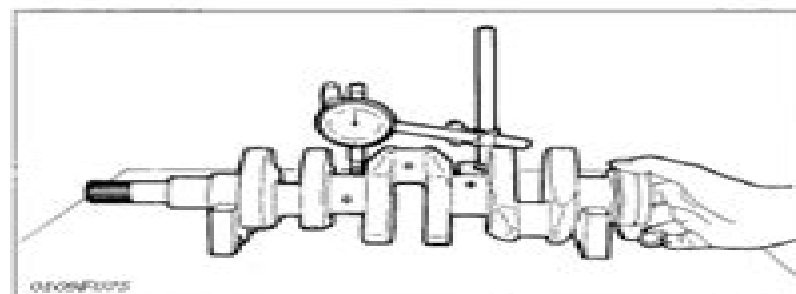
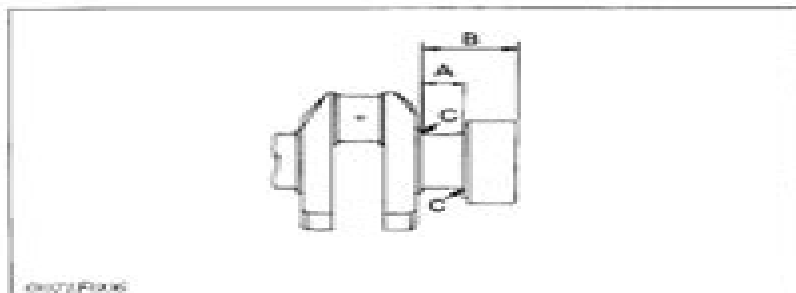
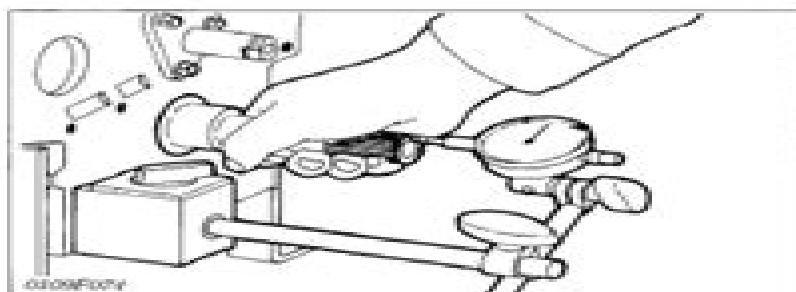


## [5] CRANKSHAFT



### 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,<br>0.0059 to 0.0122 in. |
|----------|-----------------------|------------------------------------------|
|          | Allowable limit       | 0.5 mm,<br>0.020 in.                     |

### (Reference)

#### • Oversize bearings:

| Oversize            | Bearing           | Code Number | Marking |
|---------------------|-------------------|-------------|---------|
| 0.2 mm<br>0.008 in. | Side bearing 1 02 | 15261-23951 | 020 OS  |
|                     | Side bearing 2 02 | 15261-23971 | 020 OS  |
| 0.4 mm<br>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.)

- Finally finish the contact face to the bearing, to the higher than  $\nabla\nabla\nabla\nabla$  (0.45)

### 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<br>0.0008 in. |
|--------------|-----------------|-----------------------|
|--------------|-----------------|-----------------------|

# Kubota 640 Manual

**Lei Shi**



## **Kubota 640 Manual:**

## The Enigmatic Realm of **Kubota 640 Manual**: Unleashing the Language is Inner Magic

In a fast-paced digital era where connections and knowledge intertwine, the enigmatic realm of language reveals its inherent magic. Its capacity to stir emotions, ignite contemplation, and catalyze profound transformations is nothing short of extraordinary. Within the captivating pages of **Kubota 640 Manual** a literary masterpiece penned by way of a renowned author, readers set about a transformative journey, unlocking the secrets and untapped potential embedded within each word. In this evaluation, we shall explore the book's core themes, assess its distinct writing style, and delve into its lasting affect the hearts and minds of those that partake in its reading experience.

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