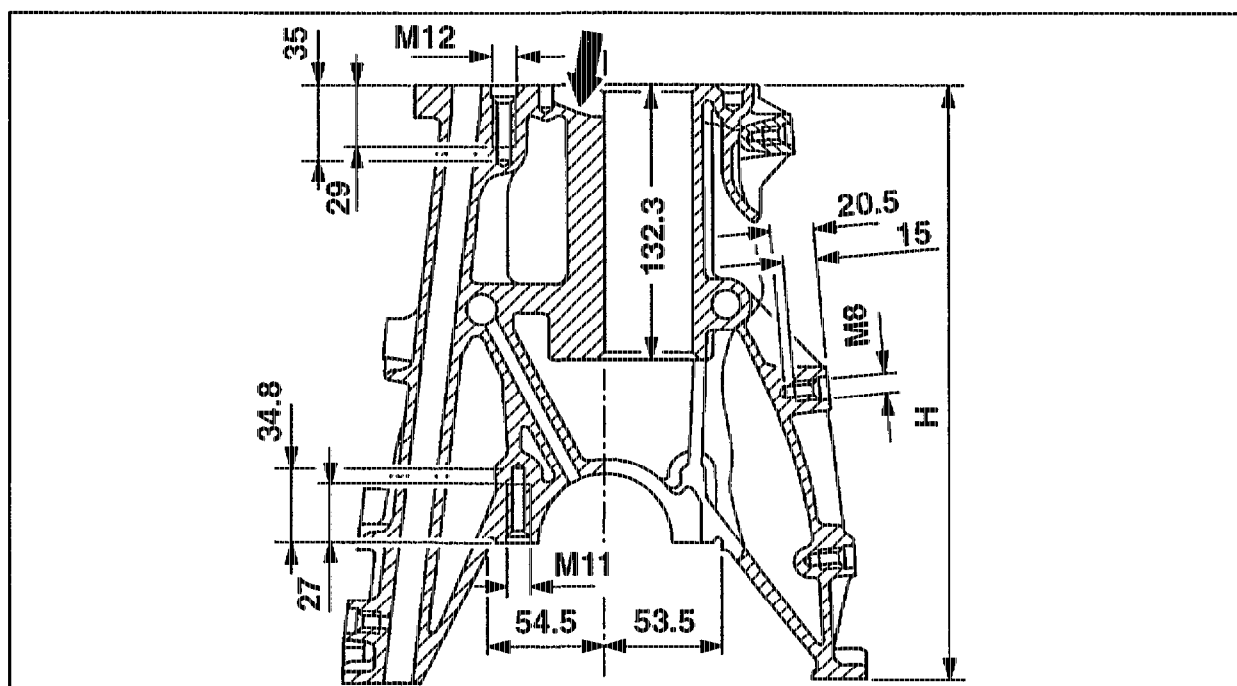


01-1200 Facing contact surface of crankcase

Preceding work:
Pistons removed (03-3160).

Operation no. of operation texts and work units or standard texts
and flat rates



P01-5888-55

Data

Height "H" of crankcase when new	282.25 – 282.35
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Minimum height after necessary stock removal ¹⁾	281.95
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Permissible unevenness	upper crankcase contact surface	0.03
	lower crankcase contact surface	0.04

Permissible deviation of parallelism of upper to lower contact surface of crankcase in	longitudinal direction	0.1
	transverse direction	0.05

Peak-to-valley height (Rz)	upper crankcase contact surface	0.005 – 0.020
	lower crankcase contact surface	0.025

Test pressure with air in water in bar gauge	1.5
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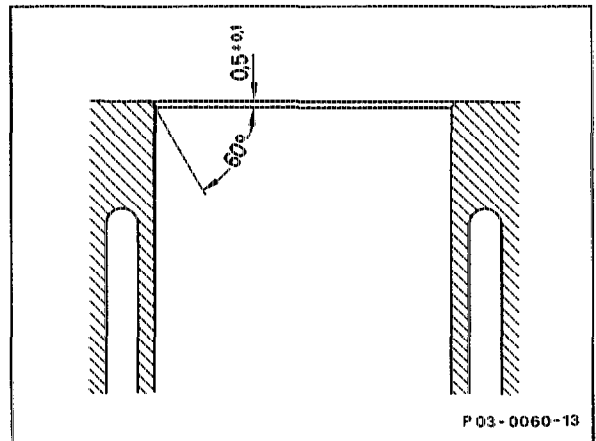
Chamfering of cylinder bores	see note
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¹⁾ The stock removal at the crankcase and at the cylinder head of an engine must together not be more than 0.4 mm (see 01-4180).

Note

Face crankcase together with the timing case cover.

After facing, chamfer the cylinder bores as shown in the drawing opposite.



Chamfer cylinder bores with a suitable handmilling cutter as shown in the drawing. Equalize bottom edge of chamfer with polishing stone.

