

AR03.10-P-6111-04AW	Aligning connecting rod		
---------------------	-------------------------	--	--

Test data of conrod

Number	Designation	Engine 601.921 USA up to 09/84	Engine 601.921 USA as of 10/84
BE03.10-P-1003-01C	Permissible twist of conrod bearing bore to conrod bush bore over length of 100 mm	mm 0.1	0.1
BE03.10-P-1004-01C	Permissible variation of axial parallelism of conrod bearing bore to conrod bush bore over length of 100 mm	mm 0.045	0.045

Test data of conrod

Number	Designation	Engine 601 except 601.921 USA up to 09/84	Engine 601 except 601.921 USA as of 10/84 Engine 602.91, 603.91
BE03.10-P-1003-01C	Permissible twist of conrod bearing bore to conrod bush bore over length of 100 mm	mm 0.1	0.1
BE03.10-P-1004-01C	Permissible variation of axial parallelism of conrod bearing bore to conrod bush bore over length of 100 mm	mm 0.045	0.045

Nm Connecting rod

Number	Designation	Engine 601, 602 except 602.98, 603 except 603.970 up to 11/90 603.970 up to 8/90	Engine 601, 602 except 602.98, 603 except 603.970 as of 12/90 - 10/92 603.970 as of 9/90 - 10/92	Engine 601, 602 except 602.98, 603 as of 11/92		
BA03.10-P-1001-01C	Conrod bolt (stretch shank)	1st stage	new	Nm -	45	40
			used	Nm -	40	-
		2nd stage		∠ ° -	90	90
		Fig. see		-	AR03.10-P-6111-01AW	AR03.10-P-6111-01AW
BA03.10-P-1002-01C	Conrod bolt (straight stretch shank)	1st stage		Nm 30	-	-
		2nd stage		∠ ° 90	-	-
		Fig. see		AR03.10-P-6111-01AW		

Test data of conrod

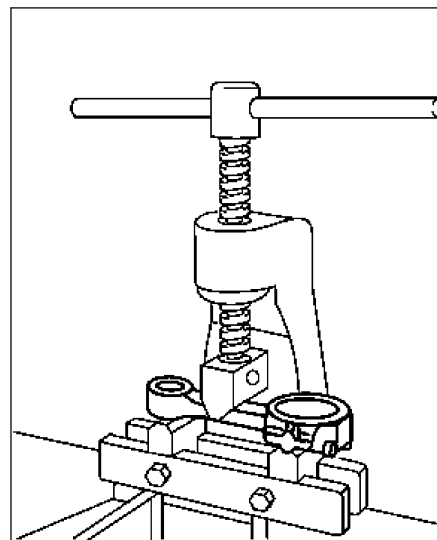
Number	Designation	Engine 602.96, 603.96	Engine 603.97

BE03.10-P-1003-01C	Permissible twist of conrod bearing bore to conrod bush bore over length of 100 mm	mm	0.1	0.1
BE03.10-P-1004-01C	Permissible variation of axial parallelism of conrod bearing bore to conrod bush bore over length of 100 mm	mm	0.045	0.045

Commercially available tools (see Workshop Equipment Manual)

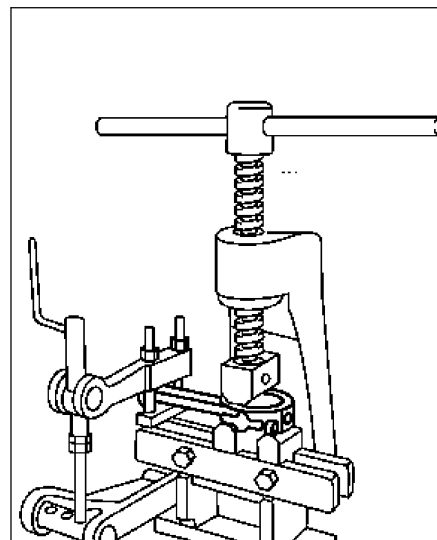
Number	Designation	Make (e.g.)	Order number
WH58.30-Z-1017-05A	Conrod inspection equipment	Modell BC 501 Firma KWT D-63128 Dietzenbach	
WH58.30-Z-1018-05A	Conrod aligning equipment	Modell BC 503 Firma KWT D-63128 Dietzenbach	

- 1 Inspect conrod with conrod inspection equipment with bearing shells and piston pins installed.
- 2 Align conrod bearing bore parallel to conrod bush bore on conrod aligning equipment.



P03.10-0204-02

- 3 Align twist of conrod bearing bore to conrod bush bore on the conrod aligning equipment.



P03.10-0205-02