

# CONNECTING ROD (RECONDITIONED)

MAKER	YANMAR	ENGINE MODEL	M200L
DESCRIPTION	CONNECTING ROD (RECONDITIONED)	PARTS NO.	741616-23010-C
INSPECTION NO.	2L16-2		

ANGLE 49 N.m 100°

REMARKS

Work Details

1. Magnaflux test
2. Machining of conrod cap
3. Reconditioning of serrated surface
4. Regrinding of big end housing

Limit of use big end housing  
**Mini -2 Max +6 Roundness 5**

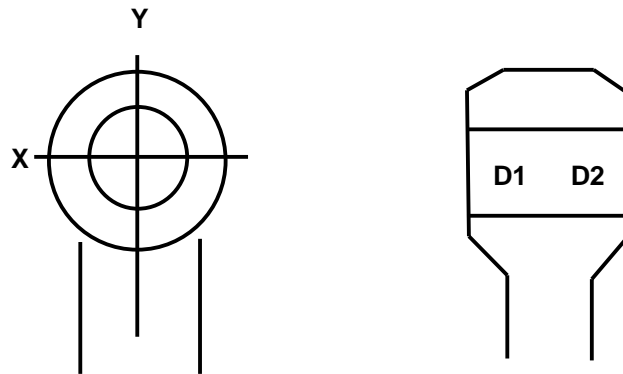
Limit of use small end housing  
**Max +18**

(UNIT : 1/100)

- \* Renewed crank pin bolt.
- \* Renewed Piston Pin Metal
- \* Apply protechgrase to the bearing surface of the rod bolt.

2L16-2 (92-11)	Nominal Dimension 160 0 ~ + 2.5						Nominal Dimension 160 0 ~ + 2.5					Dimension	
	Before Recondition Temp 26.1						After Recondition Temp 25.5					82 + 8 ~ + 10	
	A	B	C	D	E	Magnaflux	A	B	C	D	E	X	Y
D1	-0.5	4.5	3.6	-5.0	-6.0	OK	+1.9	+2.3	+1.8	+1.5	+2.0	+8.7	+8.8
D2	-2.0	3.9	3.8	-7.0	8.0		+1.7	+1.6	+2.4	+1.7	+1.8	+8.6	+8.8

\* BORE GAUGE, No. 03917, No. 01823 DIAL GAUGE, No. AQN307, No. AGB668 TORQUE WRENCH, No, 16437G.



\* Renewed Piston Pin Metal. No. 8-2 Boss 0.5mm Over Size Machined up.

UNIT 1/100 mm  
Temp 25.3

2L16-2 (92-11)	Before Recondition		Out of Metal		Repaired to Boss		Renewed to Metal		After Recondition	
	82	+8 ~ +10	88	0 ~ +2.2	88	0 ~ +2.2	82	+8 ~ +10	82	+8 ~ +10
	X	Y	X	Y	X	Y	X	Y	X	Y
D1	9.7	+17.7	+1.1	+1.2	+1.2	+1.3	-33.3	-37.5	+8.7	+8.8
D2	9.8	+17.5	+1.3	+1.3	+1.3	+1.4	-34.5	-36.8	+8.6	+8.8



INSPECTION No. 2L16-

