

CON-RODS - CRANKSHAFT - MAIN BEARINGS, FLYWHEEL AND VALVE GEARING SIDES

Selection for crankshaft and con-rod

The con-rods = A = - white marked - must be matched with the crankshaft = B = - white marked -; while the con-rods = A = blue marked - must be matched with the crankshaft = B = - blue marked.

Crankpin \varnothing = A = and = B = class

SELECTION	ORIGINAL \varnothing	UNDERSIZE		
		mm 0,254	mm 0,368	mm 0,502
CLASS = A = BLUE MARKED ON SHOULDER FLYWHEEL SIDE	44,008 44,014	43,754	43,500	43,246
CLASS = B = WHITE MARKED ON SHOULDER FLYWHEEL SIDE	44,014 44,020	43,766	43,512	43,258

- clearance between crankpin and bearing: Min. 0,030; Max. 0,054;
- coupling clearance between flange with bearing, flywheel side, and crankshaft: mm 0,040 \rightarrow 0,075;
- coupling clearance between flange with bearing, valve gearing side, and crankshaft: mm 0,028 \rightarrow 0,060;
- clearance between con-rods and crankshaft shims: mm 0,030 \rightarrow 0,060.

Fitting of the flange, valve gearing side, on the crankcase (fig. 255)

Pay attention that the lubrication hole, indicated by the arrow = A = on the flange has to be aligned with the lubrication hole indicated by the arrow = B = on the crankcase.

Lock the screws with the securing wings; after locking, bend the wings on the screw hexagonal arrows.

Fit the chain tensioner, paying attention that the spacers have to be fitted between the crankcase and the chain tensioner; after locking the screws bend the securing wings on the screws. Fit then the crankshaft through the flywheel side on the bushing of the flange, valve gearing side.

Fitting of the flange with bearings, flywheel side, on crankcase and crankshaft (fig. 257)

Pay attention that the lubrication hole indicated by arrow = A = on the flange is aligned with the lubrication hole indicated by the arrow = B = on the crankcase. Lock the screws, then bend the screw wings.

Fitting of con-rods on the crankshaft (fig. 256)

Pay attention to the position of the lubrication holes, indicated by the arrows = A =:

- con-rod for right cylinder; hole downwards;
- con-rod for left cylinder; hole upwards. The milled surfaces of con-rod and con-rod cap must coincide (see fig. 257).

Fitting of the flywheel on the crankshaft

Pay attention that the reference mark indicated by the arrow = A = on the crankshaft is aligned with the reference mark indicated by the arrow = B = on the outer flywheel (fig. 258).

Fit tool 18 91 50 50 on the flywheel (59 in fig. 259) and torque the bolts to about 4,2 Kp/m (10 pounds) then bend over the screw wings.

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