

Grinding of Camshaft

Change: Section B on page 05-38/2 and 3

Job No.

05-38

A. OM 636

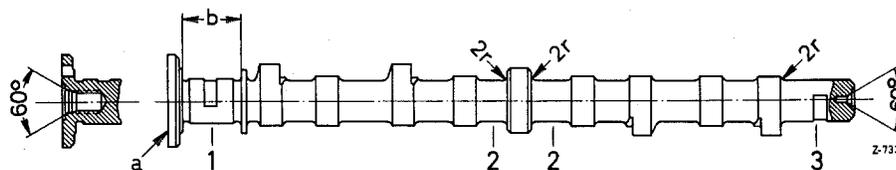


Figure 05-38/1

Camshaft OM 636

- 1 Journal of the 1st camshaft bearing (lapped bearing)
- 2 Journal of the 2nd camshaft bearing (center)
- 3 Journal of the 3rd camshaft bearing
- a Contact surface on flange of camshaft timing gear
- b Thrust surfaces for the 1st camshaft bearing (lapped bearing)

The camshaft bearing pins can once be re-ground to the specified repair size and the respective bearings with smaller bores be supplied ready for installation (see the following table and Job No. 05-39).

Diameters of the Camshaft Journals 1, 2 and 3.

Standard size	27.960 to 27.939 mm
Repair size	27.710 to 27.689 mm

The true running of the camshaft must be checked before the grinding operation. If the camshaft is pivoted at the journals (1) and (3) the eccentricity of the center journal (2) must not be more than 0.025 mm. If this eccentricity is exceeded, the camshaft must be realigned. During this operation carefully deflect the camshaft by **applying pressure, do not hammer**. The camshaft is a casting and can therefore break easily during the aligning operation (see Figure 05-38/1).

After the camshaft has been realigned check the center in the front and rear end and if necessary recondition on centering grinder or lathe. The machining of the center is done as follows:

1. Clamp the flange of the crankshaft timing gear in jaw chuck; use a protecting ring for this purpose. Align the crankshaft by supporting the journal (3) in the backrest and re-cut the center at an angle of 60 deg (see Figure 05-38/1).
2. Then clamp the journal (3) with a protecting sleeve in the jaw chuck, support the flange of the camshaft timing gear in the brackrest and also re-cut the front center.

The contact surface (a) on the flange of the camshaft timing gear must also be trimmed (machined lightly). The axial deflection of the contact surface (a) should not be more than **0.005 mm**.

In order to obtain the specified radial clearance of the camshaft the bores of the camshaft bearings to be installed must first be measured. By subtracting the bearing clearance determine the tolerance range to which the journals have to be ground. The camshaft bearings must be driven into the base bores of the crankcase, so that the bearing bores can be measured correctly.

Bearing Clearances of Camshaft in mm

Radial	Axial
0.04 to 0.08	0.08 to 0.144

When re-grinding the 1st camshaft journal (1) the thrust surfaces (b) are generally only ground so much that a proper thrust surface is obtained (see Fig. 05-38/1).

The camshaft bearing (lapped bearing) of the 1st camshaft journal, however, is wider by 0.25 mm for the overhaul stage. If the width of the overhaul stage is not reached during the grinding of the 1st camshaft journal, the lapped bearing of the overhaul stage must

be adapted by machining, so that the specified axial clearance for the camshaft of 0.08 to 0.144 mm will be obtained.

After the grinding of the camshaft journals check the camshaft for cracks and test the hardness of the individual bearing points.

Hardness of Camshaft

	Rockwell hardness Rc	Scleroscope hardness SKL
Bearing journal and cam base	45 to 60	58 to 73
cam lobe	at least 50 to 60	at least 63 to 73

B. OM 621

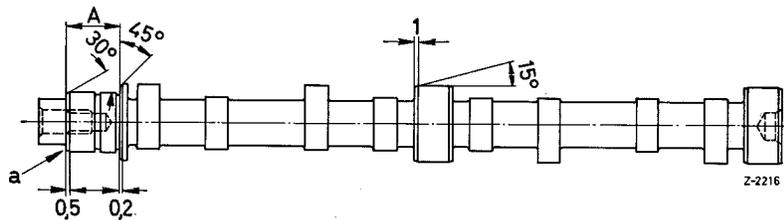


Figure 05-38/2
Camshaft OM 621 for external lubrication
with annular groove on 1st camshaft bearing journal.

The camshaft of the OM 621 is supported in three bearing brackets.

The camshaft bearing pins can once be re-ground to the specified repair size and the respective bearing brackets with smaller bores be supplied ready for installation (see the following table and Job No. 05-39, Section B, item 2).

Table of diameters for the camshaft bearing pins

Camshaft with identification No.	Camshaft bearing pin for	1st bearing (opposite flywheel side)	2nd bearing	3rd bearing (flywheel side)
01	Standard size	34.975 34.959	44.975 44.959	45.975 45.959
	Intermediate size	34.875 34.859	44.875 44.859	45.875 45.859
	Repair size I	34.725 34.709	44.725 44.709	45.725 45.709
02	Standard size	34.975 34.959	45.975 45.959	
	Intermediate size	34.875 34.859	45.875 45.859	
12 ¹⁾	Standard size	34.975 34.959	46.475 46.459	
	Intermediate size	34.875 34.859	46.375 46.359	
	Repair size I	34.725 34.709	46.225 46.209	

¹⁾ Solid shaft for external lubrication of camshaft.