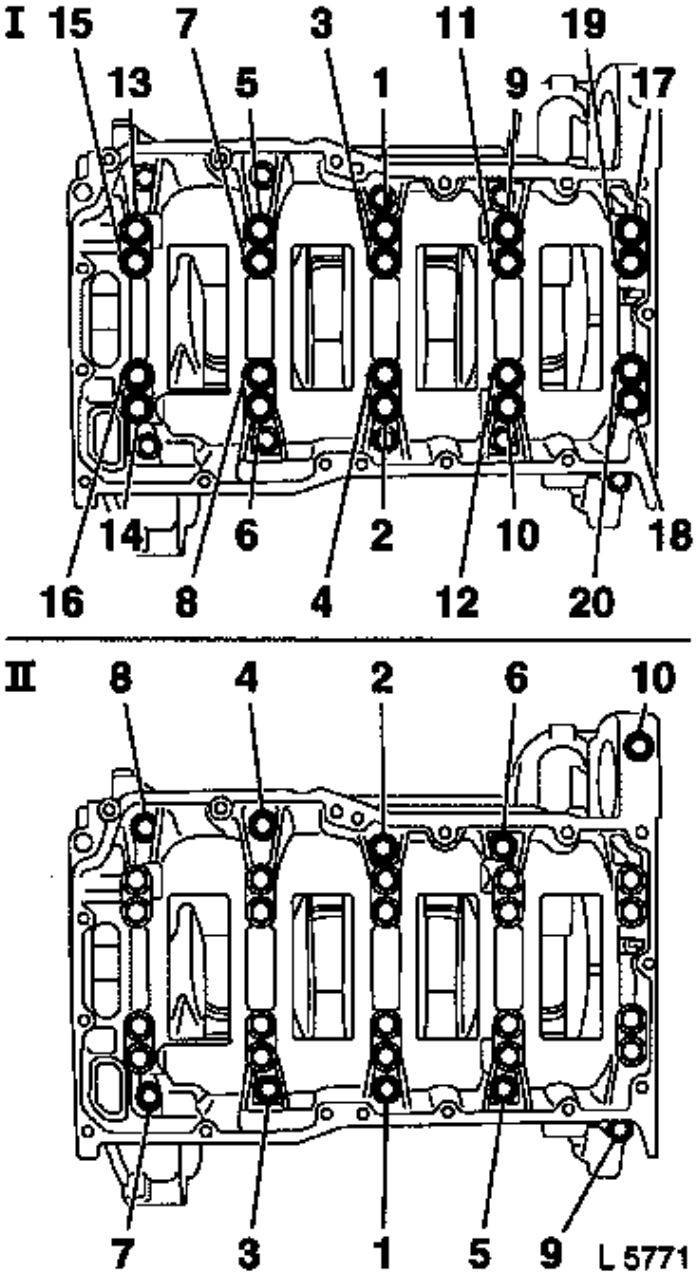
Crankshaft Bearing Clearance, Check, Measure with micrometer (Z 22 SE)

Measure

1. Attach the cylinder block base plate.
   Note: Observe the tightening sequence.
   - Tighten all bolts loosely.
   - Tighten the M10 bolts – tightening torque **20 Nm + 70° + 15°**
   - Tighten the M8 bolts – tightening torque **23 Nm**



2. Fit the internal gauge and calibrate it with the micrometer (1).
   1 Measure the diameter of the crankshaft bearings at 3 points.
   - Use the inside micrometer to measure at the points I, II and III.

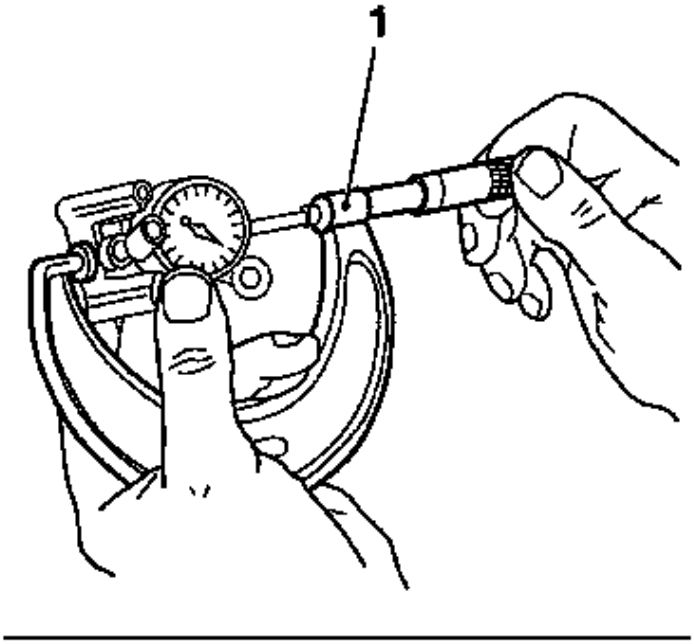
   2 Measure the diameter of the crankshaft bearings at 3 points.
   - Use the inside micrometer to

