

5. Pull connecting rod against crankpin and install rod cap with match marks aligned, Fig. 21.
6. Cap should snap on when assembled correctly. Install rod screws (and dipper, Model Series 110400, 111400, 113400, 120400, 121400, 123400, 161400, 204400, 205400).
7. Torque connecting rods screws, using Tool #19197 or 19393, Torque Wrench to specifications listed in Table No. 5, page 11.

NOTE: On Model Series 28S700, 310700, 311700, 312700, 313700, torque the screw closest to the piston first. Torque the screw farthest from piston second. The connecting rod screws **MUST** be torqued in the sequence listed.

NOTE: Failure to use a torque wrench can result in loose rods (causing breakage) or over-tightened rods (causing scoring).

8. Rotate crankshaft two revolutions to make sure crankpin and rod are not binding during rotation.
9. Move connecting rod sideways to be sure rod slides from side to side.

NOTE: On Model Series 21A800, 21B800, 284H00, 285H00, 286H00, 28AH00, 28BH00, 28CH00, 31E700, 31F700, 31G700, 31J700, 31K700, 31L700, 31M700 the notch in the connecting rod cap (3) must engage the tab on the connecting rod (2).

Torque the screw closest to the piston (4) first. Torque the screw farthest from piston second (5). The connecting rod screws **MUST** be torqued in the sequence listed.

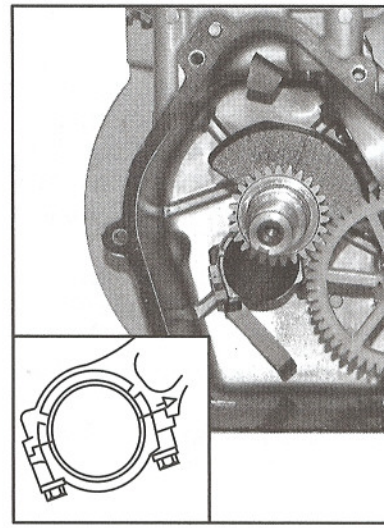


Fig. 21

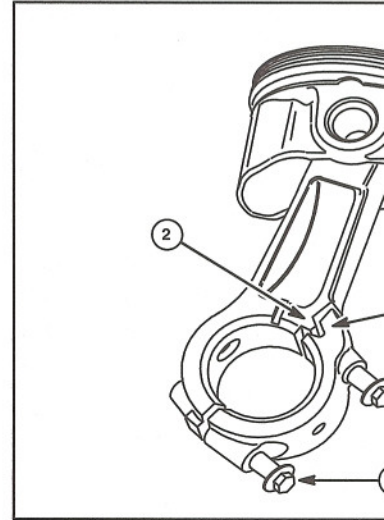


Fig. 22