

G9

AR01.40-P-9202A

Measuring cylinder bores

14.10.96

ENGINE 604, 605, 606 /

- 1, 2, 3 *Measuring points of cylinder bore*
 A *Longitudinal direction*
 B *Transverse direction*
 a *Top reversal point of 1st piston ring*
 b *Bottom dead center of piston*
 c *Bottom reversal point of oil scraper ring*

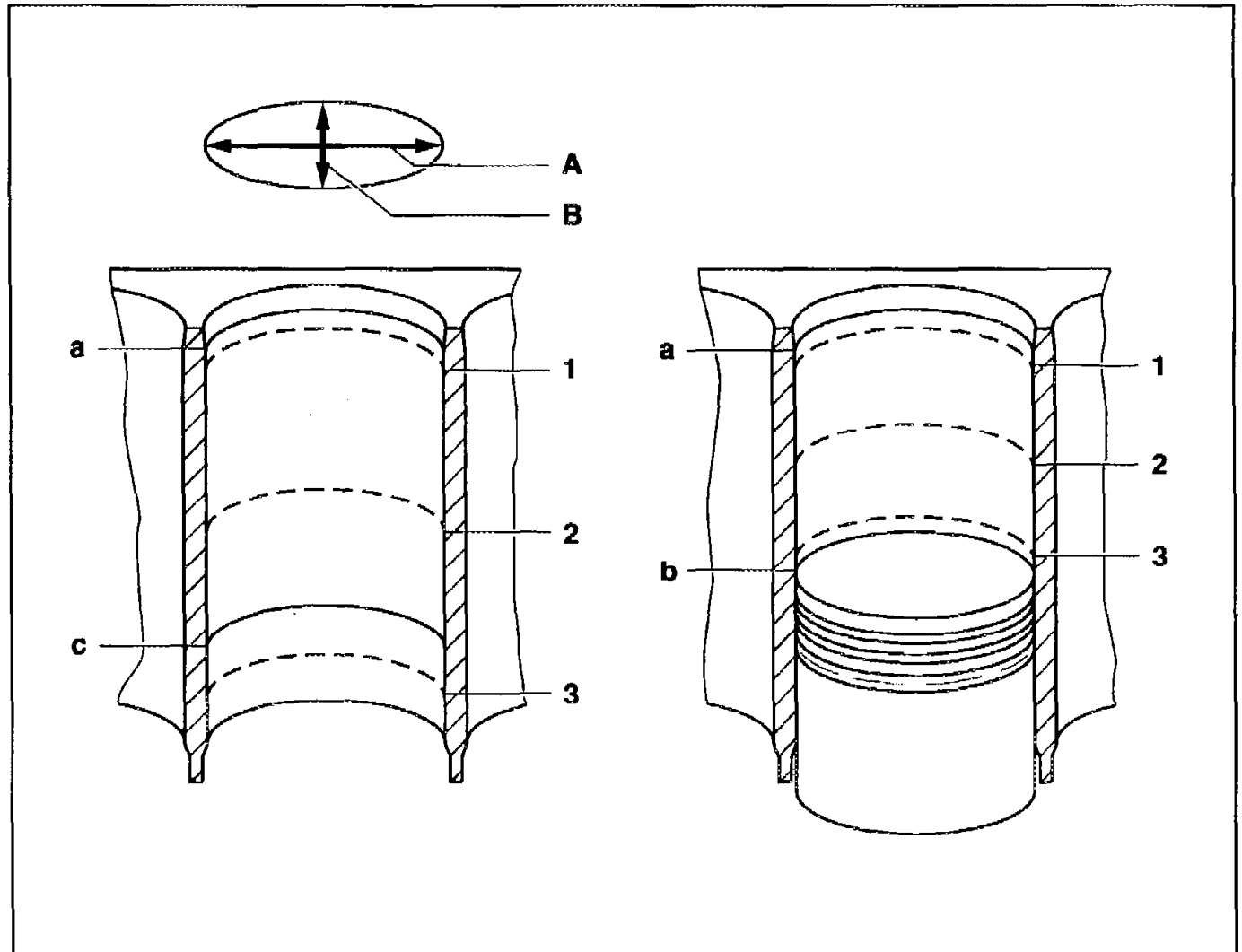



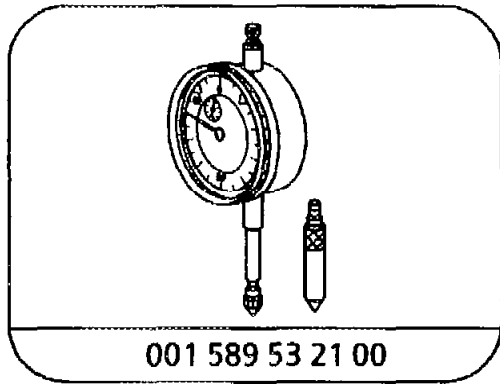


Fig. item, etc.	Work instructions		
1	Cylinder bores	<p> Measure cleaned cylinder bores at the 3 measuring points (1, 2, 3) in longitudinal and transverse direction with an internal measuring instrument</p> <p></p> <p>Cylinder diameter</p> <p>Permissible difference of cylinder shape (when new)</p> <p>Wear limit in longitudinal and transverse direction</p> <p>Out-of-roundness</p> <p>If wear excessive and/or cylinder barrel damaged ↓</p> <p>Widen cylinder bore in crankcase</p> <p> Cylinder liners are installed and standard size pistons used when carrying out repairs</p> <p>On engines fitted with cylinder liners ↓ (engines which have already been re-conditioned)</p> <p>Remove cylinder liner ↓</p>	<p>001 589 53 21 00</p> <p>WH58.30-Z-1070-12A</p> <p>BE01.40-P-1001-01E</p> <p>BE01.40-P-1004-01E</p> <p>BE01.40-P-1003-01E</p> <p>BE01.40-P-1005-01E</p> <p>AR01.40-P-9271A L9</p> <p>AR01.40-P-9272A P9</p>

		Install cylinder liner ↓	AR01.40-P-9273A	C10
		Chamfer cylinder bores ↓	AR01.40-P-9201-01B	E16
		Bore and hone cylinder bores	AR01.40-P-9291A	E10

Test data of cylinder bore

Number	Designation		Engine 604.910/912	Engine 604.915/917, 605.91/96, 606.91/96
BE01.40-P-1001-01E	Cylinder Ø	Standard size	mm 89.0	87.0
		Group code letter A	mm 89.000–89.006	87.000–87.006
		Group code letter X	mm 89.006–89.012	87.006–87.012
		Group code letter B	mm 89.012–89.018	87.012–87.018
BE01.40-P-1003-01E	Cylinder bore	Wear limit in longitudinal and transverse direction	mm 0.20	0.20
BE01.40-P-1004-01E	Cylinder bore	Permissible difference of cylinder shape (when new)	mm 0.000–0.014	0.000–0.014
		Wear limit	mm 0.05	0.05
BE01.40-P-1005-01E	Cylinder bore	Out-of-roundness	mm 0.07	0.07



Dial gage

Commercially available tools (see Workshop Equipment Manual)

Number	Designation	Make (e.g.)	Order number
WH58.30-Z-1070-12A	Internal measuring instrument for 80 – 100 mm \varnothing with 0.01 mm indication and measuring point pressure relief	Hahn und Kolb Borsigstr. 50 70469 Stuttgart	33 520 080