

E3

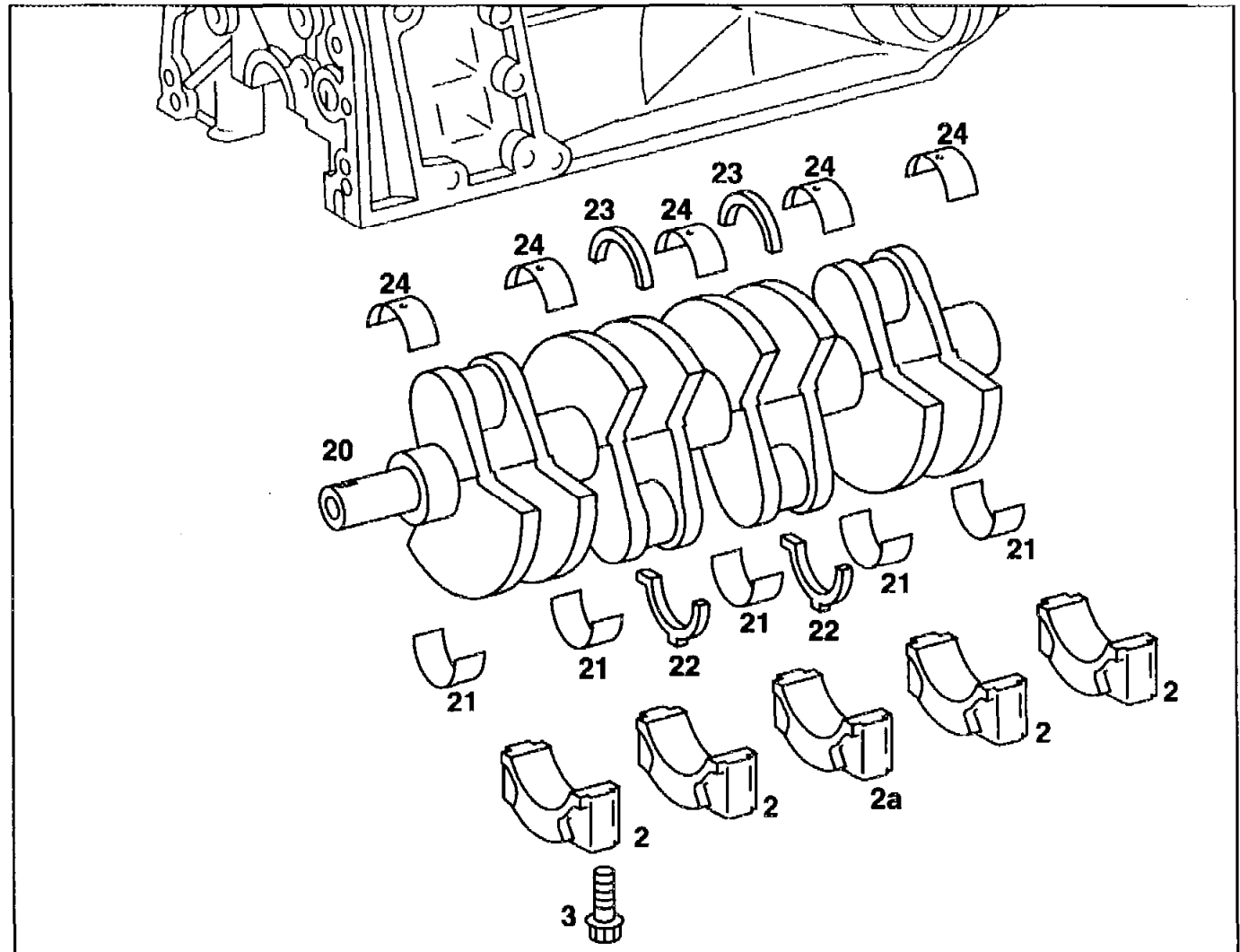
AR03.20-P-4351B

Removing and installing crankshaft





23.4.96

ENGINE 604, 605, 606 /*Shown on engine 604*



- 2 Bearing cap
- 2a Fit bearing cap
- 3 Bolts of bearing cap
- 20 Crankshaft
- 21 Bearing shells in bearing cap
(without oil drilling)
- 22 Thrust washer (axial bearings) in
bearing cap (with retaining lug)
- 23 Thrust washer (axial bearings) in
crankcase
- Engine 604 3rd main bearing = fit
bearing
- Engine 605 4th main bearing = fit
bearing
- Engine 606 5th main bearing = fit
bearing
- 24 Bearing shells in crankcase (with oil
drilling)





 	Removing, installing		
1	Remove engine	Engine 604, 605 in model 202 Engine 604, 605, 606 in model 210 Engine 605, 606 in model 124 Engine 606.961 in model 140	AR01.10-P-2400HA AR01.10-P-2400HB
		Engine 606 in model 463	AR01.10-P-2400GG
2	Remove cylinder head	Model 124, 140, 202, 210	AR01.30-P-5800HA
		Model 463	AR01.30-P-5800GG
3	Remove timing case cover	Model 124, 140, 202, 210	AR01.40-P-8000HA
		Model 463	AR01.40-P-8000GG
4	Remove end cover		AR01.40-P-8913HA
5	Remove pistons		AR03.10-P-7021B O1
6	Unbolt crankshaft bearing caps (2, 2a)	<p> The crankshaft bearing caps (2, 2a) are numbered consecutively, beginning with the first crankshaft bearing cap at the front ↓ Pay attention to fit</p> <p>Fit of crankshaft bearing caps</p> <p> Inspect bolts of crankshaft bearing caps</p>	<p>AH03.20-P-4351-02A A17</p> <p>AR03.20-P-4351-03A K15</p> <p>BE03.20-P-1001-01A</p>



		<p>Nm</p> <p> Installation: oil the threads and bolt head contact surface of the crankshaft bearing cap bolts and tighten from the inside to the outside beginning at the fit bearing.</p> <p>Rotate crankshaft and check that it rotates freely.</p>	BA03.20-P-1001-01A
7	Remove crankshaft (20) from crankcase	<p> Installation: oil bearing shells before inserting the crankshaft.</p> <p>The oil grooves in the thrust washers (22) and (23) should face toward the thrust collars of the crankshaft.</p> <p>The thrust washers (22) in the bearing cap each have two retaining lugs as an anti-twist lock.</p>	
8	Install in the reverse order		

Test data of crankshaft bearing cap bolts

Number	Designation	Engine 604, 605, 606
BE03.20-P-1001-01A	Crankshaft bearing cap bolts	Thread diameter M 11
		Length (L) when new mm 61.8–62.2
		Max. length (L) mm 63.8
		Fig. see AR03.20-P-4351-03A

 Crankshaft bearing caps

Number	Designation	Engine 604, 605, 606
BA03.20-P-1001-01A	Bolt of crankshaft bearing caps	M11 1st stage Nm 55
		2nd stage Δ° 90