

# 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 (0.1312-0.1327)  |
| 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"                             | 0.106-0.106 mm (0.0040-0.0040)   |
| 0.030"                             | 0.006-0.010 mm (0.0000-0.0003)   |
| 0.040"                             | 0.475-0.476 mm (0.0187-0.0187)   |
| 0.050"                             | 0.045-0.049 mm (0.0018-0.0019)   |

#### Connecting rod shells

|                     |                                  |
|---------------------|----------------------------------|
| Thickness: standard | 40.007-40.008 mm (1.5743-1.5740) |
| undersize 0.010"    | 40.000-40.005 mm (1.5748-1.5740) |
| 0.020"              | 40.005-40.010 mm (1.5748-1.5740) |
| 0.030"              | 40.015-40.024 mm (1.5710-1.5707) |
| 0.040"              | 40.027-40.034 mm (1.5686-1.5687) |
| 0.050"              | 40.047-40.050 mm (1.5686-1.5687) |

### Connecting rods

Marked 1 to 6 "16047" marking on steel flange forward

Provided with replaceable bearing shells

|                                               |                                  |
|-----------------------------------------------|----------------------------------|
| General: connecting rod bearing bearing shell | 40.007-40.008 mm (1.5642-1.5647) |
| bearing shell bearing shell                   | 75.140-75.152 mm (2.9571-2.9577) |
| pin/bush pin/bush                             | See bearing "bushings pin"       |
| rod clearance: connecting rod - crankshaft    | 0.10-0.20 mm (0.004-0.008)       |

### Plywheel, fitted

Max. permissible axial force measuring radius 100 mm ± 0"

|                     |                  |
|---------------------|------------------|
| Key gap on flywheel | 0.15 mm (0.006") |
|                     | 140 mm           |

### Plywheel casing, fitted

Max. permissible axial force for contact surface against crank casing

|                                                                        |                       |
|------------------------------------------------------------------------|-----------------------|
| Max. permissible axial force for steering bearing 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 | 40.000-40.015 mm (1.5748-1.5711) |
| 2nd bearing pin, standard   | 40.027-40.040 mm (1.5626-1.5620) |
| 3rd bearing pin, standard   | 40.025-40.030 mm (1.5686-1.5687) |
| 4th bearing pin, standard   | 40.040-40.045 mm (1.5675-1.5680) |

# Volvo Td42 Service Manual

**Volvo, Aktiebolaget**



## **Volvo Td42 Service Manual:**

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Volvo F/G 89 Service Manual Volvo,197?      **Volvo Td42 4786239 Turbocharger Rebuild Guide and Shop Manual** Brian Smothers,2015-01-19 This shop manual covers the proper disassembly inspection rework assembly and installation of the 4786239 turbocharger found on the Volvo TD42 engines Written by an industry professional this book contains full color photos diagrams torque specs and best practices Repairing your vehicle s turbocharger is easy and cost effective if you know how This shop manual covers Garrett Honeywell T04B61 465062 0001 465062 9001 465062 5001 465062 1 Turbochargers

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