

# 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 (0.1212-0.1220)  |
| 0.030"              | 0.006-0.016 mm (0.1302-0.1307) |
| 0.040"              | 0.406-0.440 mm (0.1598-0.1732) |
| 0.050"              | 0.045-0.049 mm (0.1417-0.1457) |

## 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 (1.5748-1.5752) |
| 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"                             | 0.475-0.478 mm (0.0187-0.0189)   |
| 0.050"                             | 0.045-0.049 mm (0.0018-0.0019)   |

### Connecting rod shells

|                     |                                  |
|---------------------|----------------------------------|
| Thickness: standard | 40.007-40.009 mm (1.5763-1.5767) |
| undersize 0.010"    | 40.000-40.005 mm (1.5748-1.5752) |
| 0.020"              | 40.005-40.010 mm (1.5763-1.5767) |
| 0.030"              | 40.015-40.024 mm (1.5769-1.5769) |
| 0.040"              | 40.025-40.034 mm (1.5769-1.5769) |
| 0.050"              | 40.045-40.050 mm (1.5769-1.5769) |

## Connecting rods

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

Provided with replaceable bearing shells

|                                             |                                  |
|---------------------------------------------|----------------------------------|
| General: connecting rod bearing bearing pin | 40.007-40.009 mm (1.5763-1.5767) |
| bearing shell bearing pin                   | 75.140-75.152 mm (2.9571-2.9577) |
| pin/bush pin bearing                        | See bearing "bushpin pin"        |
| rod clearance: connecting rod - crankshaft  | 0.10-0.20 mm (0.0039-0.0079)     |

## Plywheel, fitted

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

|                  |  |
|------------------|--|
| 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                        | 8                                |
| Number of bearings          | 7                                |
| First bearing pin, standard | 40.000-40.015 mm (1.5748-1.5757) |
| 2nd bearing pin, standard   | 40.021-40.040 mm (1.5756-1.5757) |
| 3rd bearing pin, standard   | 40.025-40.030 mm (1.5769-1.5769) |
| 4th bearing pin, standard   | 40.040-40.045 mm (1.5769-1.5769) |

# Volvo Pv Repair Manual

**Michael Hoelscher**

A red circular graphic with a gradient, appearing as a stylized arrow or a partial circle, located to the right of the author's name.

## **Volvo Pv Repair Manual:**

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