

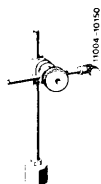
05–225 Grinding camshaft bearing journals

Data

Roughness of camshaft bearing journals		0.003	
Perm. runout of center bearing journal and camshaft sprocket seat when mounting camshaft at outer bearing journal		0.0125	
Bearing points (Fig.)		a	b and c
Normal dimension	camshaft bearing dia.	$\frac{35.00}{35.02}$	$\frac{49.00}{49.02}$
	journal dia.	$\frac{34.95}{34.93}$	$\frac{48.95}{48.93}$
Intermediate stage	camshaft bearing dia. (color coding grey)	$\frac{34.90}{34.92}$	$\frac{48.90}{48.92}$
	journal dia.	$\frac{34.85}{34.83}$	$\frac{48.85}{48.83}$
Repair stage I	camshaft bearing dia. (color coding red)	$\frac{34.75}{34.77}$	$\frac{48.75}{48.77}$
	journal dia.	$\frac{34.70}{34.68}$	$\frac{48.70}{48.68}$
Width A of journal a (Fig.)		$\frac{34.00}{34.04}$	
Bearing play	radial	0.050–0.084	
	axial	0.07–0.15	

Special tool

Dial gauge holder for end play of camshaft (2 each)



363 589 00 02 00

Conventional tool

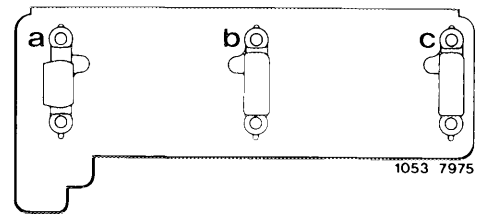
Dial gauge A 1 DIN 878

e.g. made by Mahr, D–7300 Esslingen
order No. 810

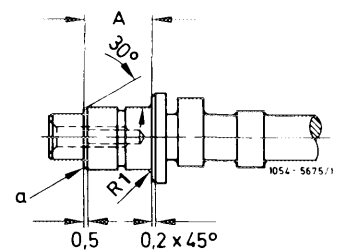
Note

In the event of repairs, regrind camshaft in accordance with available camshaft bearings.

The camshaft bearing journals are not hardened.

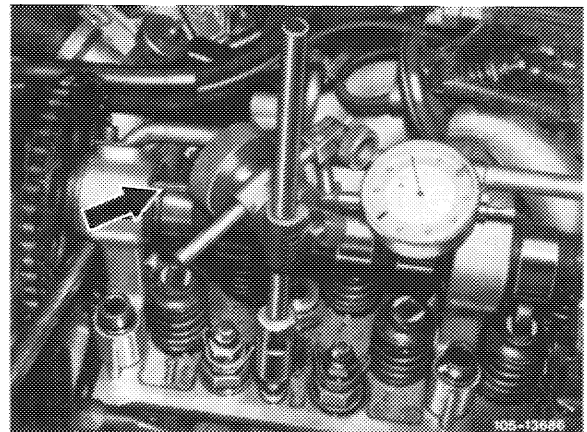


If dimension A is exceeded when grinding 1st bearing journal, also regrind face a.



Measuring end play

- 1 Screw-on dial gauge holder with threaded sleeve at front left.
- 2 Position dial gauge at approx. 3 mm preload against thrust flange of camshaft (arrow).
- 3 Push camshaft toward the rear and set large needle to zero.



- 4 Push camshaft forward and determine end play.

Note: If the end play is too low, touch up 1st camshaft bearing at its face surfaces (arrow).

If the end play is too high, regrind face a on camshaft.

