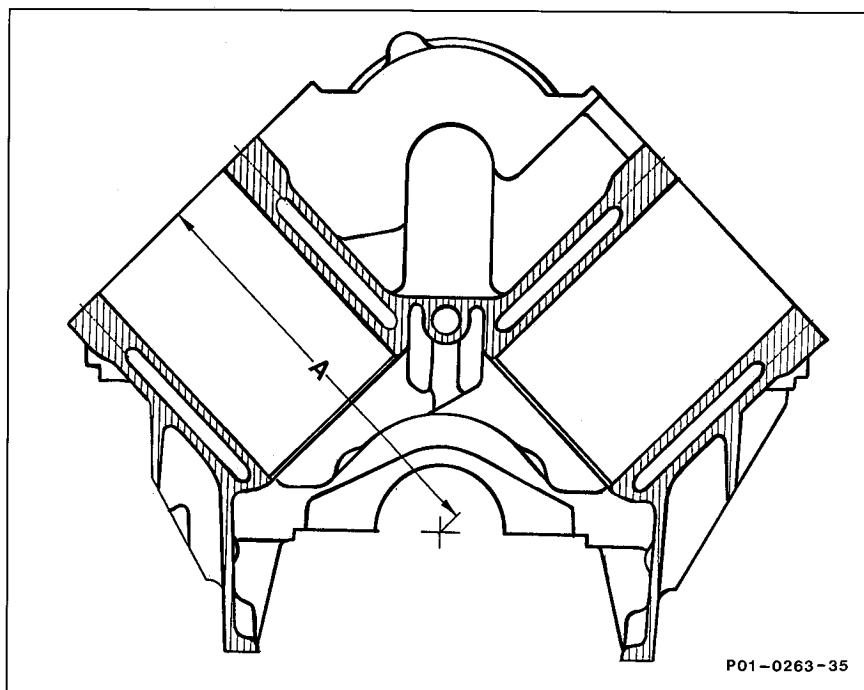


01-1200 Facing crankcase mating surface

Preceding work:
Engine, pistons, cylinder heads and crankshaft removed.



P01-0263-35

Data

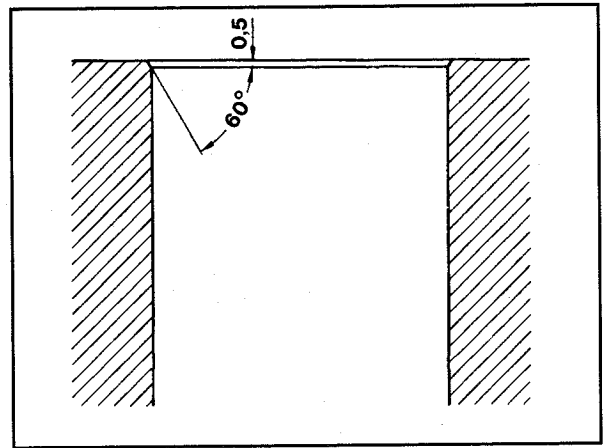
Engine		119.96	119.97/98
Height "A" of crankcase		245.35-245.45	228.90-229.00
Minimum height after required stock removal ¹⁾		245.25	228.80
Permissible variation of parallelism of top mating surface to crankshaft centre	in longitudinal direction	0.08	
	in transverse direction	0.05	
Permissible variation of evenness of top mating surfaces		0.02	
Averaged peak-to-valley height (Rz) of top mating surface		0.006-0.016	
Pressure-testing pressure: water chamber with air under water in bar gauge		3	
Chamfers of cylinder bores		see note	

¹⁾ The stock removal at the crankcase and at the cylinder head of an engine must together be not more than 0.4 mm (see 01-4180).

Note

Face crankcase together with timing case cover.
Always face right and left bank of cylinders by
the same amount.

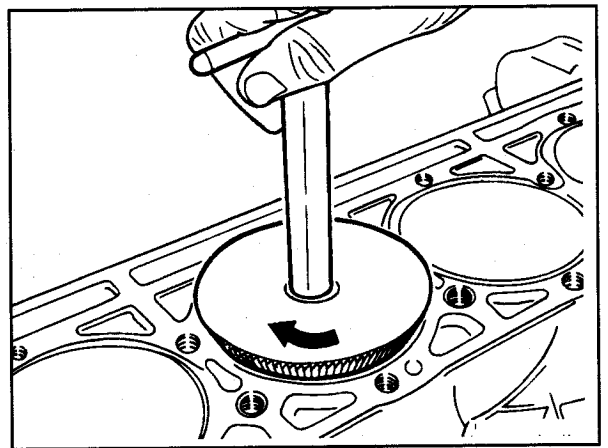
After facing, chamfer the cylinder bores as
shown in the sketch.



P03-0190-13

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

If the crankcase mating surface is machined, the
timing must be checked (see 05-2150).



P01-2573-13