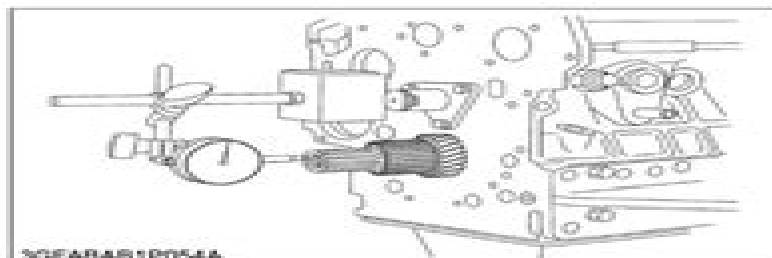


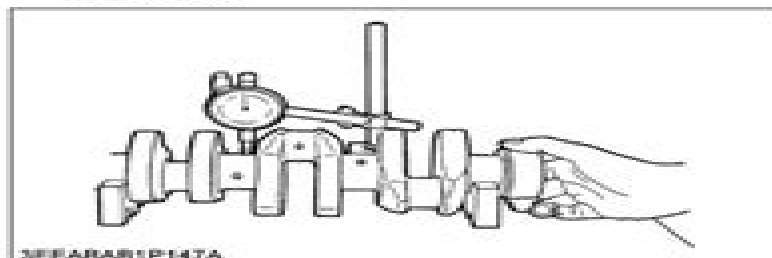
Over-size	0.20 mm 0.0079 in.	0.40 mm 0.016 in.
The crankshaft journal must be fine-finished to higher than Rmax. = 0.05		



6.4.2 Checking crankshaft alignment

Tools required

- Dial indicator
- V block
- Surface plate



1. Support the crankshaft with V blocks on the surface plate at both end journals.
2. Set a dial indicator with its tip on the intermediate journal.
3. Measure the crankshaft alignment.
4. If the measurement exceeds the service limit, replace the crankshaft.

Crankshaft alignment	Service limit	0.02 mm 0.0008 in.
----------------------	---------------	-----------------------

6.4.3 Checking oil clearance between crankpin and crankpin bearing

NOTE

- Never insert the plastigauge into the crankpin oil hole.
- Be sure not to move the crankshaft while the connecting rod screws are tightened.

Tools required

- Plastigauge

BX1880 and BX2380

Crankpin O.D.	Service specification	33.959 to 33.975 mm 1.3370 to 1.3375 in.
Crankpin bearing I.D.		33.995 to 34.010 mm 1.3384 to 1.3389 in.

BX2680

Crankpin O.D.	Service specification	39.959 to 39.975 mm 1.5732 to 1.5738 in.
Crankpin bearing I.D.		40.040 to 40.050 mm 1.5764 to 1.5767 in.

1. Clean the crankpin and crankpin bearing.
2. Put a strip of plastigauge on the center of the crankpin.
3. Install the connecting rod cap and tighten the connecting rod screws to the specified torque, and remove the cap again.
4. Measure the amount of the flattening with the scale, and get the oil clearance.
5. If the oil clearance exceeds the service limit, replace the crankpin bearing.

BX1880 and BX2380

Oil clearance between crankpin and crankpin bearing	Service specification	0.020 to 0.051 mm 0.00079 to 0.0020 in.
	Service limit	0.15 mm 0.0059 in.

BX2680

Oil clearance between crankpin and crankpin bearing	Service specification	0.029 to 0.091 mm 0.0011 to 0.0036 in.
	Service limit	0.20 mm 0.0079 in.

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J Dewey



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