

VOLVO BM 646

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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 (0.1594-0.1597)
0.020"	0.10-0.106 mm (0.1312-0.1327)
0.030"	0.006-0.016 mm (0.1300-0.1307)
0.040"	0.406-0.440 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"	0.006-0.010 mm (0.0002-0.0004)
0.040"	0.475-0.478 mm (0.0187-0.0189)
0.050"	0.045-0.049 mm (0.0018-0.0019)

Connecting rod shells

Thickness: standard	46.007-46.008 mm (2.1652-2.1650)
undersize 0.010"	46.000-46.005 mm (2.1654-2.1650)
0.020"	46.005-46.010 mm (2.1654-2.1650)
0.030"	46.015-46.024 mm (2.1703-2.1697)
0.040"	46.027-46.034 mm (2.1696-2.1697)
0.050"	46.047-46.050 mm (2.0096-2.0097)

Connecting rods

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

Provided with replaceable bearing shells

General: connecting rod bearing bearing shell	46.007-46.008 mm (2.1652-2.1650)
bearing shell bearing shell	75.140-75.152 mm (2.9571-2.9577)
pin/bush pin/bush	See bearing "bushings pin"
rod clearance: connecting rod - crankshaft	0.10-0.20 mm (0.004-0.008)

Plywheel, fitted

Max. permissible axial force measuring radius 100 mm ± 0"

0.15 mm (0.006")
140 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, diameter	46.000-46.015 mm (2.1646-2.1651)
2nd bearing pin, diameter	46.027-46.040 mm (2.0126-2.0130)
3rd bearing pin, diameter	46.025-46.030 mm (2.0098-2.0099)
4th bearing pin, diameter	46.040-46.045 mm (2.0079-2.0080)

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 also an old world thrush *turdus merula* the old world blackbird is 25 cm 10 inches long males are black and females brown
 with orange bill and eye rims common in woods and gardens

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