

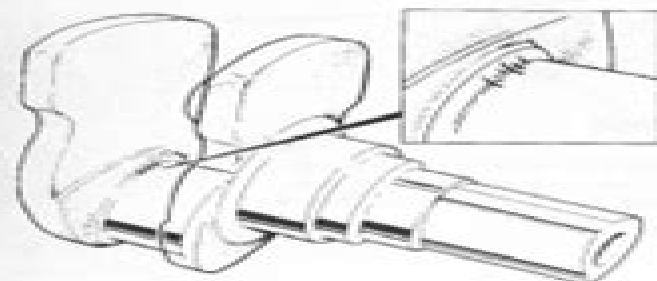
B. Checking for cracks

Checking must be carried out after alignment and before and after grinding.

To check, use a magnetic powder test, for example Magnaglo, i.e. fluorescent powder which can be seen under ultra-violet light.

Refer to manufacturer's instructions on the method to be adopted. When assessing the cracks, the following applies:

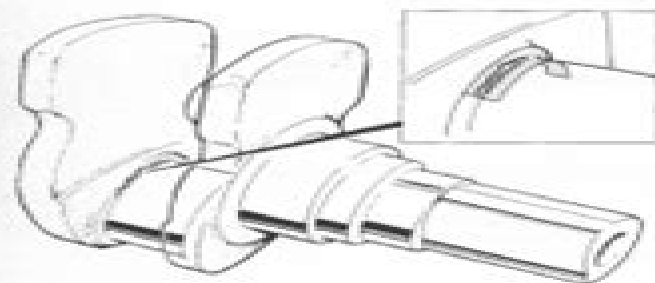
1



TOLERANCE

The shaft must be scrapped if there are longitudinal cracks on the journals and in the fillets.

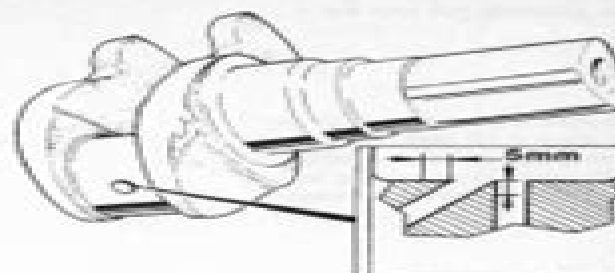
2



TOLERANCE

The shaft must be scrapped if there are crosswise cracks within the marked zone. This applies to both big-end and main bearing journals.

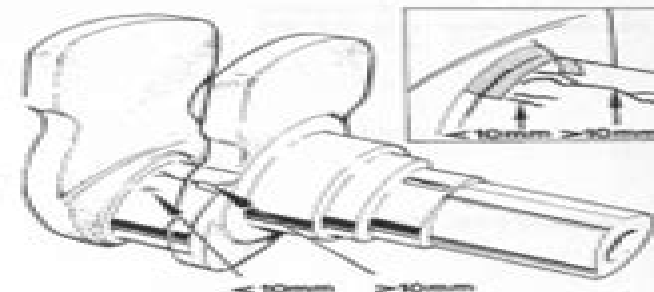
3



TOLERANCE

The shaft must be scrapped when cracks longer than 5 mm are adjacent to the area around the oil holes. Cracks shorter than 5 mm can be removed by grinding.

4



< 10mm > 10mm

TOLERANCE

The shaft must be scrapped when cracks are longer than 10 mm outside the marked area. Isolated cracks less than 10 mm are acceptable.

Overhauling

When overhauling, keep to the following routines:

1

Inspection according to points A - D

2

Grinding to undersize according to the specifications.

When grinding, it is important that the fillet radii are within the specified tolerances.

Note: When grinding the middle main bearing pin, measurement "A" requires special attention, refer to the specifications under "Width, axial bearing journal".

D16a Engine Manual Guide

Rachel Sandford



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