

## 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 0,508	mm 0,762
CLASS - A - BLUE MARKED ON SHOULDER FLY- WHEEL SIDE	44,008 44,014	43,754 43,766	43,500 43,512	43,246 43,258
CLASS - B - WHITE MARKED ON SHOULDER FLYWHEEL SIDE	44,014 44,020			

- 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.

# Mend Service Manual

**R.R. Bowker Company. Department of  
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