

CONNECTING ROD (RECONDITIONED)

MAKER	YANMAR	ENGINE MODEL	M200L
DESCRIPTION	CONNECTING ROD (RECONDITIONED)	PARTS NO.	741616-23010-C
INSPECTION NO.	3A18-10		

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

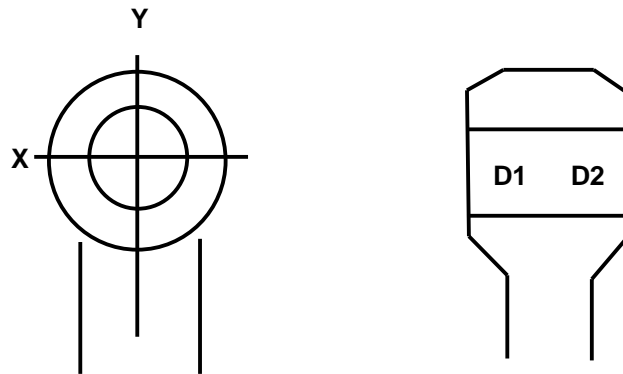
Limit of use small end housing
Max +18

(UNIT : 1/100)

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

3A18-10 (92-12)	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	-3.2	+6.0	+5.0	-7.0	-8.3	OK	+0.8	+0.7	+0.9	+0.8	+0.8	+8.3	+8.6
D2	-2.4	+3.3	+5.2	-8.3	-8.2		+0.8	+0.8	+0.9	+0.8	+0.8	+8.2	+8.5

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



* Renewed Piston Pin Metal. No. 3A18-10 Boss 0.5mm Over Size Machined up.

UNIT 1/100 mm
Temp 25.3

3A18-10 (92-12)	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	9.6	+17.0	+2.3	+5.1	+0.1	+0.1	-45.0	-46.0	+8.3	+8.6
D2	9.6	+1.8	+3.2	+5.3	+0.1	+0.2	-44.0	-46.3	+8.2	+8.5



INSPECTION No. 3A18-10



