

# CONNECTING ROD (RECONDITIONED)

MAKER	YANMAR	ENGINE MODEL	M200L
DESCRIPTION	CONNECTING ROD without Crankpin Metal	PARTS NO.	741616-23010-C
INSPECTION NO.	8-2		

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**

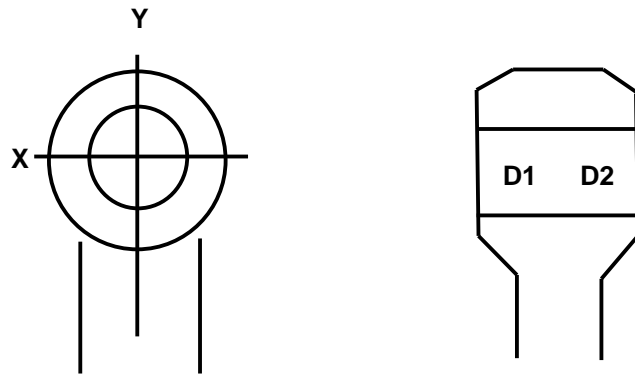
Limit of use small end housing  
**Max +18**

(UNIT : 1/100)

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

8-2 (84-12)	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	-4.4	+1.7	+1.4	-3.9	-7.5	OK	+1.4	+1.2	+1.1	+1.8	+1.5	+8.0	+8.2
D2	-4.4	-2.7	+1.0	-8.3	-6.0		+1.6	+1.0	+1.1	+1.5	+1.9	+8.0	+8.2

\* 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

8-2 (84-12)	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	+9.7	+24.6	+0.5	+4.5	+0.1	+0.2	-38.5	-43.7	+8.0	+8.2
D2	+10.8	+25.9	+0.3	+6.5	+0.1	+0.1	-38.3	-44.0	+8.0	+8.2



INSPECTION No. 8-2



