

VOLVO BM 646

Contents

Group 00 General		Group 05 Intake and Exhaust Systems	
Specifications	1	Construction and Function	17
Major subassembly	1	Service Procedures	
Tightening torques	6	Timing valve	61
Special tools	9	Exhaust pressure gauges	62
General	11		
Engine removal and installation	12		
		Group 06 Cooling System	
Group 01 Engine Assembly		Construction and Function	26
Construction and Function	26	Service Procedures	
Service Procedures		Coolant, etc.	36
Cylinder heads	31	Thermostat, coolant pump	40
Cylinder block	34	Thermostat fan	43
Cylinder liners	37		
Valve mechanism	39	Group 08 Turbo-Compressor	
Timing gears	41	Construction and Function	46
Crank mechanism	43	Service Procedures	
		Checking the charging pressure, etc.	60
Group 02 Lubricating System		Overhauling the turbo-compressor	61
Construction and Function	51	Refilling turbo-compressor oil, engine	62
Service Procedures			
Oil pump, etc.	56		
Oil cooler	57	Waterpump	
Oil filter	58	1 Fuel system, F98	
		2 Fuel system, B7	
Group 04 Fuel System		3 Cooling system, F98	
Construction and Function	64	4 Cooling system, B7	
Service Procedures		5 Turbo-compressor, aftercooler	
Injection pump	67		
Injectors	71		
Fuel pump	73		
Fuel filter	74		
Air cleaner	74		

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Main bearing shells

General: bearing shell location in block

Thickness: standard	2187-2194 mm (8 1/32-8 1/16")
undersize 0.010"	2084-2091 mm (8 1/32-8 1/16")
0.020"	2 181-2 188 mm (8 1/32-8 1/16")
0.030"	2 098-2 105 mm (8 1/32-8 1/16")
0.040"	2 015-2 022 mm (8 1/32-8 1/16")
0.050"	2 142-2 149 mm (8 1/32-8 1/16")

Big-end bearings

Connecting rod pins

Big-end bearing, rod pin clearance	0.048-0.104 mm (0.002-0.004")
Bearing pin length	40.950-40.950 mm (1.6100-1.6121)
General: standard	1.890-1.911 mm (0.0745-0.0757)
undersize 0.010"	2.050-2.059 mm (0.0800-0.0817)
0.020"	2 156-2 165 mm (0.0850-0.0857)
0.030"	2 262-2 270 mm (0.0890-0.0897)
0.040"	2 375-2 375 mm (0.0930-0.0937)
0.050"	2 545-2 545 mm (0 1000-0 1000")

Connecting rod shells

Thickness: standard	46.837-46.840 mm (2 1/32-2 1/32")
undersize 0.010"	45.835-45.838 mm (2 1/32-2 1/32")
0.020"	45.335-45.340 mm (2 1/32-2 1/32")
0.030"	44.835-44.840 mm (2 1/32-2 1/32")
0.040"	44.335-44.340 mm (2 1/32-2 1/32")
0.050"	43.835-43.840 mm (2 1/32-2 1/32")

Connecting rods

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

Provided with replaceable bearing shells

General: connecting rod bearing bearing shell	46.837-46.840 mm (2 1/32-2 1/32")
bearing shell bearing pin	75.140-75.152 mm (2.9571-2.9587)
pin/pin pin bearing	See bearing "Sudgen pin"
rod clearance: connecting rod - crankshaft	0.16-0.26 mm (0.006-0.010")

Plywheel, fitted

Max. permissible axial force measuring radius 190 mm ± 6"

Key pin on flywheel	0.16 mm (0.006")
	140 mm

Plywheel casing, fitted

Max. permissible axial force for contact surface against crank casing

Max. permissible axial force for steering bearing against crank casing	0.16 mm (0.006")
	Max. 4.25 mm (0.0017)

Crankshaft

Size	See
Number of bearings	7
First bearing pin, diameter	46.835-46.875 mm (2 1/32-2 1/16")
2nd bearing pin, diameter	46.837-46.840 mm (2.6226-2.6230)
3rd bearing pin, diameter	46.335-46.340 mm (2.0086-2.0090)
4th bearing pin, diameter	45.835-45.840 mm (2.0076-2.0080)

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Table of Contents Ownerr Manual Volvo V7

1. Understanding the eBook Ownerr Manual Volvo V7
 - The Rise of Digital Reading Ownerr Manual Volvo V7
 - Advantages of eBooks Over Traditional Books
2. Identifying Ownerr Manual Volvo V7
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Ownerr Manual Volvo V7
 - User-Friendly Interface
4. Exploring eBook Recommendations from Ownerr Manual Volvo V7
 - Personalized Recommendations
 - Ownerr Manual Volvo V7 User Reviews and Ratings
 - Ownerr Manual Volvo V7 and Bestseller Lists
5. Accessing Ownerr Manual Volvo V7 Free and Paid eBooks
 - Ownerr Manual Volvo V7 Public Domain eBooks

- Ownerr Manual Volvo V7 eBook Subscription Services
- Ownerr Manual Volvo V7 Budget-Friendly Options
- 6. Navigating Ownerr Manual Volvo V7 eBook Formats
 - ePub, PDF, MOBI, and More
 - Ownerr Manual Volvo V7 Compatibility with Devices
 - Ownerr Manual Volvo V7 Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Ownerr Manual Volvo V7
 - Highlighting and Note-Taking Ownerr Manual Volvo V7
 - Interactive Elements Ownerr Manual Volvo V7
- 8. Staying Engaged with Ownerr Manual Volvo V7
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Ownerr Manual Volvo V7
- 9. Balancing eBooks and Physical Books Ownerr Manual Volvo V7
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Ownerr Manual Volvo V7
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Ownerr Manual Volvo V7
 - Setting Reading Goals Ownerr Manual Volvo V7
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Ownerr Manual Volvo V7
 - Fact-Checking eBook Content of Ownerr Manual Volvo V7
 - Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks

14. Embracing eBook Trends

- Integration of Multimedia Elements
- Interactive and Gamified eBooks

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