

SIZES

PART #	CYL	STROKE	RODS	FRONT MAINS	REAR MAIN	SEAL OR NECK
TRANE						
CSF-1	4		1.750	1.875	1.875	
CSF-2	6		1.750	1.875	1.875	
CSF-3	8		1.750	1.875	1.875	
CSF-4	4		2.375	2.500	2.500	
CSF-5	6		2.375	2.500	2.500	
CSF-6	8		2.375	2.500	2.500	
CSF-13	4		2.750	2.875	2.875	
CSF-12	5		2.750	2.875	2.875	
CSF 80						
CSF-14	6		2.750	2.875	2.875	
CSF 81						
CSF-15	8		2.750	2.875	2.875	
CSF 82						
CSF-16	3		2.000	2.125	2.125	
CSF-17	4		2.000	2.125	2.125	
CSF-18	5		2.000	2.125	2.125	
CSF-19	6		2.000	2.125	2.125	
CSF-20	8		2.000	2.125	2.125	
CSF-23	3		2.000	2.125	2.125	
CSF-24	4		2.000	2.125	2.125	
CSF-25	5		2.000	2.125	2.125	

PART #	CYL	STROKE	RODS	MAINS	SEAL
TRANE / .020					
CSF-23 / .020			1.980 1.979	2.105 2.104	
CSF-24 / .020			1.980 1.979	2.105 2.104	
CSF-25 / .020			1.980 1.979	2.105 2.104	
CSF-26 / .020			1.980 1.979	2.105 2.104	
CSF-27 / .020			1.980 1.979	2.105 2.104	
CSF-36 / .020 CSF 75			1.980 1.979	2.105 2.104	
CSF-41 / .020			1.980 1.979	2.105 2.104	
CSF-42 / .020			1.980 1.979	2.105 2.104	
CSF-46 / .020			1.980 1.979	2.105 2.104	
CSF-28 / .020			2.730 2.729	2.8545 2.8535	
CSF-29 / .020			2.730 2.729	2.8545 2.8535	
CSF-30 / .020			2.730 2.729	2.8545 2.8535	
CSF-31 / .020			2.730 2.729	2.8545 2.8535	
CSF-48 / .020			1.9785 1.9775	2.1035 2.1025	
CSF-49 / .020			1.9785 1.9775	2.1035 2.1025	
CSF-59 / .020 CSF 90			1.9785 1.9775	2.1035 2.1025	
CSF-51 / .020 CSF 91			1.9785 1.9775	2.1035 2.1025	
CSF-56 / .020		SMALL MAIN 56 ONLY 2.1035 / 2.1025			
CSF-57 / .020			2.730	2.8545	
CSF-58 / .020			2.729	2.8535	

56
CSF 92

57

CSF 93

58

CSF 94

SIZES

PART #	CYL	STROKE	RODS	FRONT MAIN	REAR MAIN	SEAL OR NECK
TRANE						
CSF-26	6		2.000	2.125	2.125	
CSF-27	8		2.000	2.125	2.125	
CSF-28 CSF 83	4		2.750	2.875	2.875	
CSF-29 CSF 84	5		2.750	2.875	2.875	
CSF-30 CSF 85	6		2.750	2.875	2.875	
CSF-31 CSF 86	8		2.750	2.875	2.875	
CSF-36	4		2.000	2.125	2.125	
CSF-41	5		2.000	2.125	2.125	
CSF-42	6		2.000	2.125	2.125	
CSF-46	8		2.000	2.125	2.125	
CSF-48	3		1.998	2.123	2.123	
CSF-49	4		1.998	2.123	2.123	
CSF-50	5		1.998	2.123	2.123	
CSF-51 CSF 91 (6339-1)	6		1.998	2.123	2.123	
CSF-55	3		1.998	2.123	2.123	
CSF-59 (6338-1)	4		1.998	2.123	2.123	

