

VOLVO BM 646

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Main bearing shells

General: bearing shell location in block

Thickness: standard	2.017-2.024 mm (0.1183-0.1187)
undersize 0.010"	0.004-0.011 mm (0.1594-0.1597)
0.020"	0.10-0.108 mm (0.1312-0.1387)
0.030"	0.006-0.016 mm (0.1380-0.1387)
0.040"	0.406-0.440 mm (0.1594-0.1597)
0.050"	0.045-0.049 mm (0.1402-0.1407)

Big-end bearings

Connecting rod pins

Big-end bearing, rod pin clearance	0.006-0.008 mm (0.0002-0.0003)
Bearing pin length	40.000-40.005 mm (1.5748-1.5737)
General: standard	1.000-1.011 mm (0.0394-0.0397)
undersize 0.010"	0.000-0.008 mm (0.0000-0.0003)
0.020"	0.106-0.108 mm (0.0040-0.0043)
0.030"	0.006-0.010 mm (0.0000-0.0003)
0.040"	0.475-0.478 mm (0.0187-0.0189)
0.050"	0.045-0.049 mm (0.0018-0.0019)

Connecting rod shells

Thickness: standard	40.007-40.008 mm (1.5743-1.5740)
undersize 0.010"	40.000-40.005 mm (1.5748-1.5740)
0.020"	40.005-40.010 mm (1.5748-1.5740)
0.030"	40.015-40.024 mm (1.5710-1.5700)
0.040"	40.027-40.034 mm (1.5686-1.5687)
0.050"	40.047-40.050 mm (1.5686-1.5687)

Connecting rods

Marked 1 to 6 "16047" marking on steel flange forward

Provided with replaceable bearing shells

General: connecting rod bearing bearing shell	40.007-40.008 mm (1.5642-1.5647)
bearing shell bearing pin	75.140-75.152 mm (2.9571-2.9577)
pin/pin pin bearing	See bearing "bushings pin"
rod clearance: connecting rod - crankshaft	0.10-0.20 mm (0.004-0.008)

Plywheel, fitted

Max. permissible axial force measuring radius 100 mm ± 0"

Key gap on flywheel	0.15 mm (0.006")
	140 mm

Plywheel casing, fitted

Max. permissible axial force for contact surface against crank casing

Max. permissible axial force for steering bearing against crank casing	0.15 mm (0.006")
	Max. 4.25 mm (0.167")

Crankshaft

Size	Size
Number of bearings	7
First bearing pin, diameter	40.000-40.015 mm (1.5748-1.5747)
2nd bearing pin, diameter	40.027-40.040 mm (1.5626-1.5620)
3rd bearing pin, diameter	40.025-40.030 mm (1.5686-1.5687)
4th bearing pin, diameter	40.040-40.045 mm (1.5675-1.5680)

15 Volvo Repair Manual

Lei Huang



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