

FOR ALL FORD & MERCURY MODELS

'90' V8 Engine (1938)—See Note

Part Number		Size
Frnt. & Center	Rear	
68-6333-G	68-6331-J	Standard
68-6333-II	68-6331-K	.005" Undersize
68-6333-J	68-6331-L	.010" Undersize
68-6333-K	68-6331-Q	.015" Undersize
68-6333-N	68-6331-U	.020" Undersize
68-6333-L <sup>④</sup>	68-6331-M <sup>①</sup>	Standard
	68-6331-N <sup>①</sup>	.005" Undersize
68-6333-P <sup>④</sup>	68-6331-P <sup>②</sup>	.010" Undersize
	68-6331-T <sup>②</sup>	Standard
	68-6331-W <sup>②</sup>	.010" Undersize

①—Length .015" Oversize. ④—O.D. .015" Oversize.  
 ②—O.D. .015" oversize, .010" undersize within flanges.  
**Note**—Used only with No. 81A-6010-B cylinder block and 68-6303A crankshaft.

'90' & '100' V8 Engine (1939-42)

Part Numbers		Size
Frnt. & Center	Rear	
81-A-6333-A	81-A-6331-A	Standard
81-A-6333-B	81-A-6331-B	.005" Undersize
81-A-6333-C	81-A-6331-C	.010" Undersize
	81-A-6331-D <sup>①</sup>	Standard
	81-A-6331-E <sup>①</sup>	.005" Undersize
	81-A-6331-F <sup>①</sup>	.010" Undersize
81-A-6333-D	81-A-6331-G	.015" Undersize
81-A-6333-E <sup>③</sup>	81-A-6331-H <sup>②</sup>	Standard
81-A-6333-F	81-A-6331-J	.020" Undersize
81-A-6333-G <sup>③</sup>	81-A-6331-K <sup>②</sup>	.010" Undersize
81-A-6333-L	81-A-6331-L	.002" Undersize
81-A-6333-M	81-A-6331-M	.012" Undersize
81-A-6333-N	81-A-6331-N	.030" Undersize
	81-A-6331-P <sup>①</sup>	.020" Undersize
	81-A-6331-Q <sup>①</sup>	.002" Undersize
	81-A-6331-T <sup>①</sup>	.030" Undersize

①—Length .015" Oversize. ③—O.D. .015" Oversize.  
 ②—O.D. .015" Oversize, .010" Undersize in length.

1941-42 4 AND 6 CYLINDER MODELS

**CRANKSHAFT BEARINGS:** — Replacement bearings furnished as shown below. On 4 Cyl. Engine, center bearing takes end thrust (bearing flanged on both ends). On 6 Cyl. Engine, 2 intermediate bearings used; #4 bearing takes end thrust. Upper and lower bearing halves not interchangeable on Six.

4 Cyl. Engine

Part Nos.		
Front & Rear	Center	Size
9N-6333-A	9N-6331-A	Standard
9N-6333-B	9N-6331-B	.001" Undersize
9N-6333-C	9N-6331-C	.002" Undersize
9N-6333-D	9N-6331-D	.005" Undersize
9N-6333-E	9N-6331-E	.010" Undersize
9N-6333-F	9N-6331-F	.012" Undersize
9N-6333-G	9N-6331-G	.020" Undersize

6 Cyl. Engine

Front & Intermediate		
Upper Half	Lower Half	Size
1GA-6333-A	1GA-6338-A	Standard
1GA-6333-B	1GA-6338-B	.001" Undersize
1GA-6333-C	1GA-6338-C	.002" Undersize
1GA-6333-D	1GA-6338-D	.005" Undersize
1GA-6333-E	1GA-6338-E	.010" Undersize
1GA-6333-F	1GA-6338-F	.012" Undersize
1GA-6333-G	1GA-6338-G	.020" Undersize
1GA-6333-H	1GA-6338-H	.030" Undersize

Rear		
Upper Half	Lower Half	Size
1GA-6331-A	1GA-6337-A	Standard
1GA-6331-B	1GA-6337-B	.001" Undersize
1GA-6331-C	1GA-6337-C	.002" Undersize
1GA-6331-D	1GA-6337-D	.005" Undersize
1GA-6331-E	1GA-6337-E	.010" Undersize
1GA-6331-F	1GA-6337-F	.012" Undersize
1GA-6331-G	1GA-6337-G	.020" Undersize
1GA-6331-H	1GA-6337-H	.030" Undersize

**TIMING GEARS**

1940-42 MODELS

**TIMING GEARS (4 & 6 CYL., '90' & '100' V8):**—Bolted-on type Camshaft Gear (fibre, aluminum, or malleable iron) used. Gear can be replaced without removing camshaft from engine as follows:

**Camshaft Gear Removal and Installation:**—Gear is bolted on camshaft hub flange by 4 offset cap-screws. To remove gear, remove crankshaft pulley (and dampener on 6 Cyl. Engine)—use Puller 6312-A, and timing gear cover. Bend back lock plate tangs, take out four camshaft gear mounting cap-screws, remove gear. When replacing gear, make certain that marks on camshaft and crankshaft gears are lined up and see that lockplate tangs are bent up against flats on mounting screws. **NOTE**—Camshaft gear mounting screw holes offset so gear can only be installed in correct position. Use 6312-B pulley replacer to install crankshaft pulley.