G-model Trane C/S's

<u>DYNATECH PART #</u>	<u>SERVICE FIRST PART #</u>	<u>CYLINDER</u>	<u>CASTING ON CRANKSH</u>
TR-300	5057-041-01	4 cyl. Std.	1254 3515
	5057-0308-01	3 cyl.	4803
TR-600	X68406793-01	4 cyl. Truck	6793 1214
TR-700	X68406217-01	4 cyl. Redesign	1217 6217

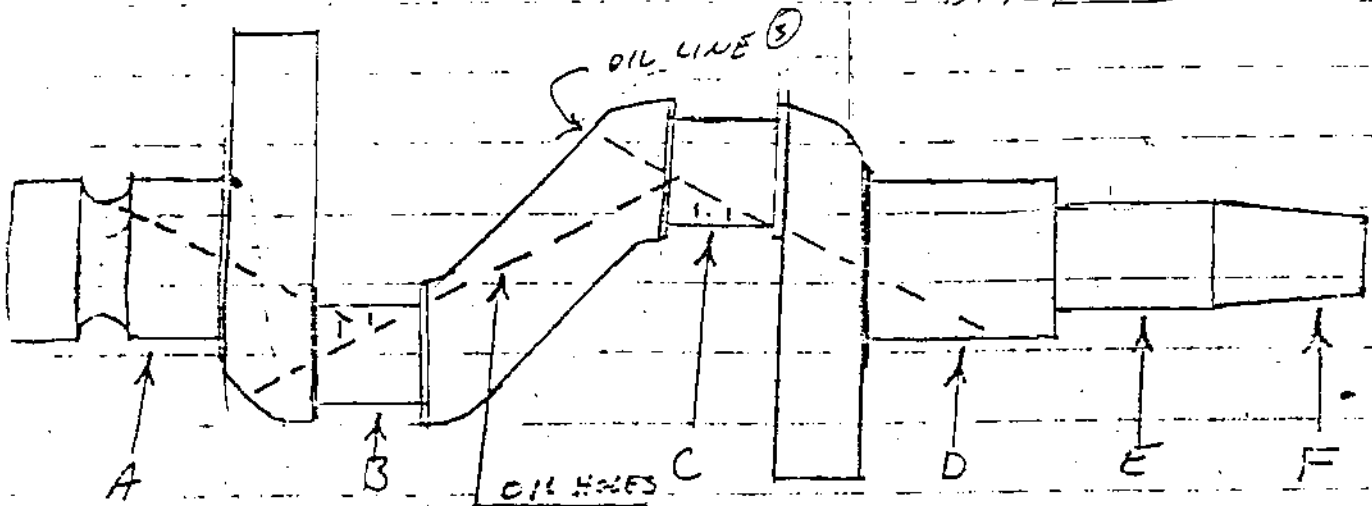
6338

G - MODEL TRANE CRANKSHAFT

<u>Dynatech Part #</u>	<u>CSF #</u>	<u>SERVICE/FIRST PART #</u>	<u>CYLINDER</u>	<u>CASTING # ON CRANKSHAFT</u>
IR-300	CSF 35	5057-0041-01	4 Cyl. Std.	1254
	CSF 39	5057-0308-01 Std. Bearing	3 Cyl.	4803
IR-600		X68406793-01 Roller Bearing Truck	4 Cyl.	6793 1214
IR-700	CSF 61 } same CSF 64 }	X68406217-01 Roller Bearing Bus	4 Cyl. Redesign	1217 6217

TRANE MODEL B $\frac{1}{2}$ CRANKSHAFT (23514)

DATE 12-16-84 NUMBER 155



DIMENSIONS FOR REPAIR

- (A) MAIN BEARING $1.875^{+0.000}_{-0.005} \times 2.190$
 - (B) CRANK PIN $1.750^{+0.000}_{-0.005} \times 1.365^{+0.001}_{-0.000}$
 - (C) CRANK PIN $1.750^{+0.000}_{-0.005} \times 1.365^{+0.001}_{-0.000}$
 - (D) MAIN BEARING $1.875^{+0.000}_{-0.005} \times 2.250$
 - (E) SEAL SEPT $1.5000 \times 2 \frac{1}{2}$
 - (F) COUPLER FIT $1.290/1.500 \times 1 \frac{3}{4}$ (TAPER .125/INCH)
- KEY WAY $3.75 \times .130 \times 1 \frac{5}{8}$

