



Install crankshaft

- Insert main bearing shells in the crankcase.



Note

- Note the assignment of the bearing shell.
- The bolt protection (1) must engage in the groove (2).



- Insert main bearing shell in the appropriate main bearing cover.



Note

- Note the assignment of the main bearing cover.
- The bolt protection (1) must engage in the groove (2).



- Insert con rod bearing shell in the con rod.



Note

- Note the assignment of the bearing shell.
- The bolt protection (1) must engage in the groove (2).



- Insert con rod bearing shell in the appropriate con rod bearing cover.

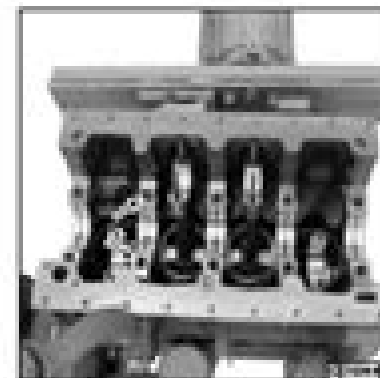


Note

- Note the assignment of the bearing shell.
- The bolt protection (1) must engage in the groove (2).



- Check all clamping bushes are in place (checked).



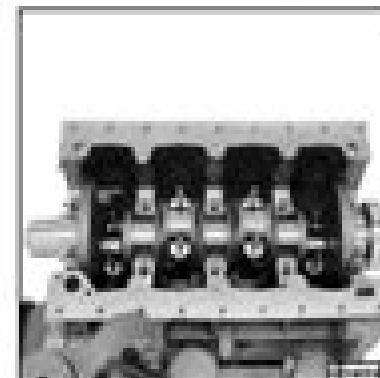
- Oil all bearing surfaces on the bearing oil and bearing shells lightly.

- Insert the crankshaft carefully in the crankcase.



Note

- Do not turn the con rods when inserting the crankshaft.



Deutz Bf4m2015 Repair Manual

RD Boyd



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