

VOLVO BM 646

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Main bearing shells

General: bearing shell location in block

Thickness: standard	2107-2108 mm (8 1133-8 1135)
undersize 0.010"	2054-2061 mm (8 1299-8 1305)
0.020"	2 104-2 106 mm (8 1292-8 1295)
0.030"	2 099-2 110 mm (8 1283-8 1297)
0.040"	2 095-2 097 mm (8 1280-8 1282)
0.050"	2 045-2 049 mm (8 1403-8 1407)

Big-end bearings

Connecting rod pins

Big-end bearing, rod pin clearance	0.008-0.016 mm (0.0003-0.0007)
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"	2.000-2.008 mm (0.0800-0.0812)
0.020"	2 106-2 108 mm (0.0800-0.0812)
0.030"	2 096-2 102 mm (0.0800-0.0812)
0.040"	2 075-2 078 mm (0.0800-0.0812)
0.050"	2 045-2 049 mm (8 1403-8 1407)

Connecting rod shells

Thickness: standard	40.007-40.008 mm (1.5743-1.5750)
undersize 0.010"	40.000-40.005 mm (1.5748-1.5752)
0.020"	40.005-40.010 mm (1.5748-1.5752)
0.030"	40.015-40.024 mm (1.5750-1.5757)
0.040"	40.021-40.034 mm (1.5750-1.5757)
0.050"	40.047-40.050 mm (1.5769-1.5767)

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 (1.5743-1.5750)
bearing shell bearing pin	75.140-75.152 mm (2.9571-2.9587)
pin/bushing pin bearing	See bearing "bushing pin"
rod clearance: connecting rod - crankshaft	0.16-0.26 mm (0.0063-0.0104)

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	40.000-40.010 mm (1.5748-1.5752)
2nd bearing pin, standard	40.021-40.040 mm (1.5750-1.5757)
3rd bearing pin, standard	40.025-40.030 mm (1.5758-1.5760)
4th bearing pin, standard	40.040-40.045 mm (1.5767-1.5769)

Volvo Repair Manual V4

KJ Lindholm-Leary



Volvo Repair Manual V4:

Volvo Repair Manual V4 Book Review: Unveiling the Magic of Language

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