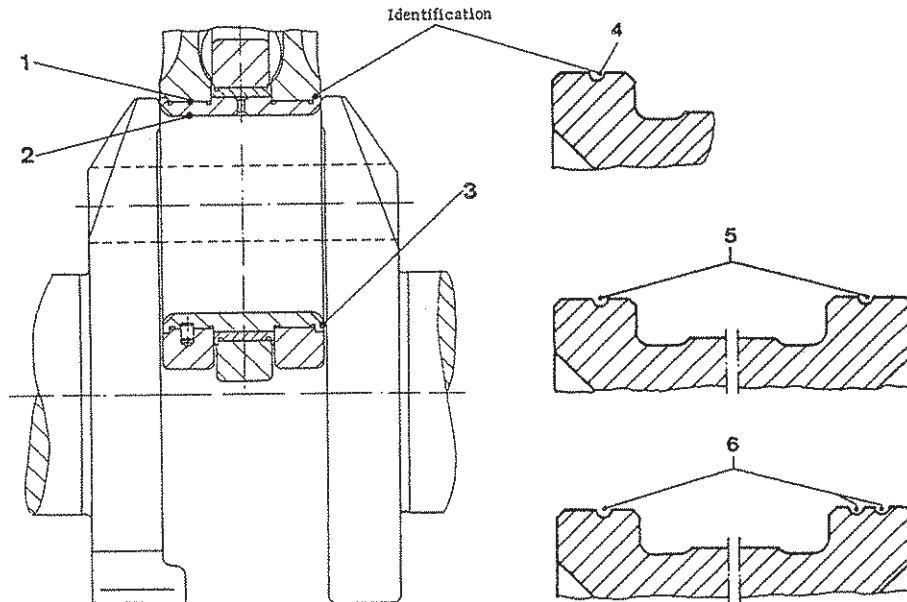


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RUNNING GEAR

Section **3**Edition 1271
01.77Page **8**FORK CONROD BEARING

TA03 158/1

Dimensions in mm

No.	Item	New condition Fit (Nominal dimension)	Stage	Rework Fit (Nominal dimension)	Tolerance		Clearance		Interference		Operational limit	Hints for rework
					min.	max.	min.	max.	min.	max.		
1	Fork Conrod Bore Diameter	148 ^{H6}	1	148.2 ^{H6}	0	+0.025					out-of- round 0.040	If interference ≤ 0.100 renew bearing shells or use next repair size.
	Fork Conrod Bearing O. D.	148.18	2	148.5 ^{H6}	-0.010	0			0.145	0.180	0.100	
2	Fork Conrod Bearing I. D.	125.09 ^{H6}	1	124.89	0	+0.025					out-of- round 0.070	If clearance ≥ 0.20 renew bearing shells or use next repair size.
			2	124.69								
			3	124.49								If out-of-round ≤ 0.03 use next repair size.
			4	124.29								
			5	124.09								
			6	123.89								
	Crankpin Diameter	125 ^{H6}	1	124.8 ^{H6}	-0.039	-0.014	0.104	0.154			clearance 0.020	
			2	124.6 ^{H6}							out-of- round 0.030	
			3	124.4 ^{H6}								
			4	124.2 ^{H6}								
			5	124.0 ^{H6}								
			6	123.8 ^{H6}								
	Deviation of shape from theoretical cylinder relative to length and diameter:										0.030	
3	Crankpin Length	104			0	+0.100						axial clearance 0.400 0.600
	Fork Conrod Bearing Width	103.6			-0.100	0					0.700	
	Bearing Shell Identification	shell O. D. 148.18, I. D. 124.09 to 124.69 - no groove										
4	Bearing Shell Identification	shell O. D. 148.18, I. D. 124.49 to 123.89 - 1 groove										
5	Bearing Shell Identification	shell O. D. 148.38 - 2 grooves										
6	Bearing Shell Identification	shell O. D. 148.68 - 3 grooves										

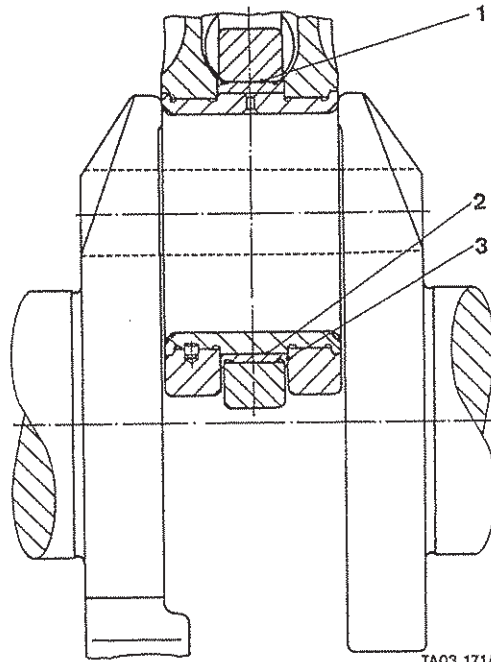
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BLADE CONROD BEARING



