

INSERT MAIN BEARING INSTALLATION INSTRUCTIONS

Crankshaft Size

Standard #8941 1.6254"/1.6259"

010 Undersize #8942 1.6154"/1.6159"

020 Undersized #8943 1.6054"/1.6059"

030 Undersized #8944 1.5954"/1.5959"

040 Undersized #8945 1.5854"/1.5859"

The Block & Caps will Require Align Boring

Housing Bore in Block 1.7705"/1.7710"

Finish 60-90 Mico Inches RA.

Cut slots in the block & caps for the aligning lugs on the inserts.

In some of the blocks (mainly early 1928), the oil holes are not consistent. If the oil hole in the block is not in line with the oil hole in the bearings elongate the hole in the bearing and completely remove any burrs. Oil grooves in the bearing will provide ample oil for the bearings without altering the oil pump or lubricating system.

The back of the rear main bearing block & cap are to be counter bored .125" deep and 2.250" diameter.

The rear thrust washers are held in place by the counter bore and crankshaft. The block thrust washer is to be doweled to the block to prevent rotating. The thrust washers are not to be attached or secured as this can cause end loading and abnormal wear.

The front on the rear main bearing block only is counter bored .125" deep and 2.250" diameter.

The front thrust washer is held in place by the counter bore and crankshaft. The cap not counter bored will prevent the thrust washer from rotating. Again the thrust washer is not secured to the block.

We recommend the use of tri metal lined bearings with the model a crankshaft. Thrust washers are available through your bearing supplier.

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