

VOLVO BM 646

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Manifolds

- 1 Fuel system, F96
- 2 Fuel system, B7
- 3 Cooling system, F96
- 4 Cooling system, B7
- 5 Turbo-compressor, A850000

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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 (0.1594-0.1587")
0.020"	0.10-0.106 mm (0.1382-0.1387")
0.030"	0.006-0.016 mm (0.1380-0.1387")
0.040"	0.406-0.407 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 (0.0042-0.0043")
0.030-0.035"	0.006-0.007 mm (0.0002-0.0003")
0.040"	0.475-0.476 mm (0.0187-0.0188")
0.050"	0.045-0.049 mm (0.0018-0.0019")

Connecting rod shells

Thickness: standard	46.007-46.008 mm (1.7725-1.7707")
undersize 0.010"	46.000-46.005 mm (1.7716-1.7707")
0.020"	46.005-46.010 mm (1.7716-1.7707")
0.030"	46.015-46.024 mm (1.7716-1.7707")
0.040"	46.025-46.034 mm (1.7706-1.7707")
0.050"	46.040-46.045 mm (1.7894-1.7897")

Connecting rods

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

Provided with replaceable bearing shells

General: connecting rod bearing bearing pin	46.007-46.008 mm (1.7725-1.7707")
bearing shell bearing pin	75.140-75.152 mm (2.9581-2.9587")
pin/pin pin bearing	See bearing "Sudgren pin"
rod clearance: connecting rod - crankshaft	0.16-0.26 mm (0.0063-0.0101")

Plywheel, fitted

Max. permissible axial force measuring radius 160 mm ± 6"

0.16 mm (0.0063")
160 mm

Plywheel casing, fitted

Max. permissible axial force for contact surface against crank casing

0.16 mm (0.0063")
Max. 4.25 mm (0.1673")

Crankshaft

Size	See
Number of bearings	7
First bearing pin, standard	46.006-46.016 mm (1.7716-1.7717")
2nd bearing pin, standard	46.021-46.040 mm (1.8125-1.8130")
3rd bearing pin, standard	46.025-46.030 mm (1.8096-1.8097")
4th bearing pin, standard	46.040-46.045 mm (1.8096-1.8097")

Volvo Repair Manual S8

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