Dimensions in mm

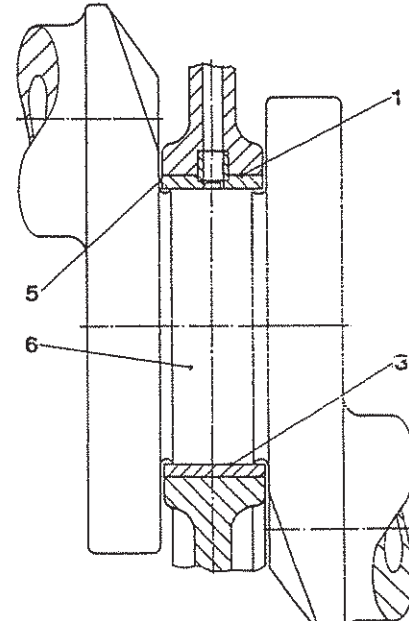
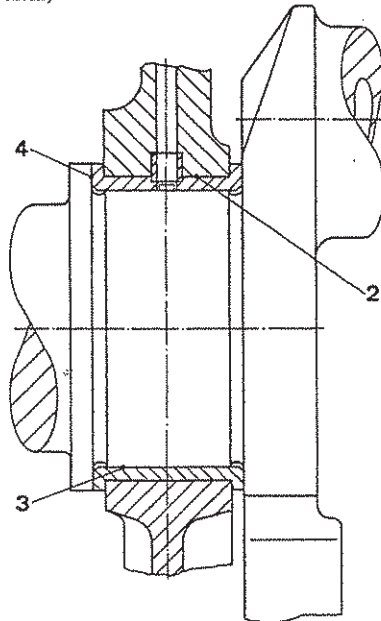
No.	Item	New condition Fit (Nominal dimension)	Stage	Rework Fit (Nominal dimension)	Tolerance		Clearance		Interference		Operational limit	Hints for rework
					min.	max.	min.	max.	min.	max.		
1	Blade Conrod Bore Diameter	164 ^{H6}	1	164.2 ^{H6}	0	+0.025					out-of- round 0.040	If interference ≤ 0.20 renew bearing shells or use next repair size.
	Blade Conrod Bearing O.D.	164.17 _{s6}	2	164.5 ^{H6}	+0.108	+0.133			0.253	0.303	0.200	
2	Blade Conrod Bearing I.D.	153.10 ^{H6}			0	+0.030	0.114	0.169			out-of- round 0.040	If clearance > 0.220 renew bearing shells.
	Fork Conrod Bearing O.D.	153.26 _{s6}			-0.039	-0.014					clearance 0.220 out-of- round 0.060	
3	Fork Conrod Fork Width	40.093			0	+0.088	axial clearance				0.750	
	Blade Conrod Bearing Width	39.6			-0.100	0	0.493	0.681				

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RUNNING GEAR

Section **3**Edition 1271
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(thin-walled bearing shells)



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Dimensions in mm

No.	Item	New condition Fit (Nominal dimension)	Stage	Rework Fit (Nominal dimension)	Tolerance		Clearance		Interference		Operational limit	Hints for rework		
					min.	max.	min.	max.	min.	max.				
1	Crankcase Bore Diameter	180 ^{H6}	1	180.50 ^{H6}	0	+0.029			0.204	0.252	0.200	If interference ≤ 0.200 renew bearing shells or use next repair size.		
			2	181.00 ^{H6}										
			3	181.50 ^{H6}										
	Main Bearing O. D.	180	1	180.50	+0.233	+0.252								
			2	181.00										
			3	181.50										
2	Crankshaft End Bearing O. D.	180	1	180.50	+0.204	+0.223			0.175	0.223	0.170	If interference ≥ 0.170 renew bearing shells or use next repair size.		
			2	181.00										
			3	181.50										
	3	Main Bearing I. D. (for measurement of I. D. see Section 3, Page 5)	168.142	1	167.942			clear- ance not to be smaller than specified					Shell I. D. out-of-round max. 0.05 when in place. Shell offset max. 0.03.	
				2	167.742									
				3	167.542									
4				167.342										
5				167.142										
6				166.942										
3	Crankshaft Diameter	168 ^{h6}	1	167.8 ^{h6}	-0.025	0	0.142	0.203			clearance 0.230	If clearance ≤ 0.230 renew bearing shells or use next repair size.		
			2	167.6 ^{h6}										
			3	167.4 ^{h6}										
			4	167.2 ^{h6}										
			5	167.0 ^{h6}										
			6	166.8 ^{h6}										
4	Main Bearing Width	86.64			-0.040	0	axial clearance 0.360 0.435				0.480			
	Journal Length	87 ^{H7}			0	+0.035								
5	Side Play	minimum 2 mm at bearing No. 8 & 9 (PTO side)												
6	Journal Runout	when supporting the shaft in bearing II and VI or VIII:										journal to journal journal I to journal IX or VII	0.030 0.100	
	Dynamic Crankshaft Balancing	each balancing plane (2)										unbalance 380 g/cm		