COMMENTS

- 1- CLEAN ALL OIL HOLES AND GROOVES
- 2- RESTORE ABC DEF
- 3- Remove plugs, clean oil lines

CRANKSHAFT REMANUFACTURE STANDARD AND UNDERSIZE

TABLE I

CRANKSHAFT	STD	MAINS	RODS	SHAFT TAPER	SCAL SURFACE	.010 UNDERSIZE	MAINS	RODS	REMARK
A 6.00PM	CSF-4	2.5000 2.4992	2.3151 2.3143	1 5/8" TAPER PER FT.	2.0000 1.999	N.A.	N.A.	N.A.	.108" - .136 Deep x .499 - .501 wide x 1 1/2" Long with 3/4" Radius. Note: A4, A6 and A8 have the same size keyway
A 6.00PM	CSF-5	2.5000 2.4992	2.3151 2.3143	1 5/8" TAPER PER FT.	2.0000 1.999	N.A.	N.A.	N.A.	
A 6.00PM	CSF-6	2.5000 2.4992	2.3151 2.3143	1 5/8" TAPER PER FT.	2.0000 1.999	N.A.	N.A.	N.A.	
B 6.00PM	CSF-1	1.8750 1.8740	1.7300 1.7295	1 5/8" TAPER PER FT.	1.5000 1.4990	N.A.	N.A.	N.A.	.125" - .135 Deep x .374 - .376 wide x 1 1/2" Long with 3/16". Note: B4, B6 and B8 have same size keyway
B 6.00PM	CSF-2	1.8750 1.8745	1.7300 1.7295	1 5/8" TAPER PER FT.	1.5000 1.4990	N.A.	N.A.	N.A.	
B 6.00PM	CSF-3	1.8750 1.8745	1.7300 1.7295	1 5/8" TAPER PER FT.	1.5000 1.4990	N.A.	N.A.	N.A.	
F 6.00PM	CSF-13	2.8745 2.8735	2.7495 2.7485	1 5/8" TAPER PER FT.	2.0000 1.9985	CSF 79	2.8745 2.8735	2.7500 2.7490	.193 Deep x .501 - .503 wide x 1.62 Long with 1.75" Radius. Note: F4, F5, F6 and F8 have same size keyway
F 6.00PM	CSF 17	2.8745 2.8735	2.7495 2.7485	1 5/8" TAPER PER FT.	2.0000 1.9985	CSF 80	2.8745 2.8735	2.7500 2.7490	
F 6.00PM	CSF-14	2.8745 2.8735	2.7495 2.7485	1 5/8" TAPER PER FT.	2.0000 1.9985	CSF 81	2.8745 2.8735	2.7500 2.7490	
F 6.00PM	CSF-15	2.8745 2.8735	2.7495 2.7485	1 5/8" TAPER PER FT.	2.0000 1.9985	CSF 82	2.8745 2.8735	2.7500 2.7490	

NOTES: ALL DIAMETERS LISTED IN THIS TABLE MUST MEET A $\sqrt{16}$ SURFACE FINISH.

TABLE I

ITEM	STD	MAINS	NOHS	SHAFT TAPPER	92AL SURFACE	.020 UNDER SIZE	MAINS	NOHS	KEYWAY
F 1. OPEN	CSF-16	2.1250 2.1240 1.999	2.000 1.999	1 1/4" TAPER PER FT.	1.5000 1.4985	CSF 69	2.1050 2.1040	1.9800 1.9790	.115 - .135 Deep x .374 - .376 wide x 1 1/2" long with 3/16" keyway Note: P3 thru P8 have same size keyway as listed above.
F 2. OPEN	CSF-17	2.1250 2.1240 1.999	2.000 1.999	1 1/4" TAPER PER FT.	1.5000 1.4985	CSF 70	2.1050 2.1040	1.9800 1.9790	
F 5. OPEN	CSF-18	2.1250 2.1240 1.999	2.000 1.999	1 1/4" TAPER PER FT.	1.5000 1.4985	CSF 71	2.1050 2.1040	1.9800 1.9790	
F 6. OPEN	CSF-19	2.1250 2.1240 1.999	2.000 1.999	1 1/4" TAPER PER FT.	1.5000 1.4985	CSF 72	2.1050 2.1040	1.9800 1.9790	
F 8. OPEN	CSF-20	2.1250 2.1240 1.999	2.000 1.999	1 1/4" TAPER PER FT.	1.5000 1.4985	CSF 73	2.1050 2.1040	1.9800 1.9790	

