

05—225 Grinding camshaft bearing journals

Data

Mean roughness of camshaft bearing journals		0.005		
Permissible radial runout of camshaft bearing journals b and c and of camshaft sprocket seat when mounting camshaft at bearing journal a and rear bearing journal c		0.025		
Permissible radial runout of cam base circle when mounting camshaft at bearing journal a and rear bearing journal c		0.03		
Bearing points (Fig.)		a	b	c
Normal dimension	bearing dia	<u>35.000</u>	<u>49.200</u>	<u>49.400</u>
		35.016	49.216	49.416
	journal dia	<u>34.975</u>	<u>49.175</u>	<u>49.375</u>
		34.959	49.159	49.359
Repair stage 1	bearing dia	<u>34.900</u>	<u>49.100</u>	<u>49.300</u>
		34.916	49.116	49.316
	journal dia	<u>34.875</u>	<u>49.075</u>	<u>49.275</u>
		34.859	49.059	49.259
Repair stage 2	bearing dia	<u>34.750</u>	<u>48.950</u>	<u>49.150</u>
		34.766	48.996	49.166
	journal dia	<u>34.725</u>	<u>48.925</u>	<u>49.125</u>
		34.709	48.909	49.109
Thrust bearing	width of bearing bracket	<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 grinding thrust surface of bearing journal "a" always regrind face "S" to the extent that the journal width "B" and thereby the end play will be maintained.

Bearing journals are not hardened.

Camshaft bearing journals can be ground; for this purpose, camshaft bearings with repair stages are available.

