

MARCH, 1957.



SERVICE SHEET

NO: 35.

'A' GROUP - UNDERSIZE CRANKSHAFT BUSH.

To enable the crankshaft bush, Part No: 67-653 (.010" undersize), to be line reamed, a new Service Tool is available. This consists of a reamer, Part No: 61-3547, 1.3668"/1.3648" diameter, which must be used in conjunction with a hardened steel guide bush, Part No: 61-3546.

This bush is designed to replace the original bush in the jig plates, Part Nos: 61-3275 and 61-3281. The internal diameter of both bushes is the same, the difference being in the length, so that the standard size reamer, Part No: 61-3284, can also be used with the new bush. It is important that the bush is accurately fitted to the jig plate.

The undersize reamer has a plain portion, .010" larger than the cutting portion, to act as a guide and will fit the holder, Part No: 61-3287, with pilots Part Nos: 61-3285 or 61-3286.

Ensure that when the crankshaft has been ground .010" undersize, the side face of the crank web is stamped - .010". See Service Sheet No: 207.

NOTE:

For Engines with numbers XA7-101 to XA7-600, use undersize Mainshaft Bush, Part No: 67-652.