

MAIN BEARING and CRANKSHAFT DIMENSIONS
for Engines Type 1600 C (616/15) and 1600 SC (616/16)

MAIN BEARINGS

Nomenclature	Version		Bearing 2 to 3 (in mm)	Bearing 1 (in mm)
Crankshaft Journal	Standard	Diameter	54,990 - 54,971	49,991 - 49,975
Bearing Insert	Inside standard	Wall thickness	2,615 - 2,603	5,096 - 5,108
	Outside standard	Outside dia.	-	60,29 + 0,02
Crankcase Bore	Standard	Diameter	60,24 ± 0,005	60,24 ± 0,005
Crankshaft Journal	Standard	Diameter	54,990 - 54,971	49,991 - 49,975
Bearing Insert	Inside standard	Wall thickness	2,740 - 2,728	5,221 - 5,233
	Outside oversize	Outside dia.	-	60,54 + 0,02
Crankcase Bore	Oversize	Diameter	60,49 ± 0,005	60,49 ± 0,005
Crankshaft Journal	1st undersize	Diameter	54,740 - 54,721	49,741 - 49,725
Bearing Insert	Inside undersize	Wall thickness	2,740 - 2,728	5,221 - 5,233
	Outside standard	Outside dia.	-	60,29 + 0,02
Crankcase Bore	Standard	Diameter	60,24 ± 0,005	60,24 ± 0,005
Crankshaft Journal	1st undersize	Diameter	54,740 - 54,721	49,741 - 49,725
Bearing Insert	Inside undersize	Wall thickness	2,865 - 2,853	5,346 - 5,358
	Outside oversize	Outside dia.	-	60,54 + 0,02
Crankcase	Oversize	Diameter	60,49 ± 0,005	60,49 ± 0,005
Crankshaft Journal	2nd undersize	Diameter	54,490 - 54,471	49,491 - 49,475
Bearing Insert	Inside undersize	Wall thickness	2,865 - 2,853	5,346 - 5,358
	Outside standard	Outside dia.	-	60,29 + 0,02
Crankcase Bore	Standard	Diameter	60,24 ± 0,005	60,24 ± 0,005
Crankshaft Journal	2nd undersize	Diameter	54,490 - 54,471	49,491 - 49,475
Bearing Insert	Inside undersize	Wall thickness	2,990 - 2,978	5,471 - 5,483
	Outside oversize	Outside dia.	-	60,54 + 0,02
Crankcase Bore	Oversize	Diameter	60,49 ± 0,005	60,49 ± 0,005

Nomenclature	Version		Bearing 2 to 3 (in mm)	Bearing 1 (in mm)
Crankshaft Journal	3rd undersize	Diameter	54,240 - 54,221	49,241 - 49,225
Bearing Insert	Inside undersize	Wall thickness	2,990 - 2,978	5,471 - 5,483
	Outside standard	Outside dia.	-	60,29 + 0,02
Crankcase Bore	Standard	Diameter	60,24 \pm 0,005	60,24 \pm 0,005
Crankshaft Journal	3rd undersize	Diameter	54,240 - 54,221	49,241 - 49,225
Bearing Insert	Inside undersize	Wall thickness	3,115 - 3,103	
	Outside oversize	Outside dia.	-	60,54 + 0,02
Crankcase Bore	Oversize	Diameter	60,49 \pm 0,005	60,49 \pm 0,005

Dimensions of crankshaft journals and bearing inserts for main bearing 4, as well as crank pin journals and bearing inserts for connecting rods are the same as for engines Type 1600 (616/1), 1600 S (616/12), and 1600 S-90 (616/7).

Crankshafts for engines Type 1600 C and 1600 SC can be reconditioned or exchanged only at the factory since these must be subjected to a special metal treatment.

The respective undersize bearings are to be ordered as spare parts whereby it must first be established if the main bearing seats in the crankcase are standard or oversize.

Measuring point for establishing thickness of bearing inserts

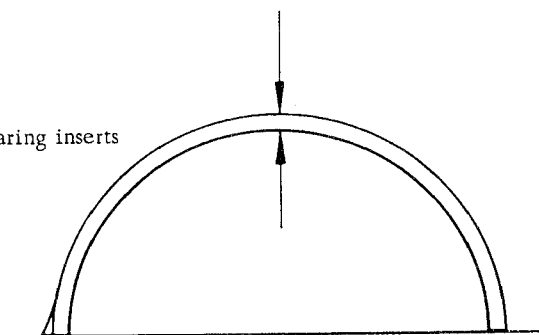


Fig. 8