

Limora Zentrallager

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Datenblatt für Rolls Royce und Bentley V8 Zylinderlaufbuchsen, Artikelnummer 501596

Description	Dimension	Permissible worn dimensions	Remarks
Crankcase and cylinders			
Cylinder liner bore grading	S 4.10040 in to 4.10095 in T 4.10095 in to 4.101 50 in X 4.1016 in to 4.1020 in	0.004 in wear	If these measurements are exceeded a new assembly of liner and piston must be fitted
Cylinder liner ,nip'	0.002 in to 0.003 in		New liners must be selectively fitted or ground on the end to give this dimension
Pistons			
Piston grading	S 4.0988 in to 4.0994 in T 4.0994 in to 4.0999 in X 4.0999 in to 4.1006 in		Pistons measured between 2.480 in and 1.338 in from the top of the piston across the thrust axis
Compression ring groove widths	0.0799 in to 0.0809 in		The rings should be assembled with staggered gaps
Compression ring widths	0.0777 in to 0.0783 in		
Clearance	0.0016 in to 0.0032 in	0.005 in	
Compression rings closed gap	0.015 in to 0.025 in		
Oil control ring groove width	0.1575 into 0.1585 in		
Oil control ring closed gap	0.0149 in to 0.0448 in		
Crankshaft and connecting rods			
Connecting rod small-end bush internal diameter	1.0004 in to 1.0006 in		
Gudgeon pin clearance in small-end bush	0.0001 in to 0.0005 in		At room temperature, 20°C to 22°C (68°F to 72°F)
Big-end bearing housing, internal diameter	2.395 in to 2.3955 in		This diameter should be checked with the big-end bolts in position and the nuts torque tightened to 47,08 Nm (4,8 kgf m; 35 lbf ft)
Big-end bearing shell, internal diameter	2.2505 in to 2.2515 in		
Crankpin diameter	2.2485 in to 2.249 in	2.2475 in	
Clearance	0.0015 in to 0.003 in	0.004 in	Clearance measured vertically
Small-end bush housing in internal diameter	1.140 in to 1.1405		
Connecting rod twist	Maximum of 0.003 inch per inch in length		
Connecting rod vertical alignment	Maximum of 0.001 inch per inch in length		
Connecting rod and cap bolt holes diameter for location	0.375 in to 0.3755 in		On location diameter
Connecting rod bolt diameter for location	0.3745 in to 0.375 in		On location diameter
Clearance	Size to 0.001 in		

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Connecting rod bolt interference on knurled diameter	0.0032 in to 0.0072 in		Bolts should not be removed from rods unless they are to be renewed
Connecting rod end-float	0.008 in to 0.017 in		Controlled by clearance between rods and crankpin end faces
Main bearing diametral clearance	0.0015 in to 0.0030 in	0.0035 in	
Crankshaft end-float	0.004 in to 0.010 in	0.012 in	
Connecting rod bolt stretch			Refer to Section E6
Crankshaft bow		0.01 in	Regrind crankshaft if this figure is exceeded
Crankshaft journals and crankpins		0.001 in	Regrind crankshaft if this figure is exceeded
Gudgeon pins			
Bore diameter in piston	Green 1.0003 in to 1.0004 in		Colour code marked on the underside of the piston boss
	Red 1.0004 in to 1.0005 in		
Gudgeon pin diameter	Green 1.0001 in to 1.0002 in		Colour code marked on the end of the gudgeon pin
	Red 1.0002 in to 1.0003 in		
Clearance in boss	0.0001 in to 0.0003 in		