

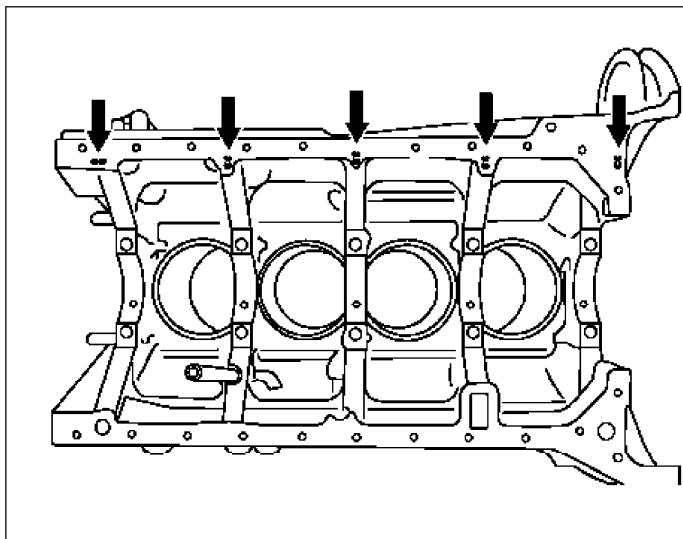
### Assign bearing shells to crankcase

The bearing shells are marked on the side with the colors blue, yellow and red.

Chisel punches are positioned on the bottom contact surface at the crankcase next to the main bearing. The bearing shells should be assigned in accordance with the number of chisel punches.

- 1 chisel punch indicates the blue bearing shell (part code 52)
- 2 chisel punches indicate the yellow bearing shell (part code 54)
- 3 chisel punches indicate the red bearing shell (part code 56)

Shown on engine block 611



P03.20-0276-11

### Assign bearing shells to the crankshaft bearing caps

The bearing shells for the crankshaft bearing caps are identified with the colors blue, yellow, red, white and purple.

- Blue (Part code 52)
- Yellow (Part code 54)
- Red (Part code 56)
- White (Part code 57)
- Purple (Part code 58)

The marking for assigning the bearing shells in the crankshaft bearing caps is indicated on the crankshaft.

The crankshaft is identified as described below.

- A Colored dots (arrows) on crankshaft webs. Insert a bearing of the same color in the bearing cap matching the color of the dot.  
**Example:** Red color dot on crankshaft = red bearing in bearing cap(s).

- B Chisel punches next to main bearings on crankshaft
- = for blue bearing shell
  - = for yellow bearing shell
  - = for red bearing shell
  - = for white bearing shell
  - = for purple bearing shell

Install bearing shell matching the number of chisel punches.

**Example:** Four center punch marks next to the main bearing = white bearing shell.

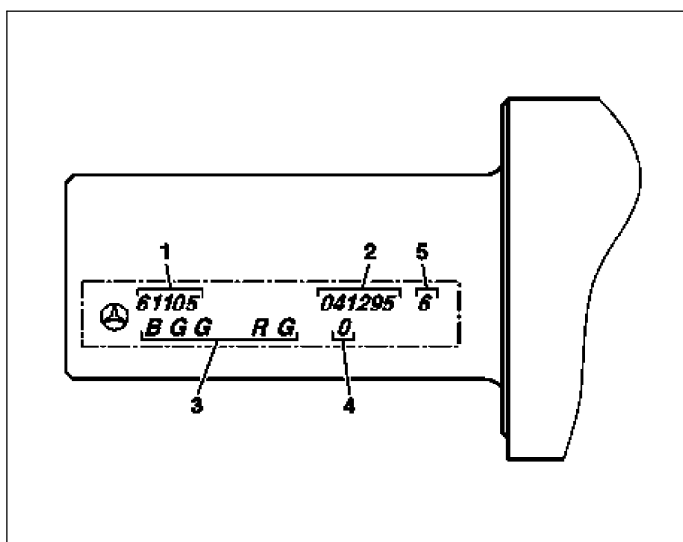
- C Letters on front of crankshaft

Assign bearing shells to match the letters.

**Example:** G=yellow bearing in bearing shell

- 1 Model designation e.g. 61105
- 2 Date of inspection
- 3 Over/undersizes of the 5 main bearing colored markings e.g.: B = blue, G = yellow, R = red
- 4 Fit bearing width e.g.: 0 = standard size, 1 = standard size I
- 5 Inspection digit for automatic measuring machine

Shown on engine 611



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- D Actual dimensions on front of crankshaft (over/undersizes of bearing journals  $58.000 - 0.035 = 57.965$  actual size)

- Actual dimension 35 - 39 = bearing shell blue
- Actual dimension 40 - 44 = bearing shell yellow
- Actual dimension 45 - 49 = bearing shell red
- Actual dimension 50 - 54 = bearing shell white
- Actual dimension 55 - 60 = bearing shell purple

Assign bearing shells to match the actual dimensions.

**Example:** Actual size 47 = red bearing shell in bearing cap.

