

Fig. H.2.  
View of Crankcase showing serial numbers and  
identification numbers.

Replacement bearings can be supplied 0.010 in (0,25 mm), 0.020 in (0,508 mm) and 0.030 in (0,762 mm) undersize.

#### Crankshaft End Float

The crankshaft end float is controlled by detachable thrust washers fitted each side of the rear main bearing cap and the cylinder block half housing. The lower halves of these thrust washers fitted in the rear main bearing cap have suitable locating lugs to prevent them from turning out of position. Fit the crankshaft thrust washers to each side of the bearing housing with the vertical oil grooves facing outwards. See Figs. H.4 and H.5.

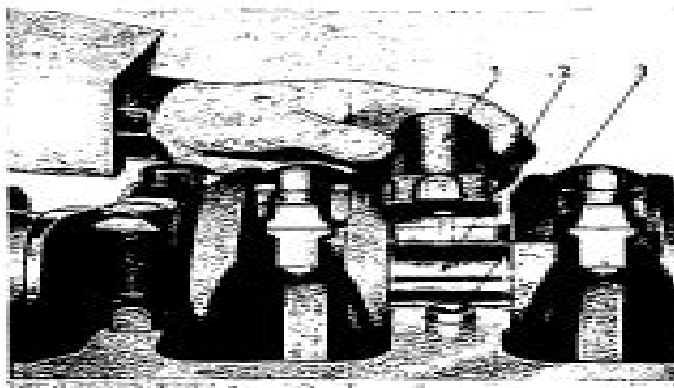


Fig. H.3.  
1. Main Bearing Cap. 2. Main Bearing Journal.  
3. Dowel.

### CRANKSHAFT AND MAIN BEARINGS—H.3



Fig. H.4.  
Showing correct location of Crankshaft Thrust Washers  
(Crankshaft Removed).

To check the crankshaft end float, push the crankshaft forward as far as it will go and using feeler gauges check the gap between the machined shoulder on the crankshaft web and the crankshaft thrust washer. See Fig. H.6.

Check the gap on the other side of the rear main bearing with the bottom half housing of the oil seal removed and the crankshaft pushed back as far as it will go.

The clearance both sides of the bearing should be identical. The manufacturers production limits for the crankshaft end float are given in the Technical Data.

#### To Remove Crankshaft

1. Remove the engine from its application.



Fig. H.5.  
Rear Main Bearing Cap.  
1. Oil Drain Holes.  
2. Bearing Shell.  
3. Thrust Washer.  
4. Bearing Cap.  
5. Cork Seal.

# Perkins 4203 Workshop Manual

**Liyong Dong**



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