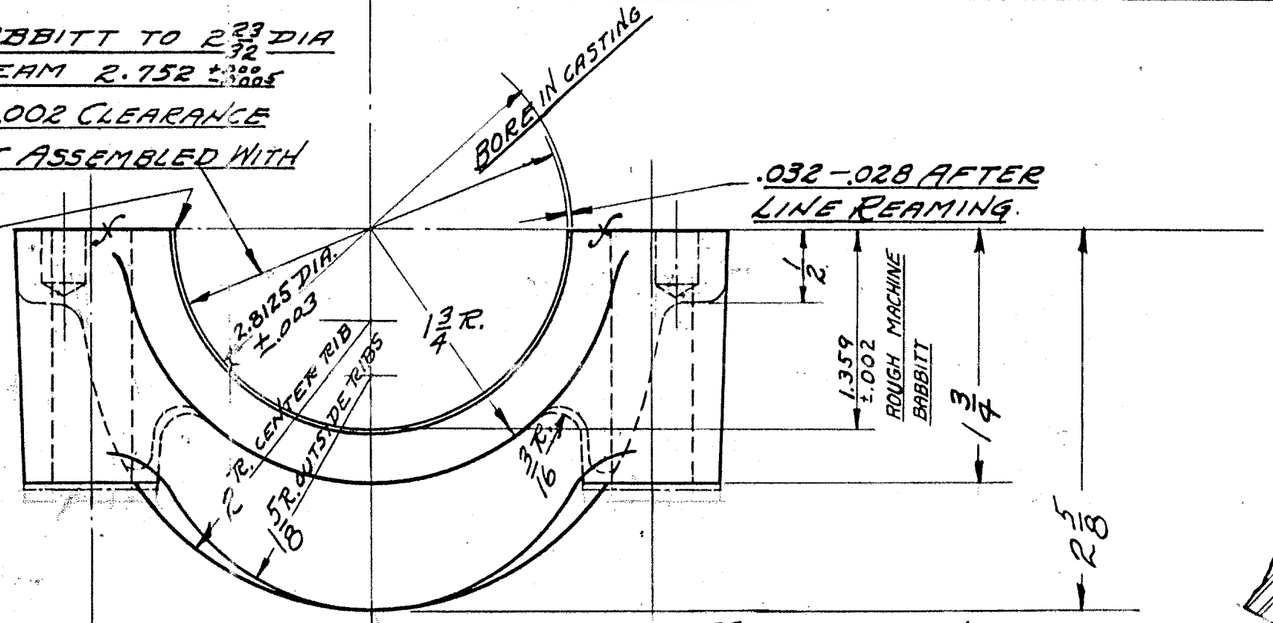
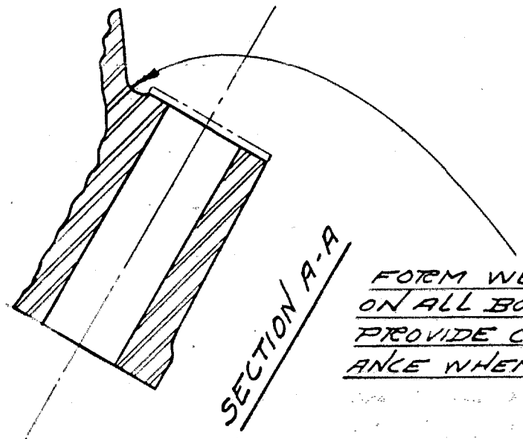
ROUGH BORE BABBITT TO $2\frac{23}{32}$ DIA
REAM 2.752 $^{+.003}_{-.000}$

BEARING TO HAVE .0015 TO .002 CLEARANCE ON DIA WITH CRANKSHAFT ASSEMBLED WITH CASE Nº J-100

DO NOT BREAK EDGE OF BABBITT.





FORM WEBS AS SHOWN ON ALL BOSSES TO PROVIDE CUTTER CLEARANCE WHEN FINISHING

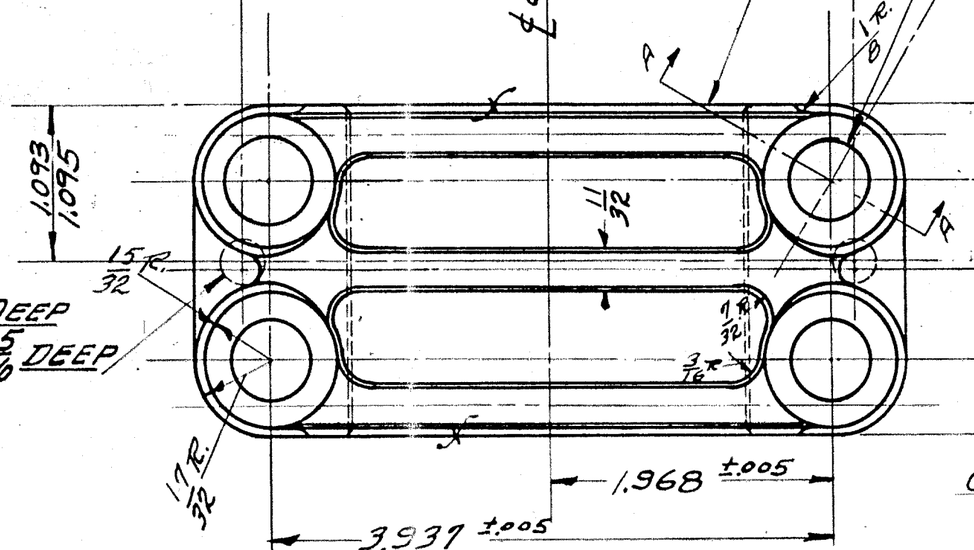
4.312
4.313

2.156
2.157

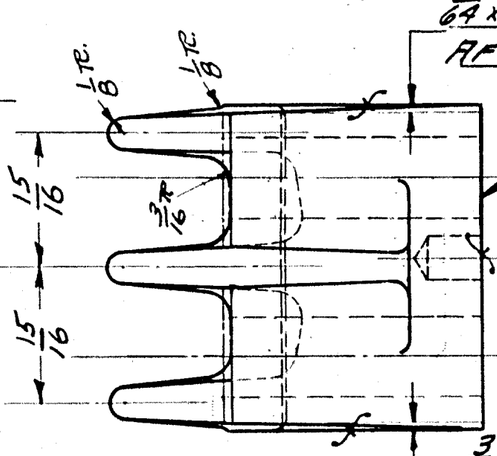
℄ CAP & SHAFT

39/64 DRILL - 4 HOLES
1 - DIA SPOT FACE
BREAK EDGES SLIGHTLY.

FRONT FACE



19/64 - DRILL - 3/8 - DEEP
REAM .3130 - .3140 - 5/16 DEEP
2 HOLES.



FACE AT BOTH SIDES TO BE TRUE WITHIN .002

LINE WITH MOGUL GENUINE ALLOY

REMOVE BURRS

3/64 x 45° CHAMFER AFTER LINE REAMING

CASTINGS TO BE SANDBLASTED & THOROUGHLY CLEANED.

DO NOT SCALE PRINT. WORK TO DIMENSIONS GIVEN. TOLERANCE ±.005 ON ALL FRACTIONS

MATERIAL STEEL CASTING BABBITT LINED SEE NOTE	NAME CENTER MAIN BEARING CAP
NO REQD. - ONE	
SCALE - FULL	DR - JPM
DATE 2-9-28	CKD -
	APPD -
	PART Nº J-103