

VOLVO BM 646

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Main bearing shells

General: bearing shell location in block

Thickness: standard	0.001-0.004 mm (0.0001-0.00015 in)
undersize 0.010"	0.004-0.001 mm (0.0001-0.00015 in)
0.020"	0.001-0.004 mm (0.0001-0.00015 in)
0.030"	0.000-0.010 mm (0.0000-0.00039 in)
0.040"	0.000-0.040 mm (0.0000-0.00157 in)
0.050"	0.000-0.050 mm (0.0000-0.00197 in)

Big-end bearings

Connecting rod pins

Big-end bearing, rod pin clearance	0.006-0.008 mm (0.0002-0.00031 in)
Bearing pin length	40.000-40.005 mm (1.5748-1.5752 in)
General: standard	1.000-1.011 mm (0.03937-0.03981 in)
undersize 0.010"	0.990-0.998 mm (0.03900-0.03929 in)
0.020"	0.980-0.990 mm (0.03858-0.03937 in)
0.030"	0.960-0.990 mm (0.03780-0.03937 in)
0.040"	0.940-0.990 mm (0.03702-0.03937 in)
0.050"	0.920-0.990 mm (0.03623-0.03937 in)

Connecting rod shells

Thickness: standard	46.000-46.005 mm (1.7716-1.7718 in)
undersize 0.010"	45.990-46.000 mm (1.7709-1.7718 in)
0.020"	45.970-46.000 mm (1.7700-1.7718 in)
0.030"	45.950-46.000 mm (1.7692-1.7718 in)
0.040"	45.930-46.000 mm (1.7684-1.7718 in)
0.050"	45.910-46.000 mm (1.7676-1.7718 in)

Connecting rods

Marked 1 to 6 (1-6000) marking on steel flange forwards

Provided with replaceable bearing shells

General: connecting rod bearing bearing shell	46.000-46.005 mm (1.7716-1.7718 in)
bearing shell bearing pin	75.140-75.152 mm (2.9581-2.9597 in)
pin/bushing pin bearing	See bearing "bushings pin"
rod clearance: connecting rod - crankshaft	0.10-0.20 mm (0.0039-0.0079 in)

Plywheel, fitted

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

0.15 mm (0.006 in)	
140 mm	

Plywheel casing, fitted

Max. permissible axial force for contact surface against crank casing

0.15 mm (0.006 in)	
Max. 4.25 mm (0.167 in)	

Crankshaft

Size	7
Number of bearings	7
First bearing pin, diameter	46.000-46.010 mm (1.7716-1.7718 in)
2nd bearing pin, diameter	46.021-46.040 mm (1.8120-1.8130 in)
3rd bearing pin, diameter	46.035-46.050 mm (1.8126-1.8130 in)
4th bearing pin, diameter	46.040-46.050 mm (1.8126-1.8130 in)

Volvo 640 Engine Manual

Mark Storey



Volvo 640 Engine Manual:

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