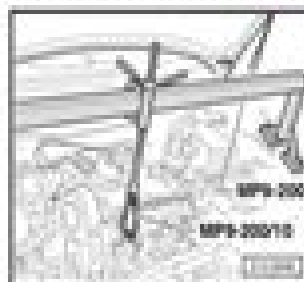
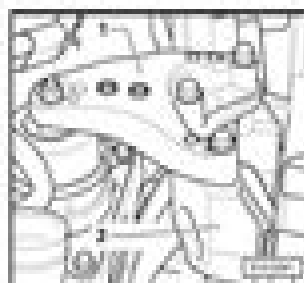




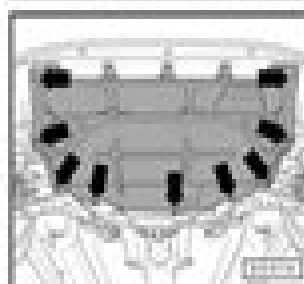
- Install supporting device -MP 1-200 (15-222A)- according to the illustration and support engine in lifting position.



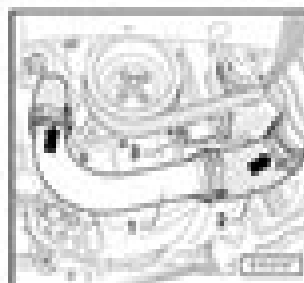
- Remove engine mount -1- and engine struts -2-.
- Remove V-belted belt [p.202.13](#).
- If necessary remove locking pin -T10005A- from tensioning element.
- Remove the locked belt guard.



- Remove noise insulation covers.



- Unscrew belt -3-.
- Remove charge-air pipe at bottom -1- with connecting hose -2- -detach-.
- Remove belt pulley [p.202.25](#) (Pos. 18).
- Remove middle toothed belt guard [p.202.25](#) (Pos. 21).
- Remove bottom toothed belt guard [p.202.25](#) (Pos. 18).
- Position crankshaft on TDC for cylinder 1.



Note

Turn crankshaft until the marking on the timing belt sprocket and the marking on the timing belt guard stand opposite each other -arrows A- at the top.

- Lock hub with rig pin -MP 1-301 (3356)-. Insert locking pin through the free left slot into the hole at the cylinder head.
- Secure the crankshaft toothed belt sprocket with the crankshaft arrester -T10050-. Insert crankshaft arrester from the front side of the timing belt sprocket into the teeth.

To facilitate this step, it is recommended to colour the TDC marking at the crankshaft timing belt sprocket and on the crankshaft arrester -T10050- with white paint -arrows B-.



Note

- The marking on the crankshaft timing belt sprocket and the marking on the crankshaft arrester must be positioned opposite each other -arrows B-. The bolt of the crankshaft arrester must engage in the hole of the sealing flange -arrow C-.
- The crankshaft arrester -T10050- must not be used as a counter-rotator when releasing or tightening the belt for the crankshaft toothed belt sprocket.

- Mark the rotation direction of the timing belt.

- Slacken both of camshaft sprocket -arrows- sufficiently so that the camshaft sprocket can be turned. For this purpose, coast behind the toothed belt sprocket using the counterholder -T10175- with bolts -T101724-.

- Loosen the fixing nut -1- of the tensioning pulley.
- Carefully turn eccentric of the tensioning pulley with offset screwdriver -T10254- in anti-clockwise direction -arrows- until the tensioning pulley can be interlocked with rig bolt -T10265-.



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S Ben Porath



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web the following sections show the methods used to calculate flat patterns for brake bent or die formed sheet metal parts the later sections describe the geometry and instructions for laying out sheet metal developments and transitions also included are calculations for punching requirements of sheet metal parts and tooling requirements for

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web ketiv technologies ketiv ava introduction 1 1 bend parameters used in this document the following parameters and terms

are used throughout this document figure 1 basic

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web die engineering layouts and formulas a reference book illustrating and describing the key designs of punches and dies based on precept and formulas sheet metal layout simplified

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web metal fabrication is the creation of metal structures by cutting and bending sheet metal than assembling those formed components into a pre determined product applied metal boatbuilding methods sheetmetal pattern development is basic to rounding out your metalworking layout

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web higher volumes pressing sheet metal is often more cost efficient due to the speed and ability to automate the majority of the process the definitions of bending and pressing can be seen in chapter 3 2 the method of pressing sheet metal also enables more complex geometries and thus makes it possible to eliminate welding of the components

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web sheetmetal layout formulas to calculate the cut sizes locations of bend lines and interior features demonstrated through the fabrication of marine components typical to steel and aluminum pleasure craft fabrication of metallic pressure vessels owen r greulich 2021 11 02 fabrication of metallic pressure vessels a

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web form height to thickness ratio to determine the minimum form height for sheet metal use the following formula $d \geq 2.5t$ r see below the height can be less but it required secondary operations and is far more costly 5

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web jan 26 2022 if the shop is using a v die to make the flange there is a minimum and maximum length that any flange can be in general the flange needs to be at least 3 though we suggest 4 times longer than the thickness of the material for sheet metal that s 0 120 thick that means a minimum flange length of 0 480 long

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web nov 9 2012 more than one sheet metal bending formula press brake technicians can use various formulas to calculate bend functions for instance in this article we have used the following for outside setback $ossb = \frac{t}{\sin(\frac{\alpha}{2})}$ tangent degree of bend angle 2 material thickness inside radius