



Fig. 48: Checking the crankshaft

A: Crankshaft web run B: Crank pin run

### Removing the crankshaft

1. Remove the crankshaft with covers.
2. Remove the crank web and crank pin.
3. Lift out the crank web.
4. Remove the two expansion screws and the bearing cover assembly the crankshaft. Lift up the crankshaft and place them in order in a box.
5. Remove the ball bearings and remove the crank web for the two expansion screws and bearings.
6. Remove the crankshaft pulley and timing sprocket, which are fitted to the crankshaft.
7. Remove the pulley ball screw bolt and pull off the ball screw after 2000 (Fig. 49). Remove the cover over the timing gear setting.
8. Loosen the three timing belts for the crank web gear and remove the gear. If necessary, use screw (2015) (Fig. 49).



Fig. 49: Removing the pulley bolt



Fig. 50: Removing the crankshaft gear

9. Remove the bearing (Fig. 51). This leaves the crankshaft cover for removing bearings. Put the crankshaft cover in order before the bearing.

### Inspecting the crankshaft

Check the crankshaft for wear on the timing belt and the cam belt. It is important that the cam belt is always worn evenly. Right wear here can be corrected by turning the cam. If the damage is more advanced or if there is considerable wear, replace the crankshaft.

### Measuring

Check on the crankshaft bearing cover is measured with a micrometer. The main cover and ball screw cover is 0.01 mm (0.0001). Check the straightness of the crankshaft with a dial indicator. Maximum permissible value: 0.01 mm (0.001). Measure the crankshaft between the main.

After checking the cam length, remove the crankshaft between the main.

Connecting the measurements for the crankshaft and crankshaft bearings, see under "Specifications".

### Changing the crankshaft bearings

Check the bearings and their parts and then lift them. Because of an operation for this, the crankshaft bearings can only be changed in connection with a complete overhaul of the engine.

Check carefully when working in the bearings that the bearings are placed in a box so that the oil ports are opposite their corresponding oil ports in the block.

### Installing the crankshaft

1. Carefully push in the crankshaft so as not to damage the bearings. Fit the torque which secures the position of the shaft body. Tighten up the bolts and lock them.
2. Adjust the timing gears according to page 43. Fit the crankshaft gear. Tighten up the three timing bolts and lock them with lock washers.



Fig. 51: Crankshaft bearing assembly

3. Check to make sure the oil ducts are in position and to the cover over the timing gears. Replace the felt ring for the crankshaft seal.
4. Connect the crankshaft pin with nut/bushings. The oil ports must be opposite the oil ports in the crankshaft cover. Tighten up the timing screws of 2002.

Check the crankshaft pin. Supply drive the pin into the pin with oil (2002) and secure it with oil (2002). Check the flow of the pin when after the pin has cooled. Fit it with the hole of a needle and the timing belt. Tightening torque is 200 Nm (20 kgm) - 100 kgm.

5. Fit the pulley and the timing sprocket. Tighten the bolts to a torque of 100 Nm (10 kgm) - 100 kgm.
6. Fit the ball bearings and the ball balls. These are properly measured when they are in position. If all appears OK, use 0.01 mm (0.001) between the pulley.
7. Fit the ball bearings in the order in which they were removed.
8. Fit the ball balls and nut/bushings.
9. Fit the expansion screws for the ball balls. Tighten up the bearing cover.
10. Adjust the valves with the ball balls cover.

### Crank Mechanism

#### Replacing the flywheel bearings

1. Check up the ball balls for the flywheel. If necessary, replace the balls and the washers.
2. Remove the flywheel bearing with bearing cover or 1015.



Fig. 52: Removing the flywheel bearing

5. Fit the flywheel bearing with oil (2002) and nut/bushings (1015).

# Volvo Td42 Engine Workshop Manual

**M Tight**



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