

CONNECTING ROD (RECONDITIONED)

MAKER	YANMAR	ENGINE MODEL	M200L
DESCRIPTION	CONNECTING ROD (RECONDITIONED)	PARTS NO.	741616-23010-C
INSPECTION NO.	8-5		

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

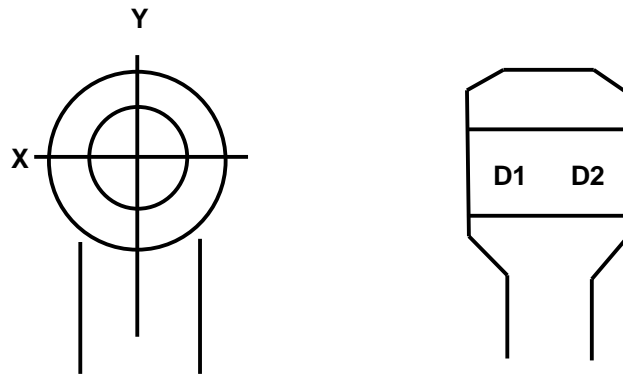
Limit of use small end housing
Max +18

(UNIT : 1/100)

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

8-5 (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	-2.7	+3.9	+3.9	-4.3	-6.8	OK	+1.5	+1.1	+1.2	+1.3	+1.2	+8.5	+8.6
D2	-1.9	-0.3	+4.5	-5.1	-5.6		+1.2	+0.8	+0.9	+0.8	+0.9	+8.4	+8.5

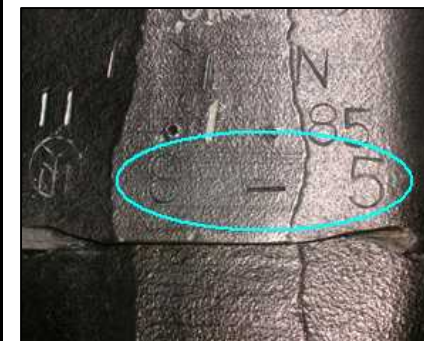
* BORE GAUGE, No. 03917, No. 01823 DIAL GAUGE, No. AQN307, No. AGB668 TORQUE WRENCH, No. 16437G.



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

UNIT 1/100 mm
Temp 25.3

8-5 (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	+9.1	+20.1	-3.0	-1.8	+0.5	+0.5	-37.8	-39.7	+8.5	+8.5
D2	+10.6	+20.2	-1.0	-1.5	+0.5	+0.6	-38.6	-40.0	+8.4	+8.5



INSPECTION No. 8-5

