

E10

AR01.40-P-9291A

Machining and polishing the cylinders

14.10.96

ENGINE 604, 605, 606 /

D Cylinder bore diameter after honing

D1 Bore diameter

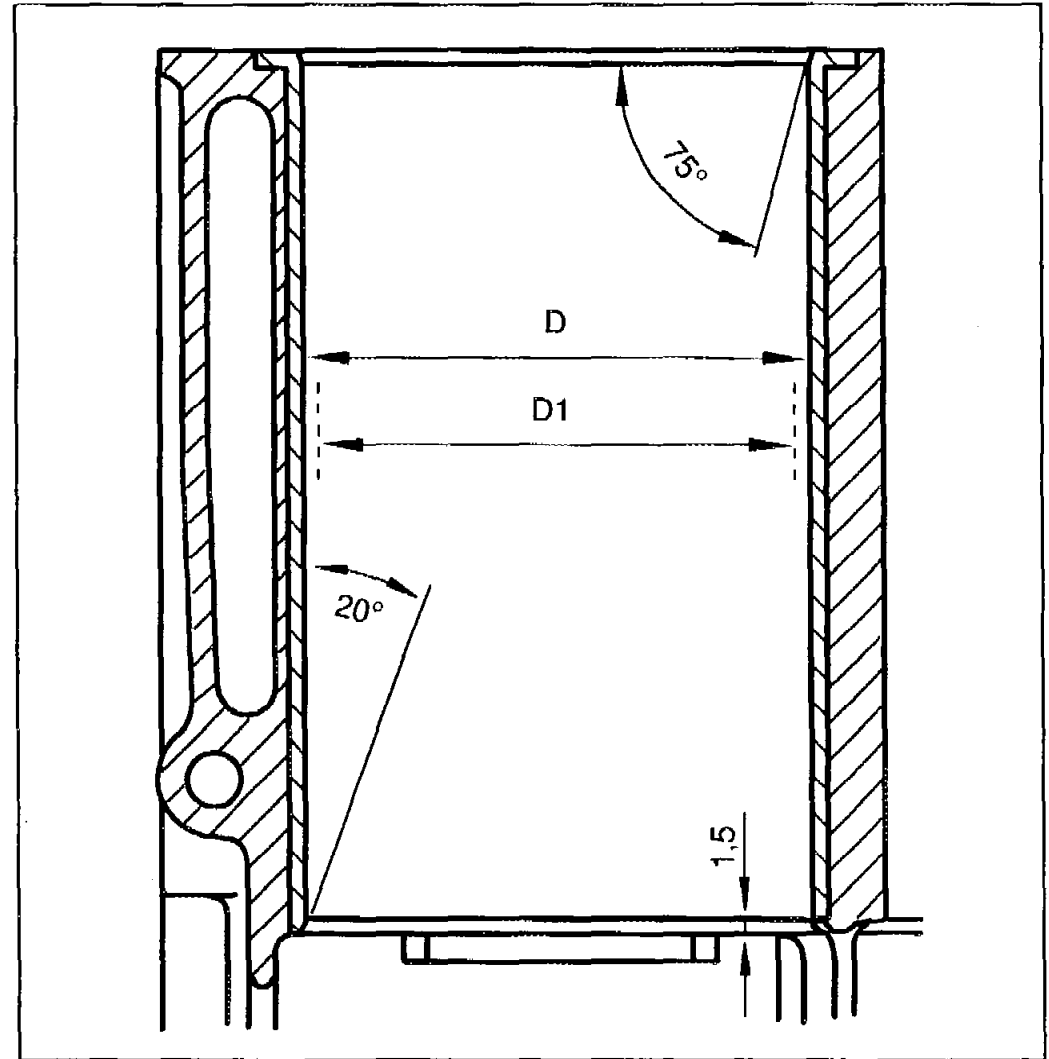





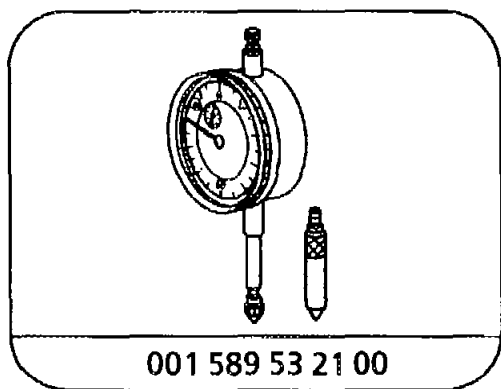


Fig.	Work instructions		
D	Cylinder bore \varnothing	 Measure   	001 589 53 21 00 WH58.30-Z-1055-12A WH58.30-Z-1070-12A WH58.30-Z-1068-12A
D1	Bore diameter	Determine and set machining tool  The bore \varnothing (D1) corresponds to the cylinder bore \varnothing (D) less the material allowance for the honing operation. The material allowance for honing should in this case not be more than 0.05 mm. Select the repair size \varnothing (D) from the existing pistons (A, X, B).	BE01.40-P-1001-01E
	Cylinder bore	Chamfer	AR01.40-P-9201-01B E16
	Honing operation	Carry out according to specified data	BE01.40-P-1008-01E BE01.40-P-1006-01E



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 \varnothing	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-1006-01E	Cylinder bore	Basic peak-to-valley height (R3 _z)	mm	0.002–0.005	0.002–0.005
BE01.40-P-1008-01E	Honing angle		$^{\circ}\Delta$	40–60	40–60



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	Hahn und Kolb Borsigstr. 50 70469 Stuttgart	33 520 080
WH58.30-Z-1055-12A	Setting gage for micrometer	Hahn und Kolb Borsigstr. 50 70469 Stuttgart	31410 0002 or 3140 0010
WH58.30-Z-1068-12A	Micrometer 75 – 100 mm	Hahn und Kolb Borsigstr. 50 70469 Stuttgart	31414 150