TABLE I

TRANSPIENTS	STD	MAINS	RODS	.020 UNDERSIZE	MAINS	RODS	REMARK	ROTOR MAIN DIAMETER
F 4. HFRM.	CSF 28	$\frac{2.0145}{2.0735}$	$\frac{2.7495}{2.7485}$	CSF 83	$\frac{2.0545}{2.0535}$	$\frac{2.7300}{2.7290}$	.2790 - .2925 Deep x .501 - .503 wide x 1.12" long with 1.75R Maximum.	2.5000/2.4985
F 5. HFRM	CSF 29	$\frac{2.0745}{2.0735}$	$\frac{2.7495}{2.7485}$	CSF 84	$\frac{2.0545}{2.0535}$	$\frac{2.7300}{2.7290}$	Note: E4, E5, and E6 have same size keyway	2.5000/2.4985
F 6. HFRM	CSF 30	$\frac{2.0745}{2.0735}$	$\frac{2.7495}{2.7485}$	CSF 85	$\frac{2.0545}{2.0535}$	$\frac{2.7300}{2.7290}$	.279 - .2925 Deep x .501 - .503 wide x 5.38 long with 1.75R Maximum	2.5000/2.4985
F 8. HFRM	CSF 31	$\frac{2.0745}{2.0735}$	$\frac{2.7495}{2.7485}$	CSF 86	$\frac{2.0545}{2.0535}$	$\frac{2.7300}{2.7290}$		
F A/R 3. HFRM.	CSF 23	$\frac{2.1250}{2.1240}$	$\frac{2.000}{1.999}$	CSF 74	$\frac{2.1050}{2.1040}$	$\frac{1.980}{1.979}$	.1508 - .1543 Deep x .374 - .376 wide x 1 1/2" long with 1 3/4R	1.3748/1.3733
F A/R 6. HFRM.	CSF 24	$\frac{2.1250}{2.1240}$	$\frac{2.000}{1.999}$	CSF 95	$\frac{2.1050}{2.1040}$	$\frac{1.980}{1.979}$	.283 - .2865 Deep x .501 - .503 wide x 1 3/4 long with 1 3/4R	1.8750/1.8735
F A/R 5. HFRM.	CSF 25	$\frac{2.1250}{2.1240}$	$\frac{2.000}{1.999}$	CSF 96	$\frac{2.1050}{2.1040}$	$\frac{1.980}{1.979}$	.2830 - .2870 Deep x .501 - .503 wide x 1 3/4 long with 1 3/4R	1.8750/1.8740
F A/R 6. HFRM.	CSF 26	$\frac{2.1250}{2.1240}$	$\frac{2.000}{1.999}$	CSF 97	$\frac{2.1050}{2.1040}$	$\frac{1.980}{1.979}$	.2830 - .2865 Deep x .501 - .503 wide x 2 1/2" long with 1 3/4R	1.8750/1.8735
F A/B 8. HFRM.	CSF 27	$\frac{2.1250}{2.1240}$	$\frac{2.000}{1.999}$		$\frac{2.1050}{2.1040}$	$\frac{1.980}{1.979}$	.2830 - .2870 Deep x .501 - .503 wide x 4" long with 1 3/4R Maximum	1.8750/1.8735

