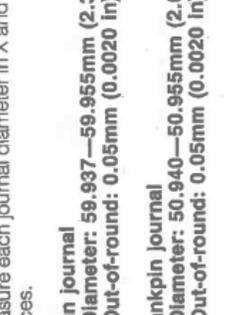
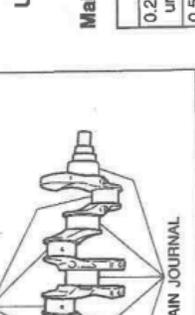
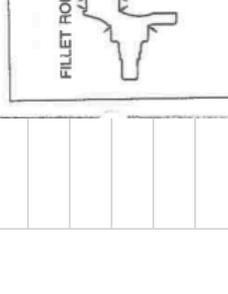


Crankpin Journals	1	2	3	4																																												
X-AXIS																																																
Y-AXIS																																																
out of round 0.0020 max																																																
<p>4. Measure each journal diameter in X and Y directions at two places.</p> <p>Main journal Diameter: 59.937—59.955mm (2.3597—2.3604 in) Out-of-round: 0.05mm (0.0020 in) max.</p> <p>Crankpin Journal Diameter: 50.940—50.955mm (2.0055—2.0061 in) Out-of-round: 0.05mm (0.0020 in) max.</p> <p>5. If the diameter is below the minimum, grind the journals to match an undersize bearing.</p> <p>Undersize bearing: 0.25mm (0.010 in), 0.50 mm (0.020 in), 0.75mm (0.030 in)</p> <p>Main journal diameter undersize</p> <table border="1" data-bbox="1055 1365 1250 1617"> <thead> <tr> <th colspan="2">Bearing size</th> <th colspan="2">Journal diameter</th> </tr> </thead> <tbody> <tr> <td>0.25 (0.010) undersize</td> <td>No.1,2,4,5</td> <td>59.693—59.711 (2.3501—2.3508)</td> <td></td> </tr> <tr> <td></td> <td>No.3</td> <td>59.687—59.705 (2.3499—2.3506)</td> <td></td> </tr> <tr> <td>0.50 (0.020) undersize</td> <td>No.1,2,4,5</td> <td>59.443—59.461 (2.3403—2.3410)</td> <td></td> </tr> <tr> <td></td> <td>No.3</td> <td>59.437—59.455 (2.3400—2.3407)</td> <td></td> </tr> <tr> <td>0.75 (0.030) undersize</td> <td>No.1,2,4,5</td> <td>59.193—59.211 (2.3304—2.3311)</td> <td></td> </tr> <tr> <td></td> <td>No.3</td> <td>59.187—59.205 (2.3302—2.3309)</td> <td></td> </tr> </tbody> </table> <p>Crankpin journal diameter undersize</p> <table border="1" data-bbox="1266 1365 1412 1617"> <thead> <tr> <th colspan="2">Bearing size</th> <th colspan="2">Journal diameter</th> </tr> </thead> <tbody> <tr> <td>0.25 (0.010) undersize</td> <td></td> <td>50.690—50.705 (1.9957—1.9963)</td> <td></td> </tr> <tr> <td>0.50 (0.020) undersize</td> <td></td> <td>50.440—50.455 (1.9858—1.9864)</td> <td></td> </tr> <tr> <td>0.75 (0.030) undersize</td> <td></td> <td>50.190—50.205 (1.9760—1.9766)</td> <td></td> </tr> </tbody> </table>	Bearing size		Journal diameter		0.25 (0.010) undersize	No.1,2,4,5	59.693—59.711 (2.3501—2.3508)			No.3	59.687—59.705 (2.3499—2.3506)		0.50 (0.020) undersize	No.1,2,4,5	59.443—59.461 (2.3403—2.3410)			No.3	59.437—59.455 (2.3400—2.3407)		0.75 (0.030) undersize	No.1,2,4,5	59.193—59.211 (2.3304—2.3311)			No.3	59.187—59.205 (2.3302—2.3309)		Bearing size		Journal diameter		0.25 (0.010) undersize		50.690—50.705 (1.9957—1.9963)		0.50 (0.020) undersize		50.440—50.455 (1.9858—1.9864)		0.75 (0.030) undersize		50.190—50.205 (1.9760—1.9766)		 <p>98L081-087</p>  <p>98L081-084</p> 			
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