

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 (0.1312-0.1321)
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"	0.410-0.416 mm (0.0161-0.0163)
0.050"	0.045-0.049 mm (0.0018-0.0019)

Connecting rod shells

Thickness: standard	40.007-40.009 mm (1.5743-1.5737)
undersize 0.010"	0.000-40.005 mm (0.1594-0.1597)
0.020"	0.006-40.010 mm (0.1594-0.1597)
0.030"	0.006-40.004 mm (0.1594-0.1597)
0.040"	0.047-40.004 mm (0.1594-0.1597)
0.050"	0.047-40.005 mm (0.1594-0.1597)

Connecting rods

Marked 1 to 6 "16007" marking on steel flange forward

Marked with replaceable bearing shells

General: connecting rod bearing bearing seat	40.007-40.009 mm (1.5942-1.5937)
bearing shell bearing seat	75.140-75.152 mm (2.9571-2.9577)
pin/bush pin bearing	See bearing "bush/pin pair"
rod clearance: connecting rod - crankshaft	0.10-0.20 mm (0.004-0.008)

Plywheel, fitted

Max. permissible axial force measuring radius 100 mm ± 6"

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, standard	40.006-40.016 mm (1.5744-1.5737)
2nd bearing pin, standard	40.021-40.040 mm (1.5726-1.5730)
3rd bearing pin, standard	40.025-40.030 mm (1.5706-1.5707)
4th bearing pin, standard	40.040-40.045 mm (1.5707-1.5708)

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Jianjun Gao



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