BABBITT TO $2\frac{29}{32}$ DIA.
REAM 2.752 $^{+.0005}_{-.0000}$
BEARING TO HAVE .0015 TO .002 CLEARANCE ON DIA. WITH CRANKSHAFT ASSEMBLED WITH CASE No. J-100

DO NOT BREAK EDGE OF BABBITT

℄ CAP & SHAFT

BORE IN CASTING

2.8125 DIA ±.003

.032-.028 AFTER LINE REAMING.

$\frac{1}{2}$

$\frac{1}{8}$ R.

$1\frac{3}{4}$ R.

$\frac{3}{16}$ R.

$\frac{1}{4}$

1.359 ±.002 ROUGH MACHINE BABBITT

$1\frac{3}{4}$

$2\frac{5}{16}$ .4375

$\frac{39}{64}$ DRILL 2-HOLES
1-DIA. SPOT FACE
BREAK EDGES SLIGHTLY.

4.312
4.313

2.156
2.157

A

FRONT FACE

$\frac{19}{64}$ DRILL · $\frac{3}{8}$ DEEP
REAM .3130 .3140 $\frac{5}{16}$ DEEP
2-HOLES

$\frac{11}{32}$ R.

.3435
.3455

$\frac{17}{32}$ R.

$\frac{15}{32}$ R.

$\frac{7}{32}$ R.

$\frac{3}{16}$ R.

.890 ±.003

1.781 ±.005

.297

2R.

$\frac{11}{32}$

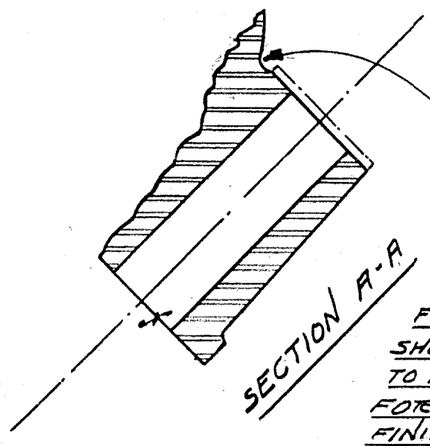
$\frac{57}{64}$ R.

1.968 ±.005

3.937 ±.005

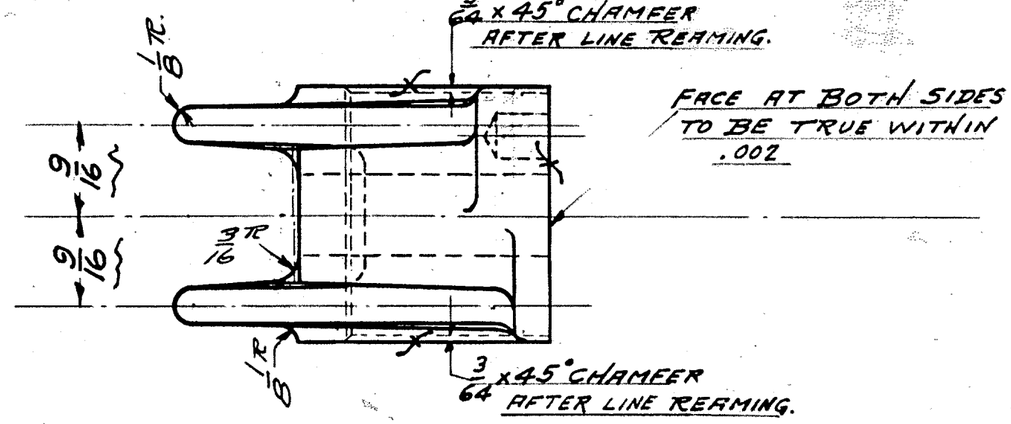
5° DA
(~~.866~~)
.833

TO IDENTIFY CAPS STAMP #2 OR #4 AFTER ASSEMBLY TO CASE & BEFORE LINE REAMING



SECTION A-A

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



FACE AT BOTH SIDES TO BE TRUE WITHIN .002

LINE WITH MOGUL GENUINE ALLOY

CASTINGS TO BE SAND BLASTED & THOROUGHLY CLEANED.

REMOVE BURRS

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

MATERIAL STEEL CASTING SEE NOTE BABBITT-LINED	NAME INTERMEDIATE MAIN BEARING CAP
SCALE - FULL	
NO REQ'D - 2	DR - J.P.M.
DATE - 2-7-28	CHD - [illegible] APPD - [illegible]
	PART No - J-102