

the crankcase joint, so that bearings No. 1 and No. 3 will not be gouged when assembling the crankcase.

6. Install bearing inserts so that the dowel pins fit and oil holes are in line with the oil passages in the crankcase.

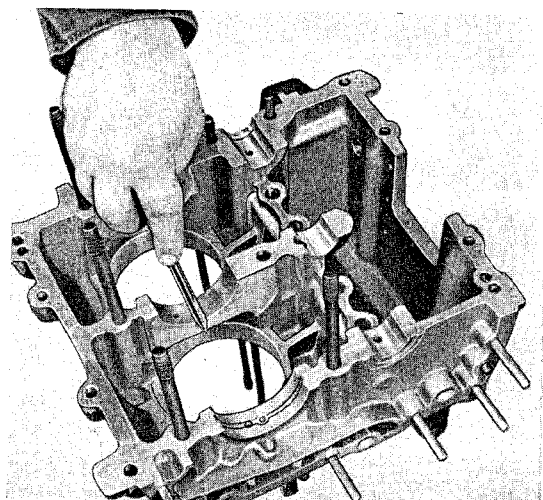


Fig. 225

2. Check whether dowel pins are secure.
3. Remove all sharp edges from the oil holes in the crankshaft journals and bearing inserts.
4. Insert one half of bearing No. 2 in the crankcase.
5. Place bearing insert No. 1 on the crankshaft with the dowel pin hole nearest the flywheel end.

7. Install the crankshaft and check each bearing to insure that the dowel pins fit properly.

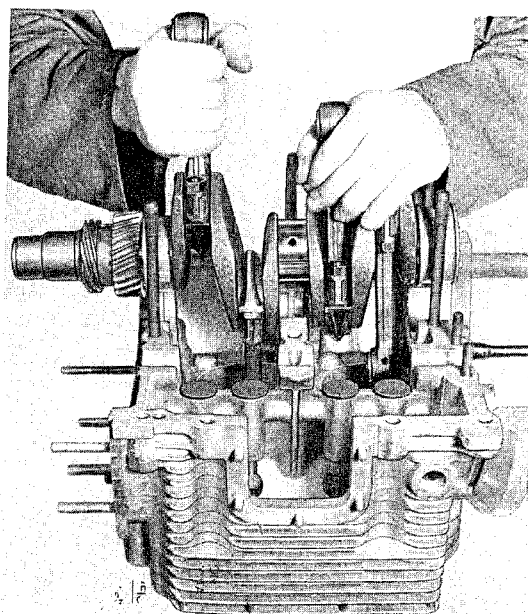


Fig. 226

8. Install camshaft noting timing marks.

## 46 EN

### Removing and Installing Connecting Rods Special Tools: VW 310 Crankshaft stand

#### Removal

1. Remove crankshaft (45 EN) and mount in crankshaft stand VW 310 (49 EN).
2. Remove connecting rod nuts and remove connecting rods and caps.