TABLE 1

CRANKSHAFTS	STD	MAINS	RODS	.020 UNDERSTIZE	MAINS	RODS	REMARK	ROTOR MAIN DIAMETER
F C/D 4 HERR.	CSF 36	2.1250 2.1240	2.000 1.999	CSF 75	2.1050 2.1040	1.980 1.979	.2050 - .2093 Deep x .376 - .378 wide x 2 1/4" long with 1 3/4R	1.6998 - 1.6983
F C/D 5 HERR.	CSF 41	2.1250 2.1240	2.000 1.999	CSF 76	2.1050 2.1040	1.980 1.979	.2058 - .2103 Deep x .376 - .378 wide x 2 1/4" long with 1 3/4R	1.6248 - 1.6233
F C/D 6 HERR.	CSF 42	2.1250 2.1240	2.000 1.999	CSF 77	2.1050 2.1040	1.980 1.979	.2058 - .2103 Deep x .376 - .378 wide x 2 1/4" long with 1 3/4R	1.6248 - 1.6233
F C/D 8 HERR.	CSF 46	2.1250 2.1240	2.000 1.999	CSF 78	2.1050 2.1040	1.980 1.979	.2058 - .2103 Deep x .376 - .378 wide x 3" long with 1 3/4R	1.6248 - 1.6233
M 3(15) HERR.	CSF 48	2.1235 2.1225	1.9985 1.9975	CSF 87	2.1035 2.1025	1.9785 1.9775	.2050 - .2095 Deep x .376 - .378 wide x 2.2" long with 1.7R	1.6240 - 1.6225
M 4(20) HERR.	CSF 49	2.1235 2.1225	1.9985 1.9975	CSF 89	2.1035 2.1025	1.9785 1.9775	.2050 - .2095 Deep x .376 - .378 wide x 2.2" long with 1.7R	1.6240 - 1.6225
M 6(25) HERR.	CSF 59	2.1235 2.1225	1.9985 1.9975	CSF 90	2.1035 2.1025	1.9785 1.9775	.205 - .2095 Deep x .376 - .378 wide x 2.2" long with 1.7R	1.6240 - 1.6225
M 6(30) HERR.	CSF 51	2.1235 2.1225	1.9985 1.9975	CSF 91	2.1035 2.1025	1.9785 1.9775	.205 - .2095 Deep x .376 - .378 wide x 2.2" long with 1.7R	1.6240 - 1.6225

TABLE I

CRANESHAFTS	STD	MAINS	RODS	.020 UNDERSIZE	MAINS	RODS	KEYWAY	ROTOR MAIN DIAMETER
R 4(40) HFRM.	CSF 56	$\frac{2.8735}{2.8725}$	$\frac{2.7485}{2.7475}$	CSF 92	$\frac{2.8545}{2.8535}$	$\frac{2.730}{2.729}$	.7050 - .2095 Deep x .376 - 3.78 wide x 2.2 Long with 1.0R	1.6240 - 1.6225
R 6(50) HFRM.	CSF 57	$\frac{2.8735}{2.8725}$	$\frac{2.7485}{2.7475}$	CSF 93	$\frac{2.8545}{2.8535}$	$\frac{2.730}{2.729}$	.7740 - .2817 Deep x .501 - .503 wide x 2.5 Long with 1.0R	1.8740 - 1.8725
R 6(60) HFRM.	CSF 58	$\frac{2.8735}{2.8725}$	$\frac{2.7485}{2.7475}$	CSF 94	$\frac{2.8545}{2.8535}$	$\frac{2.730}{2.729}$	.7780-.2825 Deep x .501 - .503 wide x 2.5 Long with 1.0R	1.8740 - 1.8725

TABLE I

SHAFT	STD	MAINS	RODS	.020 UNDERSIZE	MAINS	RODS	WEAR LIMITS		RETURNS	ROTOR MAIN DIAMETER
							MAINS	RODS		
E 70T RPRM.	N.A.	2.1225 2.1225	2.2175 3.2165	N.A.	2.1125 2.1125	3.2075 3.2065	2.1117 MIN.	3.2057 MIN.	2.050 - .2100 Deep x .375 - .378 wide x 1.90 Long with 1.5K	1.6240/1.6230
		2.1235 2.1225	2.2175 3.2165		2.1135 2.1125	3.2075 3.2065	2.1117 MIN.	3.2057 MIN.	2.050 - .2100 Deep x .375 - .378 wide x 1.90 Long with 1.5K	1.6240/1.6230
E 70T RPRM.	N.A.	2.1225 2.1225	2.2175 3.2165		2.1135 2.1125	3.2075 3.2065	2.1117 MIN.	3.2057 MIN.	2.050 - .2100 Deep x .375 - .378 wide x 1.90 Long with 1.5K	1.6240/1.6230

