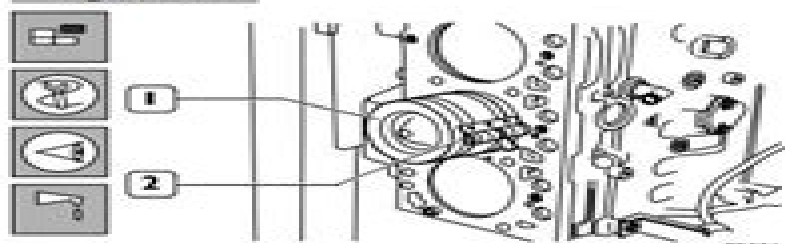


ENGINE F4BE0484E OVERHAUL

Mounting the connecting rod/piston assemblies in the cylinder liners

Figure 118

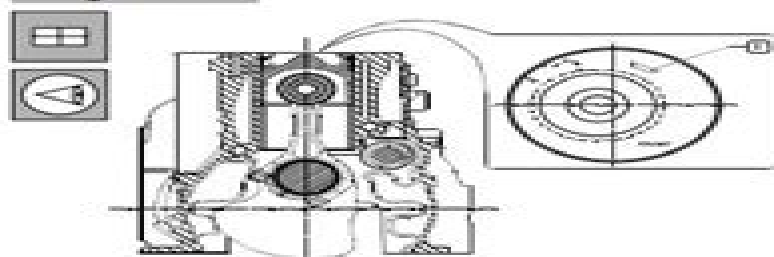


Lubricate thoroughly the pistons, including the piston rings and the cylinder liner inside.

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

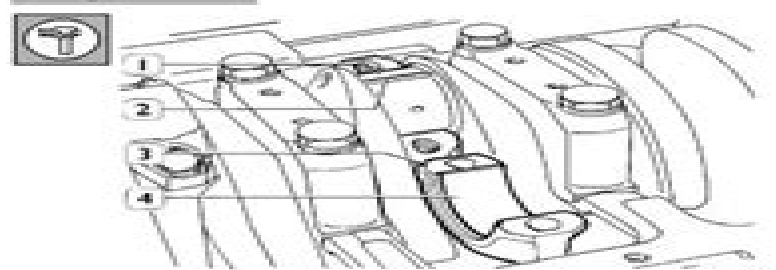


SCHEME FOR MOUNTING THE CONNECTING ROD-PISTON ASSEMBLY INTO THE TUNNEL

- ☐ 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

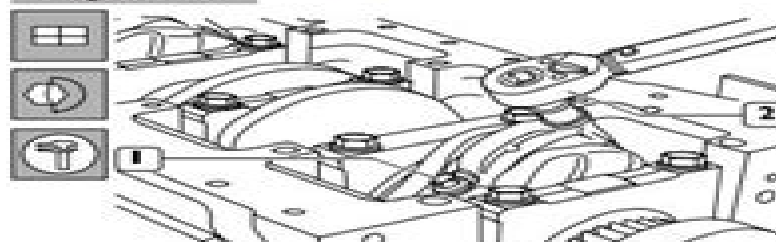
Figure 120



The play can be measured by following the procedure below:

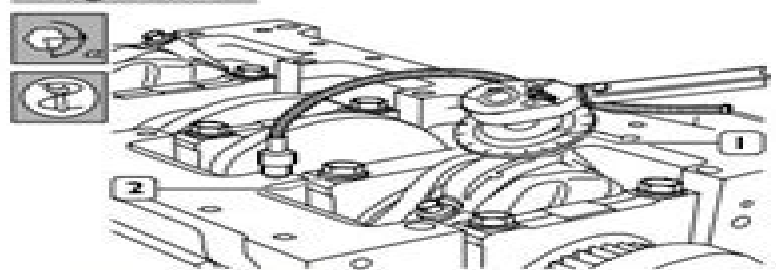
- ☐ clean thoroughly the parts and eliminate any trace of oil;
- ☐ place a piece of gauged wire (2) on drive shaft pins (1);
- ☐ mount the connecting rod caps (3) with their respective half bearings (4);

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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