

**05—225 Grinding camshaft bearing journals**

**Data**

Average roughness (Rz) of camshaft bearing journals		0.005		
Permissible radial runout of camshaft bearing journals b and c and of camshaft sprocket seat when mounting camshaft in bearing journal a and rear bearing journal c		0.025		
Permissible radial runout of camshaft base circle when mounting camshaft in bearing journal a and rear bearing journal c		0.03		
Bearing points (Fig.)		a	b	c
Standard dimension	Bearing dia.	<u>35.000</u> 35.016	<u>49.200</u> 49.216	<u>49.400</u> 49.416
	Journal dia.	<u>34.975</u> 34.959	<u>49.175</u> 49.159	<u>49.375</u> 49.359
Repair stage 1	Bearing dia.	<u>34.900</u> 34.916	<u>49.100</u> 49.116	<u>49.300</u> 49.316
	Journal dia.	<u>34.875</u> 34.859	<u>49.075</u> 49.059	<u>49.275</u> 49.259
Repair stage 2	Bearing dia.	<u>34.750</u> 34.766	<u>48.950</u> 48.966	<u>49.150</u> 49.166
	Journal dia.	<u>34.725</u> 34.709	<u>48.925</u> 48.909	<u>49.125</u> 49.109
Fitted bearing	Bearing bracket width	<u>25.430</u> 25.390		
	Journal width B	<u>25.500</u> 25.533		
Camshaft bearing play	radial	0.025—0.057	0.025—0.057	0.025—0.057
	axial	0.070—0.143		

**Note**

When regrinding thrust face of bearing journal „a“, grind face „S“ always so that the journal width „B“ and consequently the axial play (end play) is maintained.

Bearing journals are not hardened.

Suitable repair stage camshaft bearings are available for ground camshaft bearing journals.

