

Crankshaft test data

Number	Designation		Engine 601.943	Engine 602.980/982/983/984/985	
BE03.20-N-1001-02D	Crankshaft bearing journal \varnothing	Standard size	mm	57.950...57.965	57.950...57.965
		1st repair size	mm	57.700...57.715	57.700...57.715
		2nd repair size	mm	57.450...57.465	57.450...57.465
		3rd repair size	mm	57.200...57.215	57.200...57.215
		4th repair size	mm	56.950...56.965	56.950...56.965
BE03.20-N-1002-02D	Connecting rod journal \varnothing	Standard size	mm	47.950...47.965	47.950...47.965
		1st repair size	mm	47.700...47.715	47.700...47.715
		2nd repair size	mm	47.450...47.465	47.450...47.465
		3rd repair size	mm	47.200...47.215	47.200...47.215
		4th repair size	mm	46.950...46.964	46.950...46.965
BE03.20-N-1003-02D	Fitted bearing journal width	Standard size	mm	24.500...24.533	24.500...24.533
			mm	24.600...24.633	24.600...24.633
		1st repair size	mm	24.700...24.733	24.700...24.733
		2nd repair size	mm	24.900...24.933	24.900...24.933
		3rd repair size	mm	25.000...25.033	25.000...25.033
BE03.20-N-1004-02D	Permissible out-of-roundness of crankshaft and connecting rod journals		mm	-	0.005
BE03.20-N-1005-02D	Permissible conicity of crankshaft and connecting rod journals		mm	-	0.01
BE03.20-N-1006-02D	Permissible peak-to-valley height of crankshaft and connecting rod journals (Ra)		mm	-	0.005...0.015
BE03.20-N-1007-02D	Permissible concentricity deviation of flywheel flange		mm	-	0.02
BE03.20-N-1008-02D	Permissible planning deviation of fitted bearing		mm	-	0.02
BE03.20-N-1009-02D	Fillet radii	Crankshaft bearing journals	mm	-	2.5...3.0
		Connecting rod journal	mm	-	3.0...3.5
BE03.20-N-1010-02D	Permissible concentricity deviation of crankshaft bearing journals on contact in the outer crankshaft bearing journals	Journal 2, 4	mm	-	0.16
		Journal 3	mm	-	0.25
BE03.20-N-1011-02D	Scleroscopic hardness of crankshaft and connecting rod journals		HRB	-	55...74
BE03.20-N-1012-02D	Permissible imbalance of crankshaft		cmg	-	10

Crankshaft test data

Number	Designation		Engine 602.981	
BE03.20-N-1001-02D	Crankshaft bearing journal \varnothing	Standard size	mm	57.950...57.965
		1st repair size	mm	57.700...57.715
		2nd repair size	mm	57.450...57.465
		3rd repair size	mm	57.200...57.215
		4th repair size	mm	56.950...56.965

BE03.20-N-1002-02D	Connecting rod journal \varnothing	Standard size	mm	47.950...47.965
		1st repair size	mm	47.700...47.715
		2nd repair size	mm	47.450...47.465
		3rd repair size	mm	47.200...47.215
		4th repair size	mm	46.950...46.964
BE03.20-N-1003-02D	Fitted bearing journal width	Standard size	mm	24.500...24.533
			mm	24.600...24.633
		1st repair size	mm	24.700...24.733
		2nd repair size	mm	24.900...24.933
		3rd repair size	mm	25.000...25.033
BE03.20-N-1004-02D	Permissible out-of-roundness of crankshaft and connecting rod journals		mm	-
BE03.20-N-1005-02D	Permissible conicity of crankshaft and connecting rod journals		mm	-
BE03.20-N-1006-02D	Permissible peak-to-valley height of crankshaft and connecting rod journals (Ra)		mm	-
BE03.20-N-1007-02D	Permissible concentricity deviation of flywheel flange		mm	-
BE03.20-N-1008-02D	Permissible planning deviation of fitted bearing		mm	-
BE03.20-N-1009-02D	Fillet radii	Crankshaft bearing journals	mm	-
		Connecting rod journal	mm	-
BE03.20-N-1010-02D	Permissible concentricity deviation of crankshaft bearing journals on contact in the outer crankshaft bearing journals	Journal 2, 4	mm	-
		Journal 3	mm	-
BE03.20-N-1011-02D	Scleroscopic hardness of crankshaft and connecting rod journals		HRB	-
BE03.20-N-1012-02D	Permissible imbalance of crankshaft		cmg	-