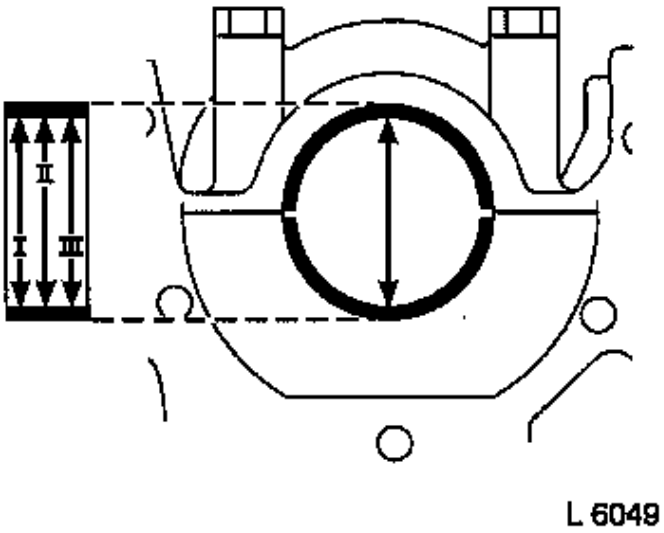
measure at the points I, II and III.

3 Measure the diameter of the crankshaft bearings at 3 points.
- Use the inside micrometer to measure at the points I, II and III.

4 Measure the diameter of the crankshaft bearings at 3 points.
- Use the inside micrometer to measure at the points I, II and III.

Calculate the mean value for the crankshaft bearing diameter.
- Formula: I + II + III / 3





3.

Measure the crankshaft bearing journal diameter.

1 Measure the crankshaft bearing journal diameter at 2 points.
- Use a micrometer to measure at the points I and II.

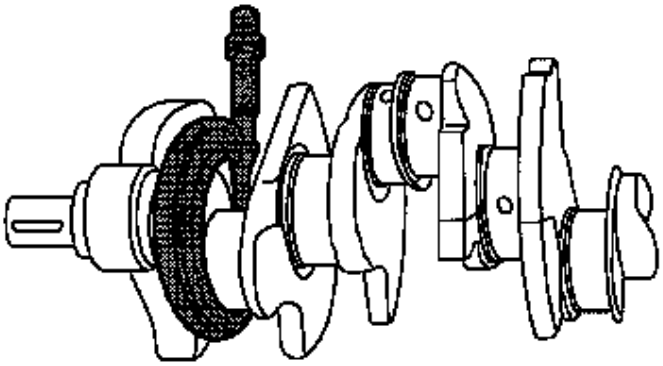
2 Measure the crankshaft bearing journal diameter at 2 points.
- Use a micrometer to measure at the points I and II.

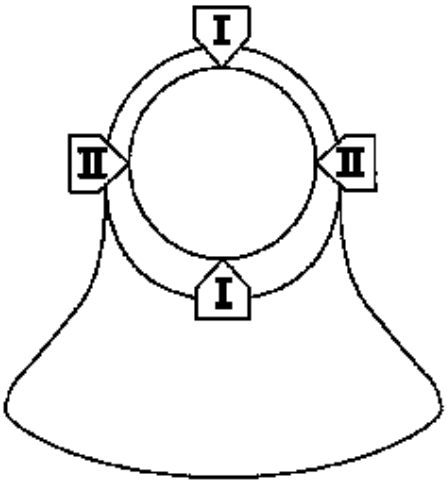
3 Measure the crankshaft bearing journal diameter at 2 points.
- Use a micrometer to measure at

the points I and II.

4 Measure the crankshaft bearing journal diameter at 2 points.
- Use a micrometer to measure at the points I and II.

Calculate the mean value for the crankshaft bearing journal diameter.
- Formula: I + II / 2





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4. Determine the crankshaft bearing clearance.
- Formula: Mean crankshaft bearing diameter – mean crankshaft bearing journal diameter

5. Comparison between specified values and actual values
- Permissible crankshaft bearing clearance: **0,007 - 0,014 mm**