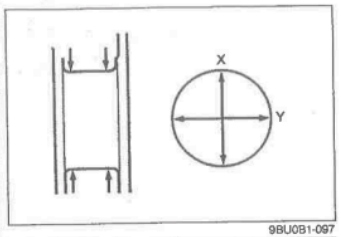
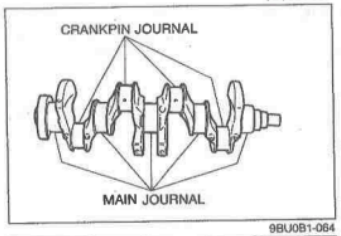
Main Journals	1	2	3	4	5
X-AXIS					
Y-AXIS					
out of round					
0.0020 max					



9BU0B1-097



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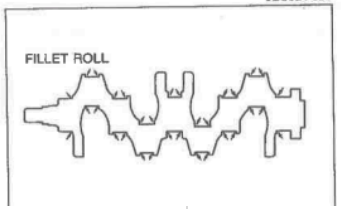

4. Measure each journal diameter in X and Y directions at two places.

Main journal
Diameter: 59.937—59.955mm (2.3597—2.3604 in)
Out-of-round: 0.05mm (0.0020 in) max.

Crankpin journal
Diameter: 50.940—50.955mm (2.0055—2.0061 in)
Out-of-round: 0.05mm (0.0020 in) max.

5. If the diameter is below the minimum, grind the journals to match an undersize bearing.

Undersize bearing: 0.25mm (0.010 in), 0.50 mm (0.020 in), 0.75mm (0.030 in)

Main journal diameter undersize

mm (in)

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)

Crankpin journal diameter undersize

mm (in)

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)