

## 03-3190 Crankshaft machining dimensions and identifications

### Crankshaft machining dimensions and identifications, radial mounting <sup>1)</sup>

Machining stage <sup>2)</sup>	Crankshaft bearing journal Ø	Colored identification on counterweight	Laser lettering on front of crankshaft
Standard	57.960-57.965	blue	B
Standard	57.955-57.960	yellow	G
Standard	57.950-57.955	red	R
Standard 1	57.945-57.950	white	W
Standard 1	57.940-57.945	purple	V
Rep. 1	57.705-57.715	--	--
Rep. 2	57.450-57.465	--	--
Rep. 3	57.205-57.215	--	--
Rep. 4	56.955-56.965	--	--

1) New crankshafts are identified before shipping from the factory with the tolerance classification of the crankshaft bearing journal Ø and fit bearing width either with a colored identification on the counterweights or with laser lettering on the front of the crankshaft journal.

2) Standard size 1 and repair size crankshafts are not supplied as replacement parts except in reconditioned engines.

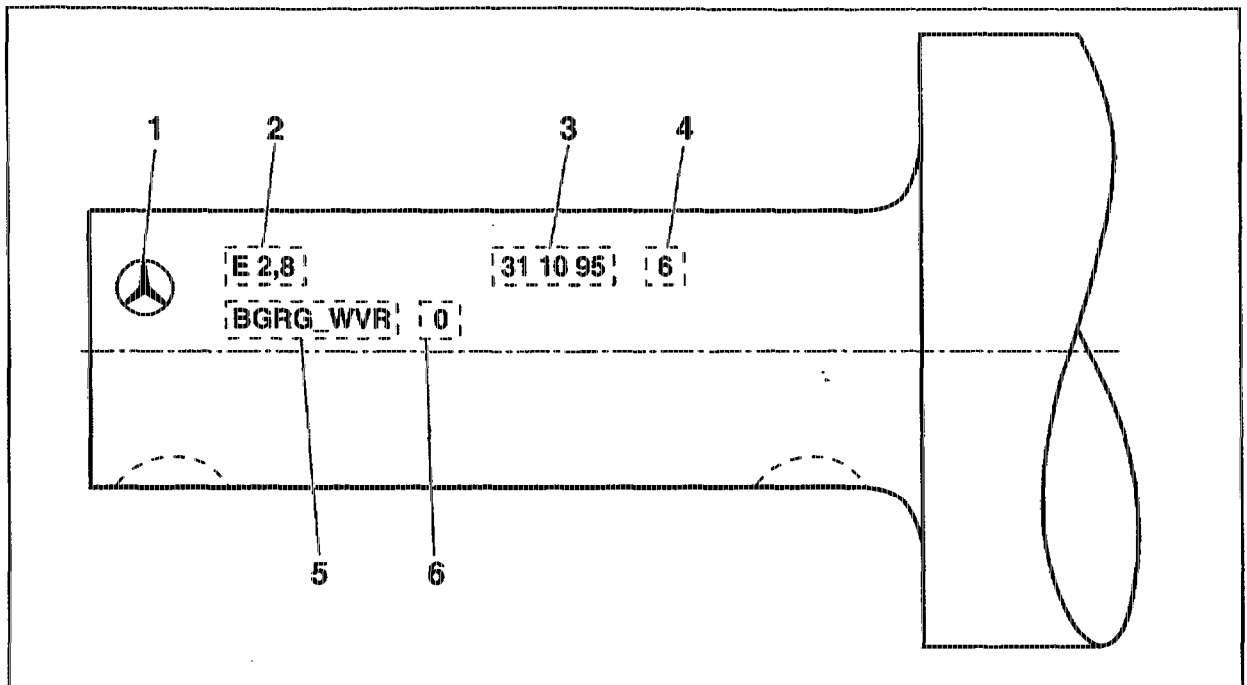
### Crankshaft machining dimensions and identifications, axial mounting <sup>1)</sup>

Machining stage <sup>2)</sup>	Fit bearing width <sup>3)</sup>	Colored identification on counterweight 8 and 9	Laser lettering on front of crankshaft
Standard	24.500-24.533	none	0
Standard	24.500-24.533	none	0
Standard	24.500-24.533	none	0
Standard 1	24.600-24.633	red	1
Standard 2	24.600-24.633	red	1
Rep. 1	24.700-24.733	--	--
Rep. 2	24.900-24.933	--	--
Rep. 3	25.000-25.033	--	--
Rep. 4	--	--	--

1) New crankshafts are identified before shipping from the factory with the tolerance classification of the crankshaft bearing journal Ø and fit bearing width either with a colored identification on the counterweights or with laser lettering on the front of the crankshaft journal.

2) Standard size 1 and repair size crankshafts are not supplied as replacement parts except in reconditioned engines.

3) The thrust washers for axial bearing play are supplied in thicknesses of 2.15, 2.20, 2.25, 2.35 and 2.40 mm, each with a thrust washer for the crankcase and the thrustwasher for the bearing cap as a parts kit (2 in total).



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Laser lettering on front of crankshaft

- |   |                   |   |  |
|---|-------------------|---|--|
| 1 | Company emblem    | 4 | Inspection digit of automatic measuring system |
| 2 | Model designation | 5 | Crankshaft bearing journal $\varnothing$       |
| 3 | Inspection date   | 6 | Fit bearing width                              |