

# Fitting Connecting Rods with Bearing on Crankshaft

Types 220 and 220a

Operation No.
M 4k

## Special Tools:

Torque wrench 0 to 6 mkg  
(0 to 43.5 ft.lb.)

000 589 27 21

If necessary, adapt cap by tapping with a plastic hammer.

## Procedure:

**Note:** For fitting the connecting rods with inserted bearing shells on the crankshaft refer to Operation No. M 4g.

1. Bolt bearing cap to connecting rod. Tighten connecting rod bolts to an expansion of 0.1 mm (0.004"). See Operation No. M 3, cf. 55.
2. Check diameter of basic bore as indicated in Fig. M 4g/00. The diameter must be between 54.000 and 54.019 mm (2.12598 and 2.12673").
3. Unscrew cap and insert bearing shells after cleaning shells and connecting rod carefully. Return cap and tighten.
4. Check bore with bearing shells installed. The standard size is 47.99–48.02 mm (1.8894–1.8976"). Undersizes I to IV are smaller by 0.25 mm (0.0098") each.
5. Regrind connecting rod bearing journals of crankshaft according to the checked bore and making provision for the specified play (see Table 7).