

C10

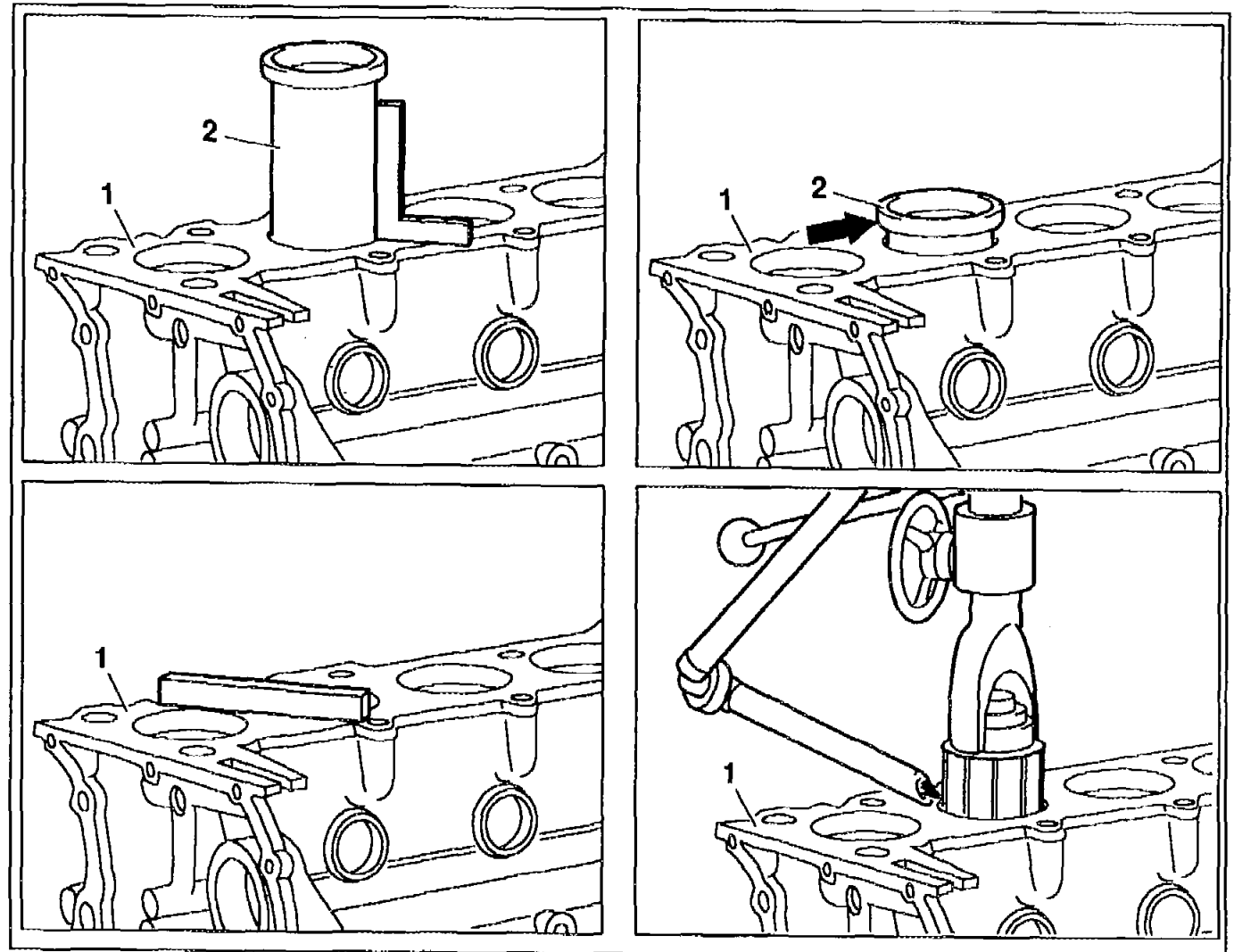
AR01.40-P-9273A

Installing cylinder liner




20.9.96

ENGINE 604, 605, 606 /

- 1 Crankcase
- 2 Cylinder liner





	Installing		
1.1	Widen cylinder bore in crankcase (1)	On engines without cylinder liners	AR01.40-P-9271A L9
1.2	Remove cylinder liner	On engines with cylinder liners	AR01.40-P-9272A P9
2	Place crankcase (1) onto the press and align		
3	Place new cylinder liner (2) onto the bore and align at right angles		
4	Press in cylinder liner (2)	 Use a suitable plate for pressing in. Inspect cylinder liner seat for abrasion and clean with compressed air if necessary. After pressing in, maintain the pressure on the cylinder liner for about 7 seconds (settling pressure).	
5	Machine contact surface of crankcase (1) together with timing case cover	 Stock removal at contact surface should be as minimal as possible	AR01.40-P-9133B C9
6	Clean crankcase (1)		
7	Bore and hone cylinder bores		AR01.40-P-9271A L9