

T -3024 Inserted Rod Instructions

Recommended mean or average clearance for rod bearings is .0015" +1- .0005. Since both the connecting rod and the bearings have tolerances, both of the factories that manufacture the rods and the bearings have agreed to holding an I.D. tolerance of 1.2497-1.2505". This will yield a mean I.D. tolerance of 1.2501". Below is an example of what the clearances will yield with standard grinds of the Model T Crankshaft:

Maximum Standard Crank O.D. of 1.249" will yield clearances of .0007-.0015"

Minimum Standard Crank O.D. of 1.248" will yield clearances of .0017-.0025"

A crankshaft ground to the maximum may have to be polished to obtain the desired minimum clearance of .001 ", but only when the I.D. dimension of the rod and bearing are at their minimum. Oversize bearings will be sized using the same method as shown above for Standard bearings plus the oversize dimension. However, the actual crankshaft diameter can be custom ground when using oversize bearings to obtain the engine builder's desired clearance.

Below are recommended crankshaft grinds. Grinding to the mid range should give you an average clearance of about .0015" plus the +1- tolerance of the crankshaft dimension.

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STD 1.248/1.249"

.010 undersize 1.238/1.239"

.020 undersize 1.228/1.229"

.030 undersize 1.218/1.219"

.040 undersize 1.208/1.209"