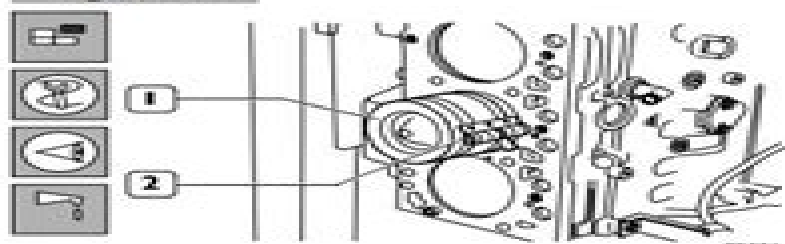


ENGINE F4BE0484E OVERHAUL

Mounting the connecting rod/piston assemblies in the cylinder liners

Figure 118

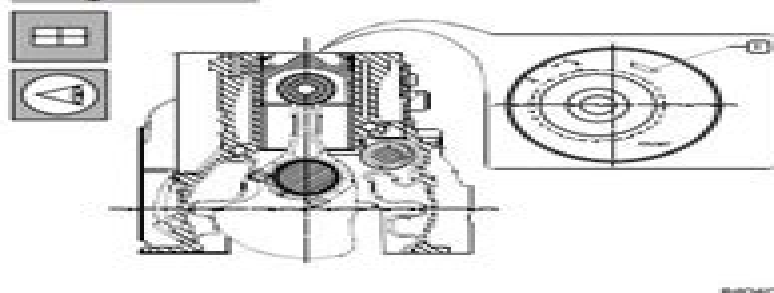


Lubricate thoroughly the pistons, including the piston rings and the cylinder liner inside.

Use band 380000994 (2) to mount the connecting rod-piston assemblies (1) into the cylinder liners; moreover, verify that:

- ☐ the number of each connecting rod corresponds to the cap matching number.

Figure 119

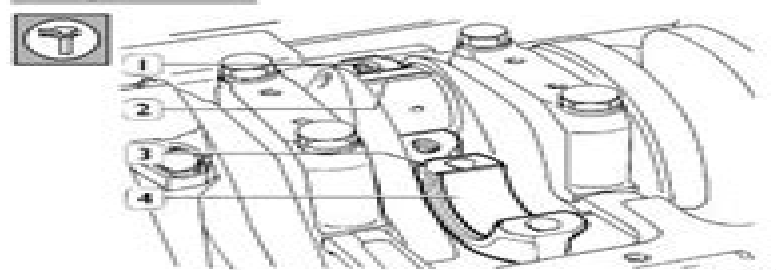


SCHEME FOR MOUNTING THE CONNECTING ROD-PISTON ASSEMBLY INTO THE TUNNEL

- ☐ the piston ring apertures are offset to each other by 120°;
- ☐ all the connecting rod/piston assemblies weigh the same;
- ☐ the writing stamped on the piston crown faces the crankcase front side, or the notch obtained on the piston skirt corresponds to the position of oil nozzles.

Measuring the crankpin assembling play

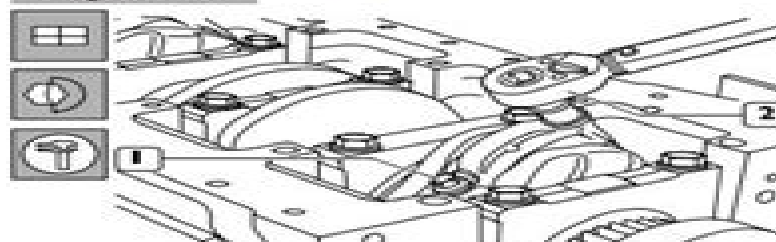
Figure 120



The play can be measured by following the procedure below:

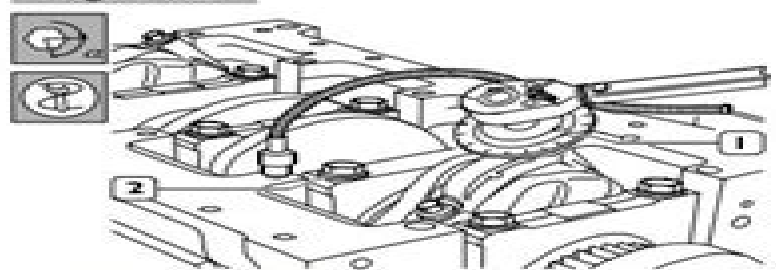
- ☐ clean thoroughly the parts and eliminate any trace of oil;
- ☐ place a piece of gauged wire (2) on drive shaft pins (1);
- ☐ mount the connecting rod caps (3) with their respective half bearings (4);

Figure 121



- ☐ tighten screws (1) (previously lubricated with engine oil) to the specified torque by means of a torque wrench (2).

Figure 122



- ☐ Apply tool 380001001 (1) on the compass wrench, then tighten screws (2) further in a criss-cross sequence.

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Albert A Gayle



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Table of Contents New Holland Iveco Engine Service Manual

1. Understanding the eBook New Holland Iveco Engine Service Manual
 - The Rise of Digital Reading New Holland Iveco Engine Service Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying New Holland Iveco Engine Service Manual
 - 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 New Holland Iveco Engine Service Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from New Holland Iveco Engine Service Manual
 - Personalized Recommendations
 - New Holland Iveco Engine Service Manual User Reviews and Ratings
 - New Holland Iveco Engine Service Manual and Bestseller Lists
5. Accessing New Holland Iveco Engine Service Manual Free and Paid eBooks

- New Holland Iveco Engine Service Manual Public Domain eBooks
- New Holland Iveco Engine Service Manual eBook Subscription Services
- New Holland Iveco Engine Service Manual Budget-Friendly Options
- 6. Navigating New Holland Iveco Engine Service Manual eBook Formats
 - ePub, PDF, MOBI, and More
 - New Holland Iveco Engine Service Manual Compatibility with Devices
 - New Holland Iveco Engine Service Manual Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of New Holland Iveco Engine Service Manual
 - Highlighting and Note-Taking New Holland Iveco Engine Service Manual
 - Interactive Elements New Holland Iveco Engine Service Manual
- 8. Staying Engaged with New Holland Iveco Engine Service Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers New Holland Iveco Engine Service Manual
- 9. Balancing eBooks and Physical Books New Holland Iveco Engine Service Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection New Holland Iveco Engine Service Manual
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine New Holland Iveco Engine Service Manual
 - Setting Reading Goals New Holland Iveco Engine Service Manual
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of New Holland Iveco Engine Service Manual
 - Fact-Checking eBook Content of New Holland Iveco Engine Service Manual
 - 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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