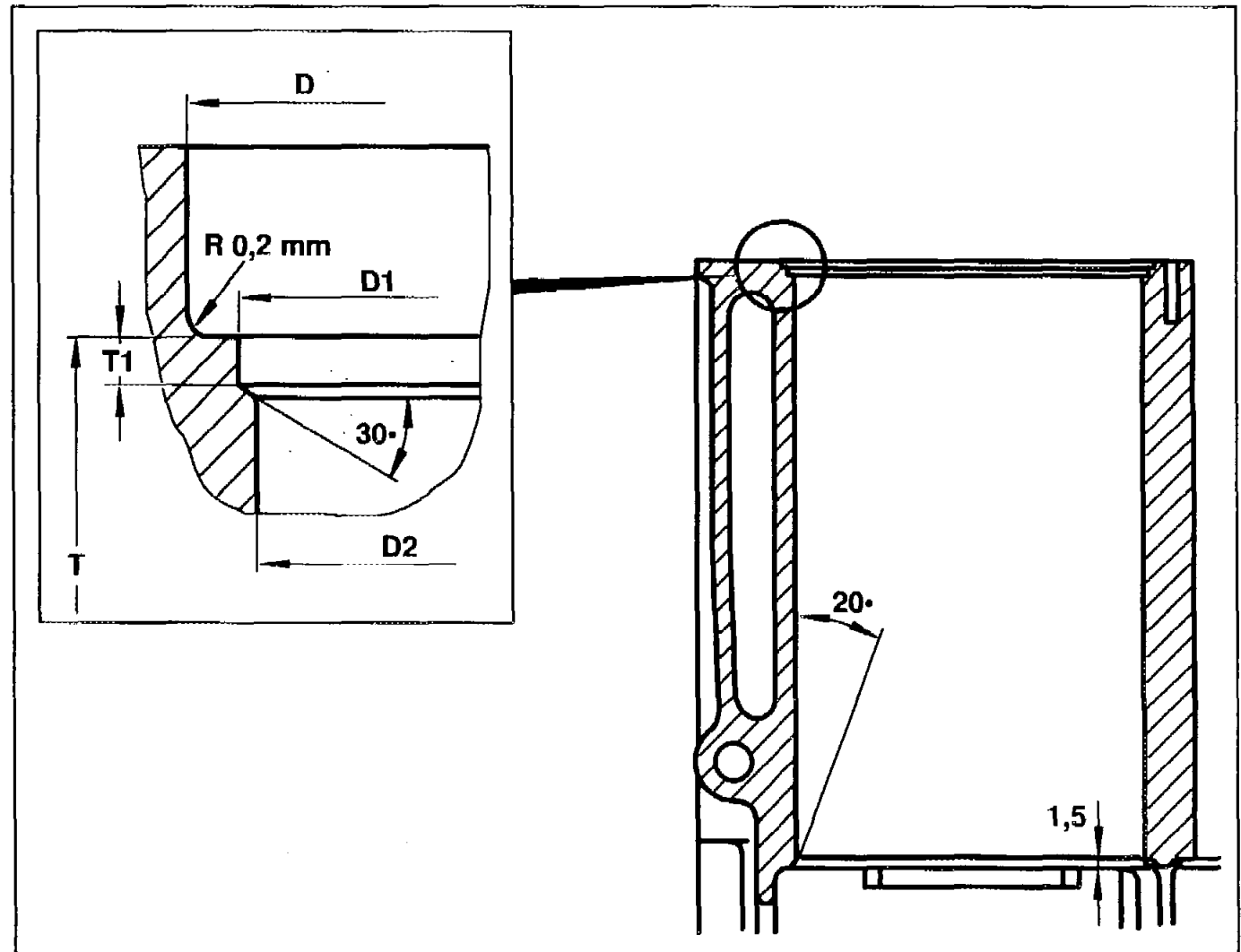


L9

AR01.40-P-9271A

Widening cylinder bore in crankcase

20.9.96

ENGINE 604, 605, 606 /*D* Bore \varnothing for cylinder liner collar*D1* Bore \varnothing for cylinder liner collar*D2* Bore \varnothing for cylinder liner*T* Cylinder liner seat to center of basic bearing bore*T1* Depth of cylinder liner seat

	Machining		
1	Widen cylinder bore	Pay attention to operating instructions of the tool manufacturer. Keep to the dimensions indicated in the test and setting data. Bore \varnothing (D2)	BE01.40-P-1007-02B
2	Bore liner collar seat	Bore \varnothing (D, D1) Distance between cylinder liner collar seat and contact surface of crankshaft bearing cap (T) Depth of cylinder liner seat (T1)	BE01.40-P-1008-02B BE01.40-P-1009-02B BE01.40-P-1010-02B
3	Use a polishing stone to remove burrs at the slip chamfer of the crankcase		

Test data of crankcase

Number	Designation		Engine 604.910/912
BE01.40-P-1007-02B	Bore \varnothing for cylinder liner in crankcase D2	mm	91.500–91.535
		Fig. see	AR01.40-P-9133-02A
BE01.40-P-1008-02B	Bore \varnothing for cylinder liner collar in crankcase	D1 mm	92.09–92.11
		D mm	94.15–94.25
		Fig. see	AR01.40-P-9133-02A

Test data of crankcase

Number	Designation	Engine 604.910/912
BE01.40-P-1009-02B	Seat of liner to center of basic bearing bore (T)	mm 231.0-231.2
	Fig. see	AR01.40-P-9133-02A
BE01.40-P-1010-02B	Depth of liner seat (T1)	mm 1.0-1.2
	Fig. see	AR01.40-P-9133-02A
BE01.40-P-1011-02B	Chamfer of cylinder bore at bottom of cylinder runout	mm 1.5×20°



Test data of crankcase

Number	Designation	Engine 604.915/917 605.91/96 606.91/96
BE01.40-P-1007-02B	Bore \varnothing for cylinder liner in crankcase D2	mm 90.000–90.035
	Fig. see	AR01.40-P-9133-02A
BE01.40-P-1008-02B	Bore \varnothing for cylinder liner collar in crankcase	D1 mm 90.55–90.65
		D mm 92.65–92.75
		Fig. see AR01.40-P-9133-02A
BE01.40-P-1009-02B	Seat of liner to center of basic bearing bore (T)	mm 231.0–231.2
		Fig. see AR01.40-P-9133-02A
BE01.40-P-1010-02B	Depth of liner seat (T1)	mm 1.0–1.2
		Fig. see AR01.40-P-9133-02A
BE01.40-P-1011-02B	Chamfer of cylinder bore at bottom of cylinder runout	mm 1.5×20°