CRANKSHAFT

RADIUS REQUIREMENTS

TABLE 11

MODEL	TYPE	PART #	ROD	MAIN
A	CYL. (4)	CSF0004	N/A (*)	RADIUS 1/8 +.010
A	CYL. (6)	CSF0005	N/A (*)	RADIUS 1/8 +.010
A	CYL. (8)	CSF0006	N/A (*)	RADIUS 1/8 +.010
B	CYL. (4)	CSF0001	N/A (*)	RADIUS 1/8 +.010
B	CYL. (6)	CSF0002	N/A (*)	RADIUS 1/8 +.010
B	CYL. (8)	CSF0003	N/A (*)	RADIUS 1/8 +.010
* CRANKSHAFT MAY HAVE UNDERCUT RADIUS FROM ORIGINAL MACH:				
E HERN. STD.	CYL. (4)	CSF0028	RADIUS .085/.105	RADIUS .12 +.015
E HERN. STD.	CYL. (5)	CSF0029	RADIUS .085/.105	RADIUS .12 +.015
E HERN. STD.	CYL. (6)	CSF0030	RADIUS .085/.105	RADIUS .12 +.015
E HERN. STD.	CYL. (8)	CSF0031	RADIUS .085/.105	RADIUS .12 +.015
E HERN. UND.	CYL. (4)	CSF0083	RADIUS .085/.105	RADIUS .12 +.015
E HERN. UND.	CYL. (5)	CSF0084	RADIUS .085/.105	RADIUS .12 +.015
E HERN. UND.	CYL. (6)	CSF0085	RADIUS .085/.105	RADIUS .12 +.015
E HERN. UND.	CYL. (8)	CSF0086	RADIUS .085/.105	RADIUS .12 +.015
E OPEN STD.	CYL. (4)	CSF0013	RADIUS .085/.105	RADIUS .12 +.015
E OPEN STD.	CYL. (5)	CSF0012	RADIUS .085/.105	RADIUS .12 +.015
E OPEN STD.	CYL. (6)	CSF0014	RADIUS .085/.105	RADIUS .12 +.015
E OPEN STD.	CYL. (8)	CSF0015	RADIUS .085/.105	RADIUS .12 +.015
E OPEN UND.	CYL. (4)	CSF0079	RADIUS .085/.105	RADIUS .12 +.015
E OPEN UND.	CYL. (5)	CSF0080	RADIUS .085/.105	RADIUS .12 +.015
E OPEN UND.	CYL. (6)	CSF0081	RADIUS .085/.105	RADIUS .12 +.015
E OPEN UND.	CYL. (8)	CSF0082	RADIUS .085/.105	RADIUS .12 +.015

