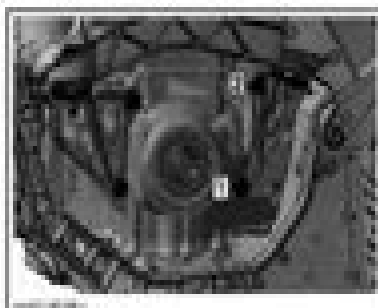


ENGINE SUPPORT SCREWS TORQUE

42 Nm x 4 Nm (31 lb-ft x 3 lb-ft)



FRONT ENGINE SUPPORT

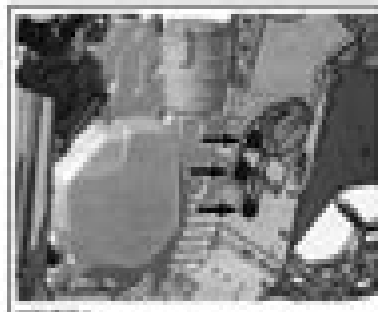
Front Engine Support Replacement (MAG Side)

1. Remove body parts and components as required to access to the engine support.
2. Remove screw securing rubber mount to engine support.



FRONT ENGINE SUPPORT

3. Remove screws securing engine to engine support.



FRONT ENGINE SUPPORT

4. Replace engine support.
5. Install new screws to secure engine support on engine.
6. Tighten engine support screws to specification as per the following sequence.

ENGINE SUPPORT SCREWS TORQUE

42 Nm x 4 Nm (31 lb-ft x 3 lb-ft)



FRONT ENGINE SUPPORT

7. Install new screw to secure engine rubber mount on engine support.
8. Tighten engine rubber mount screw to specification.

ENGINE RUBBER MOUNT SCREWS TORQUE (N/A)

24.5 Nm x 3.5 Nm (18 lb-ft x 2.6 lb-ft)

8. Install body parts and components as the reverse of removal procedure.

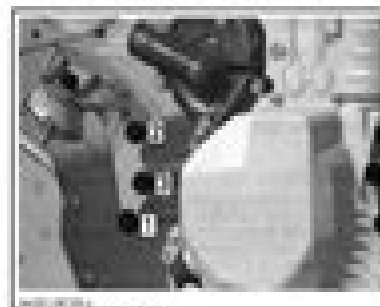
Rear Engine Support Replacement (MAG Side)

To replace rear engine support, refer to **FRONT ENGINE SUPPORT REPLACEMENT (MAG SIDE)**. However pay attention to the following.

Tighten engine support screws to specification as per the following sequence.

ENGINE SUPPORT SCREWS TORQUE

42 Nm x 4 Nm (31 lb-ft x 3 lb-ft)



REAR ENGINE SUPPORT

ENGINE RUBBER MOUNTS

Engine Rubber Mount Inspection

Check rubber mounts. Replace them if brittle, cracked or damaged.

Front and Rear Engine Rubber Mount Replacement (PTO Side)

1. Remove countershaft bearing support. Refer to **DRIVEN PULLEY AND COUNTERSHAFT (600 ACE)** subsection.
2. Replace engine rubber mount.
3. Install countershaft bearing support. Refer to **DRIVEN PULLEY AND COUNTERSHAFT (600 ACE)** subsection.

Front and Rear Engine Rubber Mount Replacement (MAG Side)

1. Remove body parts and components as required to access to the engine rubber mount.
2. Remove screw securing rubber mount to engine support.
3. Remove screws securing rubber mount to frame.



REAR ENGINE SUPPORT

REAR ENGINE SUPPORT

1. Remove screw securing rubber mount to engine support and

2. Remove screws securing rubber mount to frame.

4. Replace engine rubber mount.

5. Install new screws to secure engine rubber mount.

6. Tighten engine rubber mount screws to specification.

ENGINE RUBBER MOUNT SCREWS TORQUE (N/A)

24.5 Nm x 3.5 Nm (18 lb-ft x 2.6 lb-ft)

ENGINE RUBBER MOUNT SCREWS TORQUE (N/A)

10 Nm x 2 Nm (8 lb-ft x 1.5 lb-ft)

7. Install body parts and components as the reverse of removal procedure.

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calculate rolling power flat rolling analysis consider rolling of a flat plate in mill v_0 v_f 2 roll q h_0 h_f v_0 width of plate w is large à plane strain processing limits

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may 1 2018 an improved calculation method for rolling pressure and load torque of electrical drive engine is suggested further this method considers peculiar strain of product in high deformation zones and its accelerated motion in reverse mode improved analytical dependences for rolling pressure and load torque of electrical drive are reviewed

the calculation of rolling force innoval technology - May 06 2022

mar 26 2020 yield stress strain hardening factor \times strain rate hardening factor \times thermal softening factor in the rolling of aluminium it is strain hardening which typically dominates at low temperatures on the other hand strain rate and temperature are more important in hot rolling