

MAINTENANCE OPERATION No. 4

TIGHTENING BIG END BOLTS

There are as many ways of tightening these bolts as there are mechanics actually carrying out the work. In order to obviate these varying degrees of tightness the operator should observe the following :

First check the overall length of the bolts with a micrometer or vernier gauge before fitting and note the measurements. Assemble the connecting rod to the crankshaft journal, fit the bolts and self-locking nuts and commence to tighten. Continue to tighten until the bolts have been elongated .008" (.2032 m/m) and when this stage is reached the correct tension has been applied.

BOLT MATERIAL—NICKEL CHROME STEEL 75 to 85 TON