		CRANKSHAFT	RADIUS REQUIREMENTS		TABLE 11
MODEL	TYPE	PART #	ROD	MAIN	
F A/B STD.	CYL. (3)	CSF0023	N/A (*)	RADIUS 1/8 +.010	
F A/B STD.	CYL. (4)	CSF0024	N/A (*)	RADIUS 1/8 +.010	
F A/B STD.	CYL. (5)	CSF0025	N/A (*)	RADIUS 1/8 +.010	
F A/B STD.	CYL. (6)	CSF0026	N/A (*)	RADIUS 1/8 +.010	
F A/B STD.	CYL. (8)	CSF0027	N/A (*)	RADIUS 1/8 +.010	
F A/B UND.	CYL. (3)	CSF0074	N/A (*)	RADIUS 1/8 +.010	
F A/B UND.	CYL. (4)	CSF0095	N/A (*)	RADIUS 1/8 +.010	
F A/B UND.	CYL. (5)	CSF0096	N/A (*)	RADIUS 1/8 +.010	
F A/B UND.	CYL. (6)	CSF0097	N/A (*)	RADIUS 1/8 +.010	
F A/B UND.	CYL. (8)	CSF0098	N/A (*)	RADIUS 1/8 +.010	
F C/D STD.	CYL. (4)	CSF0036	N/A (*)	RADIUS 1/8 +.010	
F C/D STD.	CYL. (5)	CSF0041	N/A (*)	RADIUS 1/8 +.010	
F C/D STD.	CYL. (6)	CSF0042	N/A (*)	RADIUS 1/8 +.010	
F C/D STD.	CYL. (8)	CSF0046	N/A (*)	RADIUS 1/8 +.010	
F C/D UND.	CYL. (4)	CSF0075	N/A (*)	RADIUS 1/8 +.010	
F C/D UND.	CYL. (5)	CSF0076	N/A (*)	RADIUS 1/8 +.010	
F C/D UND.	CYL. (6)	CSF0077	N/A (*)	RADIUS 1/8 +.010	
F C/D UND.	CYL. (8)	CSF0078	N/A (*)	RADIUS 1/8 +.010	
F OPEN STD.	CYL. (3)	CSF0016	N/A (*)	RADIUS 1/8 +.010	
F OPEN STD.	CYL. (4)	CSF0017	N/A (*)	RADIUS 1/8 +.010	
F OPEN STD.	CYL. (5)	CSF0018	N/A (*)	RADIUS 1/8 +.010	
F OPEN STD.	CYL. (6)	CSF0019	N/A (*)	RADIUS 1/8 +.010	
F OPEN STD.	CYL. (8)	CSF0020	N/A (*)	RADIUS 1/8 +.010	
F OPEN UND.	CYL. (3)	CSF0069	N/A (*)	RADIUS 1/8 +.010	
F OPEN UND.	CYL. (4)	CSF0070	N/A (*)	RADIUS 1/8 +.010	
F OPEN UND.	CYL. (5)	CSF0071	N/A (*)	RADIUS 1/8 +.010	
F OPEN UND.	CYL. (6)	CSF0072	N/A (*)	RADIUS 1/8 +.010	
F OPEN UND.	CYL. (8)	CSF0073	N/A (*)	RADIUS 1/8 +.010	

*CRANKSHAFT MAY HAVE UNDERCUT RADIUS FROM ORIGINAL MACHING.

