

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"	0.10-0.106 mm (0.1212-0.1221)
0.030"	0.006-0.016 mm (0.1302-0.1307)
0.040"	0.406-0.440 mm (0.1598-0.1732)
0.050"	0.045-0.049 mm (0.1413-0.1457)

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 (1.5748-1.5752)
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 (0.0042-0.0043)
0.030"	0.006-0.010 mm (0.0002-0.0004)
0.040"	0.410-0.418 mm (0.0161-0.0165)
0.050"	0.045-0.049 mm (0.0018-0.0019)

Connecting rod shells

Thickness: standard	40.007-40.009 mm (1.5763-1.5767)
undersize 0.010"	40.000-40.005 mm (1.5748-1.5752)
0.020"	40.005-40.010 mm (1.5764-1.5767)
0.030"	40.015-40.024 mm (1.5778-1.5797)
0.040"	40.025-40.034 mm (1.5799-1.5817)
0.050"	40.040-40.049 mm (1.5813-1.5831)

Connecting rods

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

Provided with replaceable bearing shells

General: connecting rod bearing bearing shell	40.007-40.009 mm (1.5763-1.5767)
bearing shell bearing pin	70.140-70.152 mm (2.7607-2.7617)
pin/pin pin bearing	See bearing "Sudgren 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 ± 6"

0.15 mm (0.006")
140 mm

Plywheel casing, fitted

Max. permissible axial force for contact surface against crank casing

0.15 mm (0.006")
Max. 4.25 mm (0.167")

Crankshaft

Size	See
Number of bearings	7
First bearing pin, standard	40.000-40.015 mm (1.5748-1.5757)
2nd bearing pin, standard	40.021-40.040 mm (1.5828-1.5837)
3rd bearing pin, standard	40.025-40.030 mm (1.5806-1.5817)
4th bearing pin, standard	40.040-40.045 mm (1.5813-1.5821)

15 Volvo Repair Manual

ML Yell



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