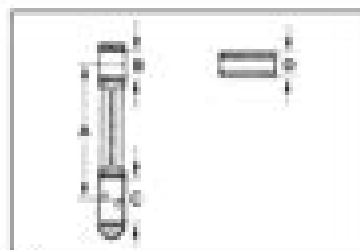


Clearance volume
A = Clearance volume
B = Head gasket

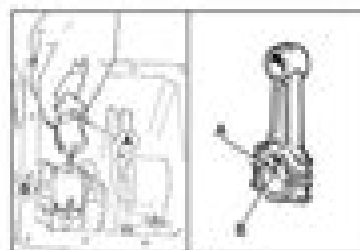
The thickness of head gasket determines the clearance volume. A piston seal for 0.75 + 0.05 mm for 5.0 450, 5.0 451S, 5.0 515, 5.0 515S and 0.80 + 0.05 mm for 4.0 540, 4.0 705, 4.0 820. Measure the gasket crown position as to the cylinder surface and choose a gasket having a suitable thickness. Always remember that the gasket at the top dead center could be at the same level, either under or over the cylinder.



Connecting rod equipped with bearings and pin pin
For 5.0 450, 5.0 451S, 5.0 515, 5.0 515S

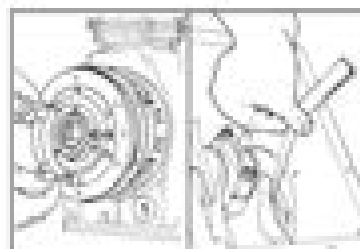
Dimensions (mm)
A = 140.00 + 0.05
B = 25.00 + 0.05 (with pin and machined bearing)
C = 40.00 + 0.05 (with bearing tightening at 0 Nm)
D = 27.00 + 0.05
For 4.0 540, 4.0 705, 4.0 820
Dimensions (mm)
A = 140.00 + 0.05
B = 25.00 + 0.05
C = 35.00 + 0.05
D = 27.00 + 0.05

The connecting rod big end bearings are supplied either at normal size and dimension 0.025 and 0.50 mm.



Connecting rod, big end bearings

While reassembling, the A and B connecting rods should not be at the same size.
Tighten the screws at 30 Nm for 5.0 450, 5.0 451S, 5.0 515, 5.0 515S and at 40 Nm for 4.0 540, 4.0 705, 4.0 820.



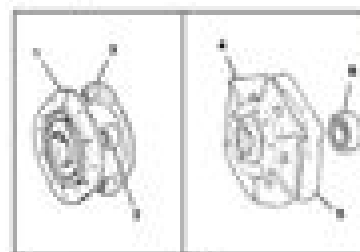
Main bearing on flywheel side

Extract the bearing using three screws, as per picture 16. While reassembling, replace gasket 1. Check that the oil seal ring is intact. Tighten the screws at 25 Nm.

Drive shaft axial clearance

After having removed the main bearing on the flywheel, check drive shaft axial clearance. Its value is 0.10 + 0.40 mm for 5.0 450, 5.0 451S, 5.0 515, 5.0 515S and 0.10 + 0.30 mm for 4.0 540, 4.0 705, 4.0 820.

The adjustment is carried out by changing the gasket 1 thickness.



Side distributor pin

It can be found in engines equipped with industrial type drive shaft. The gaskets 2 and 3, thanks to their thickness, ensure the oil seal and affect the pin shaft axial clearance, as well. For the check, see information hereafter.

Components

For 5.0 450, 5.0 515 picture 17

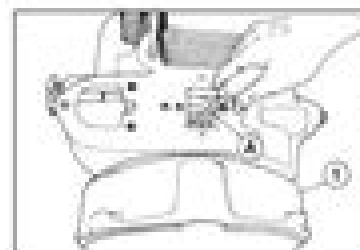
1 Pin 2 Seal 3 Gasket

Fit the pin at its base at 20 Nm.

For 4.0 540, 4.0 705, 4.0 820 picture 17

1 Pin 2 Gasket 3 Ball bearing

Fit the pin at its base at 40 Nm.



Camshaft axial clearance

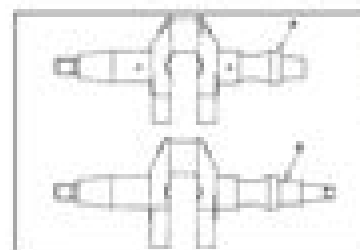
Carry out this check before assembling the head. Fit the side distributor pin, or ball 1 at 20 Nm. Remove the intake and exhaust tappets and with an implanter operate on the camshaft forward and backward in an axial direction.

The axial clearance A shall be:

A = 0.20 + 0.60 mm for 5.0 450, 5.0 451S, 5.0 515, 5.0 515S

A = 0.10 + 0.60 mm for 4.0 540, 4.0 705, 4.0 820.

Adjust the clearance by changing the gasket thickness between the distributor part of 2 is assembled or ball 1 and the base. It is forbidden to assemble more than one gasket.



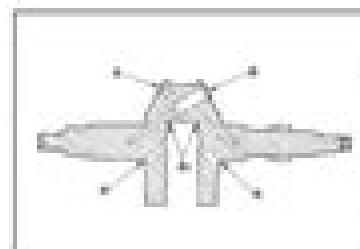
Drive shaft

There are two types of standard drive shafts:

A Automotive type (agricultural machines)

B Industrial type (motor pumps generating set, etc.)

Note for left-handed engines, i.e. 5.0 515S, the drive shaft turns anticlockwise (seen from the flywheel position) and the thread is clockwise on the power takeoff side as well as on the flywheel side.



Drive shaft lubrication ducts

Remove the caps, clean the ducts A and B with a point and blow them with compressed air.

Replace the caps by inserting them on their seat, then check their seat.

Drive shaft connecting radius

R = 2 mm

R₀ = 0.5 mm

Note: when the main journal and the crank are ground, it is essential to reach R and R₀ values in order to avoid any possible breaking of the drive shaft.

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Ying-Ying Zheng



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