

VOLVO BM 646

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Main bearing shells

General: bearing shell location in block

Thickness: standard	2.027-2.034 mm (0.1183-0.1192")
undersize 0.010"	0.004-0.011 mm (0.1594-0.1381")
0.020"	0.10-0.108 mm (0.1312-0.1381")
0.030"	0.006-0.016 mm (0.1300-0.1381")
0.040"	0.406-0.440 mm (0.1598-0.1732")
0.050"	0.045-0.049 mm (0.1410-0.1457")

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"	0.475-0.478 mm (0.0187-0.0188")
0.050"	0.045-0.049 mm (0.0018-0.0019")

Connecting rod shells

Thickness: standard	40.007-40.008 mm (1.5743-1.5749")
undersize 0.010"	40.000-40.005 mm (1.5748-1.5752")
0.020"	40.005-40.010 mm (1.5749-1.5752")
0.030"	40.015-40.024 mm (1.5770-1.5767")
0.040"	40.027-40.034 mm (1.5769-1.5767")
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 pin	40.007-40.008 mm (1.5743-1.5749")
bearing shell bearing pin	75.140-75.152 mm (2.9571-2.9577")
pin/bush pin bearing	See bearing "bushpin pin"
rod clearance: connecting rod - crankshaft	0.10-0.20 mm (0.004-0.008")

Plywheel, fitted

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

0.15 mm (0.006")	
160 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	Size
Number of bearings	7
First bearing pin, standard	40.006-40.016 mm (1.5744-1.5751")
2nd bearing pin, standard	40.027-40.040 mm (1.5770-1.5767")
3rd bearing pin, standard	40.025-40.030 mm (1.5769-1.5767")
4th bearing pin, standard	40.046-40.050 mm (1.5770-1.5767")

Volvo 640 Engine Manual

Puja Mehta



Volvo 640 Engine Manual:

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