

VOLVO BM 646

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Main bearing shells

General: bearing shell location in block

Thickness: standard	2187-2194 mm (86.133-86.771 in)
undersize 0.010"	2054-2061 mm (80.866-80.751 in)
0.020"	2181-2188 mm (85.862-85.750 in)
0.030"	2098-2105 mm (82.559-82.520 in)
0.040"	2185-2192 mm (86.331-86.300 in)
0.050"	2162-2169 mm (85.118-85.000 in)

Big-end bearings

Connecting rod pins

Big-end bearing, rod pin clearance	0.048-0.104 mm (0.002-0.004 in)
Bearing pin length	40.950-41.050 mm (1.6120-1.6537 in)
General: standard	1.890-1.911 mm (0.0744-0.0752 in)
undersize 0.010"	2.050-2.070 mm (0.0807-0.0817 in)
0.020"	2.155-2.175 mm (0.0848-0.0857 in)
0.030"	2.260-2.280 mm (0.0889-0.0902 in)
0.040"	2.475-2.495 mm (0.0974-0.0982 in)
0.050"	2.540-2.560 mm (0.1000-0.1007 in)

Connecting rod shells

Thickness: standard	46.807-46.880 mm (1.8426-1.8457 in)
undersize 0.010"	45.935-46.008 mm (1.8084-1.8497 in)
0.020"	46.325-46.398 mm (1.8242-1.8671 in)
0.030"	46.075-46.148 mm (1.8103-1.8497 in)
0.040"	46.827-46.900 mm (1.8436-1.8457 in)
0.050"	46.567-46.640 mm (1.8333-1.8697 in)

Connecting rods

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

Provided with replaceable bearing shells

General: connecting rod bearing bearing seat	46.807-46.880 mm (1.8426-1.8457 in)
bearing shell bearing seat	75.140-75.702 mm (2.9581-2.9837 in)
pin/bush pin bearing	See bearing "bush/pin pair"
rod clearance: connecting rod - crankshaft	0.16-0.26 mm (0.006-0.010 in)

Plywheel, fitted

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

0.16 mm (0.006")	
160 mm	

Plywheel casing, fitted

Max. permissible axial force for contact surface against crank casing

0.16 mm (0.006")	
Max. 4.25 mm (0.167 in)	

Crankshaft

Size	Size
Number of bearings	7
First bearing pin, standard	46.950-46.975 mm (1.8445-1.8497 in)
2nd bearing pin, standard	46.827-46.849 mm (1.8426-1.8497 in)
3rd bearing pin, standard	46.325-46.350 mm (1.8242-1.8497 in)
4th bearing pin, standard	46.848-46.870 mm (1.8445-1.8497 in)

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