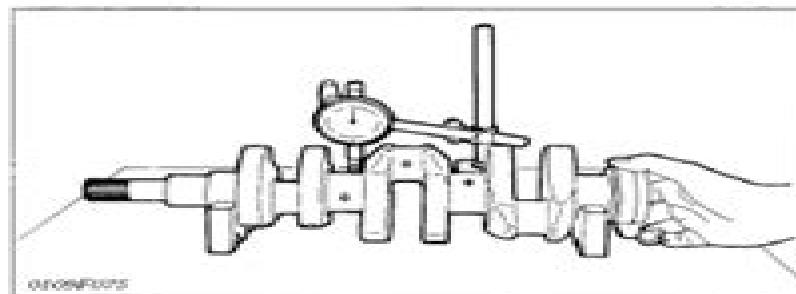
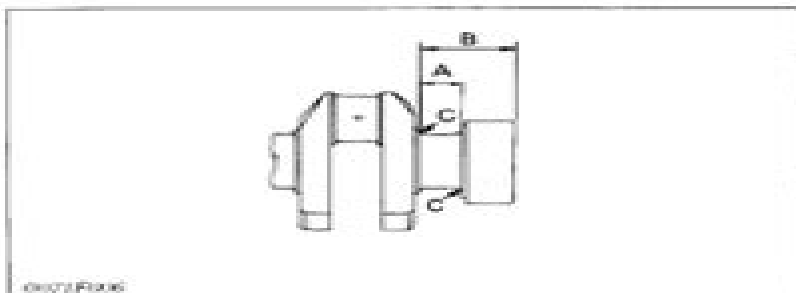
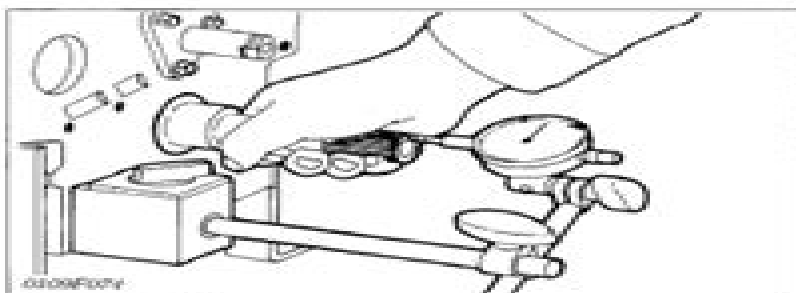


[5] CRANKSHAFT



Crankshaft End Play

1. Set a dial indicator with its indicator tip touching the end of the crankshaft.
2. Measure the end play by moving the crankshaft to the front and rear.
3. If the play exceeds the allowable limit, replace the side bearing.
4. If the same size bearing is useless because of the crankshaft journal wear, replace it with an oversize one referring to the table and the figure.

End play	Factory specification	0.15 to 0.31 mm, 0.0059 to 0.0122 in.
	Allowable limit	0.5 mm, 0.020 in.

(Reference)

- Oversize bearings:

Oversize	Bearing	Code Number	Marking
0.2 mm 0.008 in.	Side bearing 1 02	15261-23951	020 OS
	Side bearing 2 02	15261-23971	020 OS
0.4 mm 0.016 in.	Side bearing 1 04	15261-23961	040 OS
	Side bearing 2 04	15261-23981	040 OS

- Oversize dimensions of crankshaft:

Dimension

- (A) 0.2 mm Oversize 23.40 to 23.45 mm
(0.008 in.) (0.9134 to 0.9154 in.)
- 0.4 mm Oversize 23.80 to 23.85 mm
(0.016 in.) (0.9213 to 0.9232 in.)
- (B) 0.2 mm Oversize 46.1 to 46.3 mm
(0.008 in.) (1.815 to 1.823 in.)
- 0.4 mm Oversize 46.3 to 46.5 mm
(0.016 in.) (1.823 to 1.831 in.)
- (C) 1.8 to 2.2 mm (0.071 to 0.087 in.)

- Finely finish the contact face to the bearing, to the higher than $\nabla\nabla\nabla\nabla$ (0.4S)

Crankshaft Alignment

1. Support the crankshaft with V blocks on the surface plate at both end journals.
2. Set a dial indicator with its indicator tip touching the intermediate journal.
3. Rotate the crankshaft on the V blocks and get the eccentricity (half of the measurement).
4. If the eccentricity exceeds the allowable limit, replace the crankshaft.

Eccentricity	Allowable limit	0.02 mm 0.0008 in.
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Kubota 640 Manual

**Matthew Kroh, Salvatore Docimo
Jr., Sofiane El Djouzi, Amber
Shada, Kevin M. Reavis**

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