. Tighten bolts to the special torque 18 ft/lbs using the following sequence shown in Figure 2 below.
Figure 2. Lower Crankcase Outer Bolt Torque Sequence.

The AERA Technical Committee

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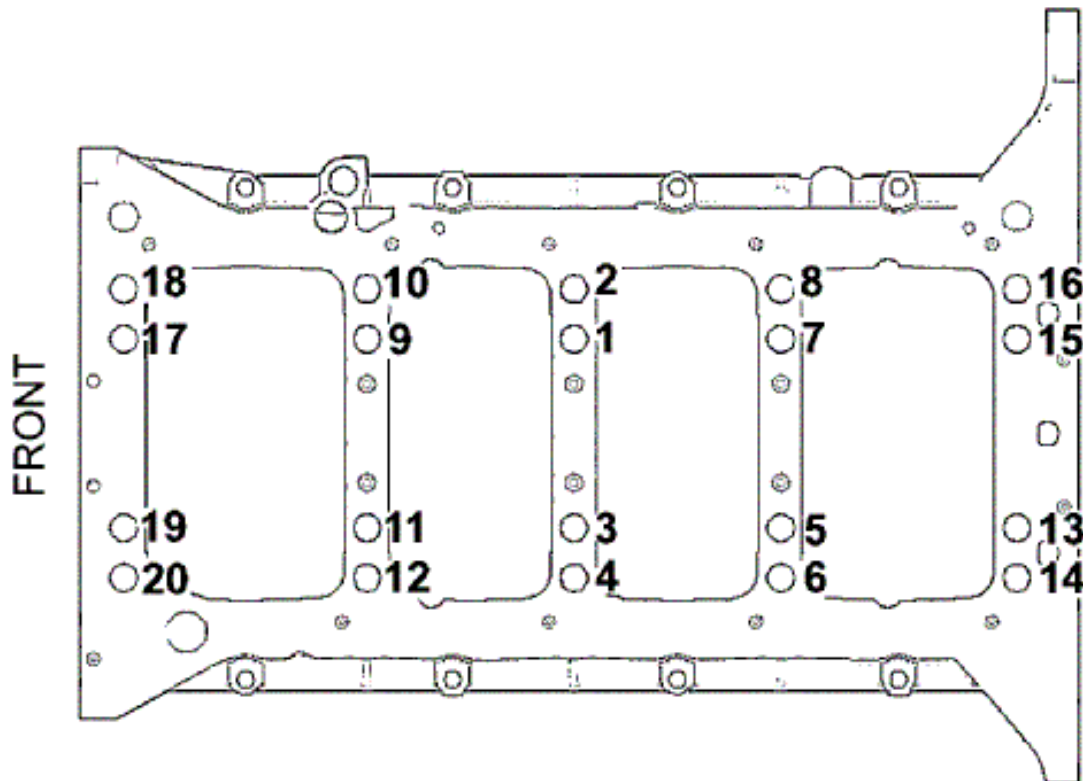
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Bulletin Diagram: FIGURE 1. MAIN BEARING BOLT TORQUE SEQUENCE - CYLINDER BLOCK



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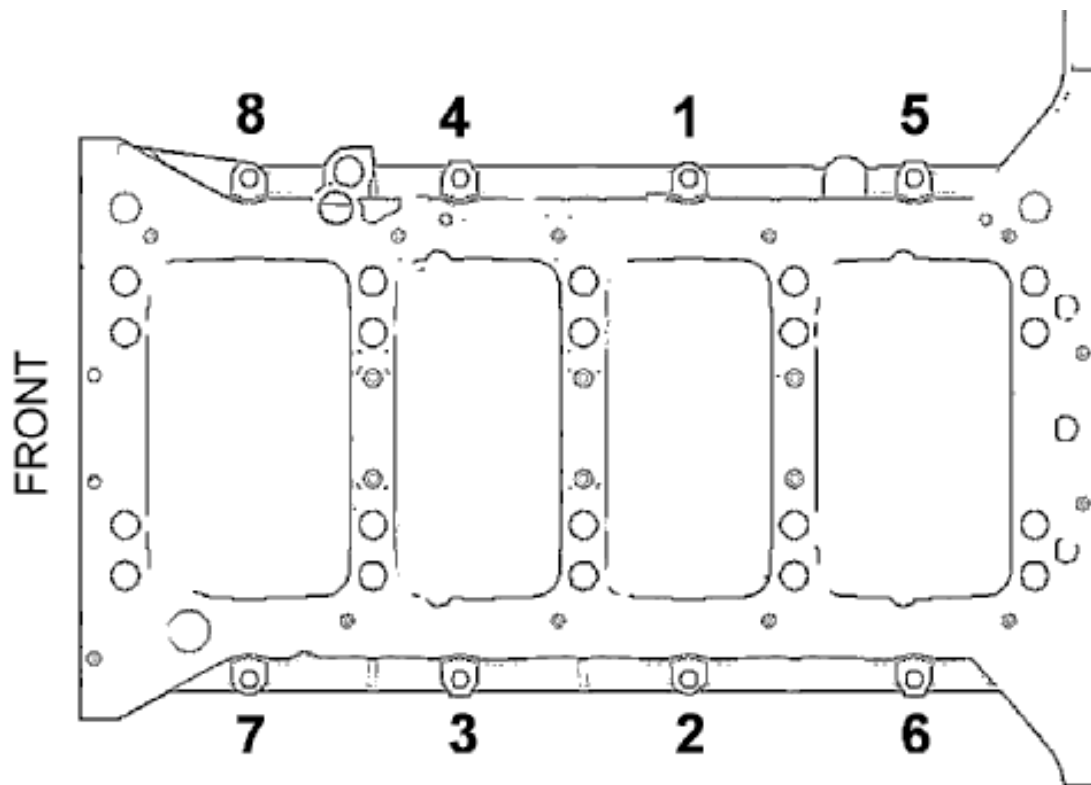
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Bulletin Diagram: FIGURE 2. LOWER CRANKCASE BOLT TORQUE SEQUENCE - CYLINDER BLOCK



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