CRANKSHAFT

RADIUS REQUIREMENTS

TABLE II

MODEL	TYPE	PART #	ROD	RAIN
F A/B STD.	CYL. (3)	CSF0023	N/A (+)	RADIUS 1/8 +.010
F A/B STD.	CYL. (4)	CSF0024	N/A (+)	RADIUS 1/8 +.010
F A/B STD.	CYL. (5)	CSF0025	N/A (+)	RADIUS 1/8 +.010
F A/B STD.	CYL. (6)	CSF0026	N/A (+)	RADIUS 1/8 +.010
F A/B STD.	CYL. (8)	CSF0027	N/A (+)	RADIUS 1/8 +.010
F A/B UNB.	CYL. (3)	CSF0074	N/A (+)	RADIUS 1/8 +.010
F A/B UNB.	CYL. (4)	CSF0095	N/A (+)	RADIUS 1/8 +.010
F A/B UNB.	CYL. (5)	CSF0096	N/A (+)	RADIUS 1/8 +.010
F A/B UNB.	CYL. (6)	CSF0097	N/A (+)	RADIUS 1/8 +.010
F A/B UNB.	CYL. (8)	CSF0098	N/A (+)	RADIUS 1/8 +.010
F C/D STD.	CYL. (4)	CSF0036	N/A (+)	RADIUS 1/8 +.010
F C/D STD.	CYL. (5)	CSF0041	N/A (+)	RADIUS 1/8 +.010
F C/D STD.	CYL. (6)	CSF0042	N/A (+)	RADIUS 1/8 +.010
F C/D STD.	CYL. (8)	CSF0046	N/A (+)	RADIUS 1/8 +.010
F C/D UNB.	CYL. (4)	CSF0075	N/A (+)	RADIUS 1/8 +.010
F C/D UNB.	CYL. (5)	CSF0076	N/A (+)	RADIUS 1/8 +.010
F C/D UNB.	CYL. (6)	CSF0077	N/A (+)	RADIUS 1/8 +.010
F C/D UNB.	CYL. (8)	CSF0078	N/A (+)	RADIUS 1/8 +.010
F OPEN STD.	CYL. (3)	CSF0016	N/A (+)	RADIUS 1/8 +.010
F OPEN STD.	CYL. (4)	CSF0017	N/A (+)	RADIUS 1/8 +.010
F OPEN STD.	CYL. (5)	CSF0018	N/A (+)	RADIUS 1/8 +.010
F OPEN STD.	CYL. (6)	CSF0019	N/A (+)	RADIUS 1/8 +.010
F OPEN STD.	CYL. (8)	CSF0020	N/A (+)	RADIUS 1/8 +.010
F OPEN UNB.	CYL. (3)	CSF0069	N/A (+)	RADIUS 1/8 +.010
F OPEN UNB.	CYL. (4)	CSF0070	N/A (+)	RADIUS 1/8 +.010
F OPEN UNB.	CYL. (5)	CSF0071	N/A (+)	RADIUS 1/8 +.010
F OPEN UNB.	CYL. (6)	CSF0072	N/A (+)	RADIUS 1/8 +.010
F OPEN UNB.	CYL. (8)	CSF0073	N/A (+)	RADIUS 1/8 +.010

*CRANKSHAFT MAY HAVE UNDERCUT RADIUS FROM ORIGINAL MACHING.

CRANKSHAFT

RADIUS REQUIREMENTS
TABLE II

MODEL	TYPE	PART #	ROD	MAIN
K STD.	TOM (20)	PART # 5057119201	N/A	N/A
K STD.	TOM (25)	PART # 5057119202	N/A	N/A
K STD.	TOM (30)	PART # 5057119203	N/A	N/A
K .010	TOM (20)	PART # 5057147201	N/A	N/A
K .010	TOM (25)	PART # 5057147202	N/A	N/A
K .010	TOM (30)	PART # 5057147203	N/A	N/A
M STD.	CYL. (3)	CSF0048	RADIUS .065/.045	RADIUS .12 $\pm$.015
M STD.	CYL. (4)	CSF0049	RADIUS .065/.045	RADIUS .12 $\pm$.015
M STD. LS	CYL. (6)	CSF0051	RADIUS .065/.045	RADIUS .12 $\pm$.015
M STD. SS	CYL. (6)	CSF0059	RADIUS .065/.045	RADIUS .12 $\pm$.015
M UND.	CYL. (3)	CSF0087	RADIUS .065/.045	RADIUS .12 $\pm$.015
M UND.	CYL. (4)	CSF0089	RADIUS .065/.045	RADIUS .12 $\pm$.015
M UND. LS	CYL. (6)	CSF0091	RADIUS .065/.045	RADIUS .12 $\pm$.015
M UND. SS	CYL. (6)	CSF0090	RADIUS .065/.045	RADIUS .12 $\pm$.015
R STD.	CYL. (4)	CSF0056	RADIUS .065/.045	RADIUS .12 $\pm$.015
R STD. SS	CYL. (6)	CSF0057	RADIUS .065/.045	RADIUS .12 $\pm$.015
R STD. LS	CYL. (6)	CSF0058	RADIUS .065/.045	RADIUS .12 $\pm$.015
R UND.	CYL. (4)	CSF0092	RADIUS .065/.045	RADIUS .12 $\pm$.015
R UND. SS	CYL. (6)	CSF0093	RADIUS .065/.045	RADIUS .12 $\pm$.015
R UND. LS	CYL. (6)	CSF0094	RADIUS .065/.045	RADIUS .12 $\pm$.015