

(1) Press Gauge

Oil Clearance between Crankpins and Crankpin Bearings

1. Paste a press gauge onto the crankpin bearing with grease.
2. Tighten the connecting rod onto the crankpin to the specified torque (44.1 to 49.0 N·m, 4.5 to 5.0 kgf·m, 32.5 to 36.2 ft·lb).
3. Remove the connecting rod gently, and measure the depression of the press gauge with a sheet of gauge (paper).
4. If the measurement exceeds the allowable limit, replace the crankpin bearing.
5. If an undersize bearing is to be used, machine the crankshaft.

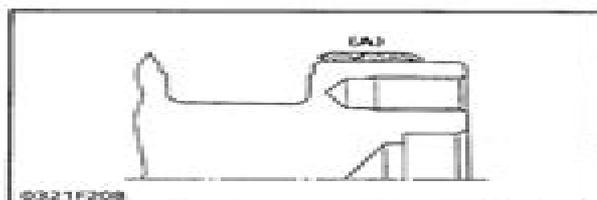
Oil clearance between crankpin and crankpin bearing	Factory spec.	0.025 to 0.087 mm 0.00098 to 0.00343 in.
	Allowable limit	0.20 mm 0.0079 in.
Crankpin O.D.	Factory spec.	46.959 to 46.975 mm 1.84878 to 1.84941 in.
Crankpin bearing I.D.	Factory spec.	47.000 to 47.046 mm 1.85039 to 1.85320 in.

Crankshaft Sleeve Wear

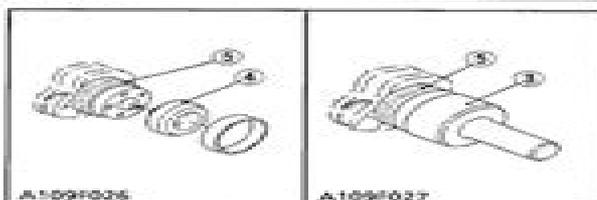
1. Measure the wear (A) of the crankshaft sleeve with a surface roughness tester.
2. If the wear exceeds the allowable limit, replace the crankshaft sleeve.

Wear (A)	Allowable limit	0.10 mm 0.0039 in.
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(A) Wear



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Replacing Crankshaft Sleeve

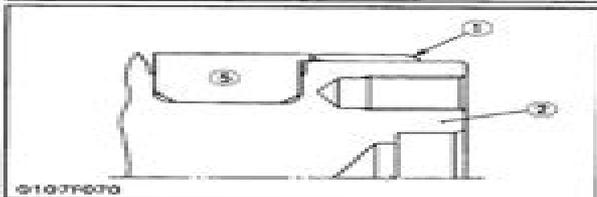
1. Remove the used crankshaft sleeve using a special-use puller set.
2. Set the sleeve guide (4) to the crankshaft.
3. Set the stopper (5) to the crankshaft as shown in figure.
4. Heat a new sleeve to a temperature between 150 and 200 °C (302 and 392 °F), and fix the sleeve to the crankshaft as shown in figure.
5. Press fit the sleeve using the auxiliary socket for pushing (3).

NOTE

- Mount the sleeve with its largely chamfered surface facing outward.

(1) Crankshaft Sleeve
(2) Crankshaft
(3) Auxiliary Socket for Pushing

(4) Sleeve Guide
(5) Stopper



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L4200 Operating Manual

Christian Drosten



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