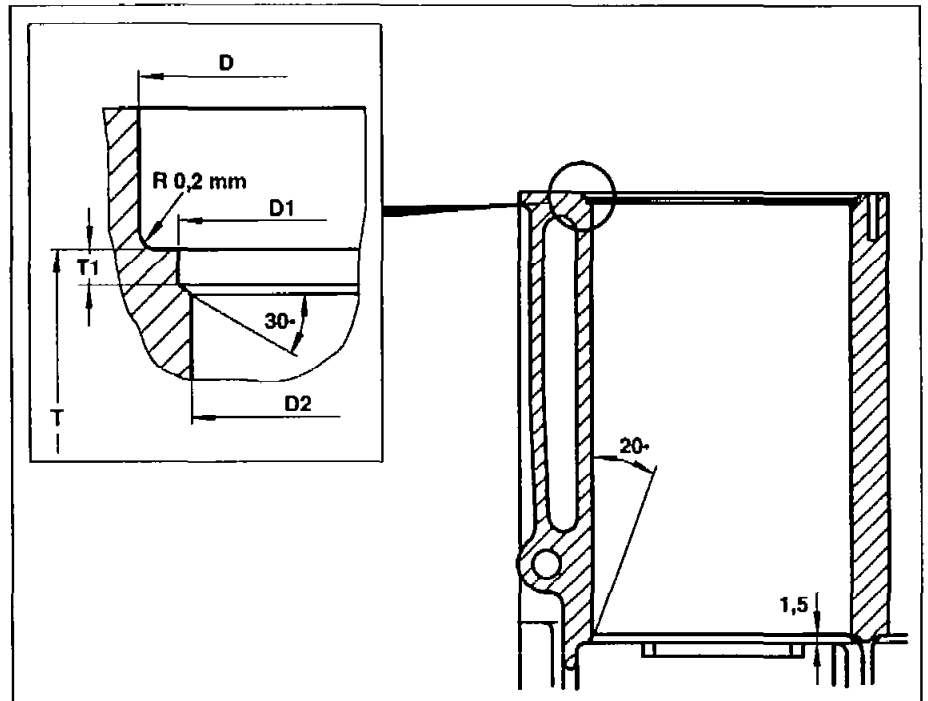


ENGINE 601, 602, 603 (except, 602.982)

- D* Bore Ø for cylinder liner collar  
*D1* Bore Ø for cylinder liner collar  
*D2* Bore Ø for cylinder liner  
*T* Cylinder liner seat to middle of basic bearing bore  
*T1* Depth of cylinder liner seat



P01.40-0299-06

	Machining		
1	Widen cylinder bore	Pay attention to operating instructions of tool manufacturer; maintain dimensions as specified in test and setting data. Bore Ø (D2)	BE01.40-P-1007-02D
2	Bore cylinder liner collar seat	Bore Ø (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-1008-02D BE01.40-P-1009-02D BE01.40-P-1010-02D
3	Mill off land tips between the cylinders		AR01.40-P-9271-01AW AR01.40-P-9271AW/2 BE01.40-P-1012-02D
4	Debur crankcase with polishing wheel at the chamfer		
5	Thoroughly clean crankcase		

Test data of crankcase

Number	Designation	Engine 601, 602.91/96, 603.91/96
BE01.40-P-1007-02D	Bore Ø for cylinder liner in crankcase D2	mm 90.000-90.035
	Fig. see	AR01.40-P-9271AW

Test data of crankcase

Number	Designation		Engine 601, 602.91/96, 603.91/96
BE01.40-P-1008-02D	Bore Ø for cylinder liner collar in crankcase	D1	mm 90.55–90.65
		D	mm 92.65–92.75
		Fig. see	AR01.40-P-9271AW
BE01.40-P-1009-02D	Cylinder liner seat to middle of basic bearing bore (T)		mm 231.0–231.2
		Fig. see	AR01.40-P-9271AW
BE01.40-P-1010-02D	Depth of liner seat (T1)		mm 1.0–1.2
		Fig. see	AR01.40-P-9271AW
BE01.40-P-1012-02D	Land depth and peak to valley height between cylinder bores after machining	Land width (M)	mm 35
		Peak-to-valley height (RZ)	mm 0.100
		Fig. see	AR01.40-P-9271-01AW

Test data of crankcase

Number	Designation		Engine 603.97
BE01.40-P-1007-02D	Bore Ø for cylinder liner in crankcase	D2	mm 91.500–91.535
		Fig. see	AR01.40-P-9271AW
BE01.40-P-1008-02D	Bore Ø for cylinder liner collar in crankcase	D1	mm 92.00–92.20
		D	mm 94.15–94.25
		Fig. see	AR01.40-P-9271AW
BE01.40-P-1009-02D	Cylinder liner seat to middle of basic bearing bore (T)		mm 231.0–231.2
		Fig. see	AR01.40-P-9271AW
BE01.40-P-1010-02D	Depth of liner seat (T1)		mm 1.0–1.2
		Fig. see	AR01.40-P-9271AW
BE01.40-P-1012-02D	Land depth and peak to valley height between cylinder bores after machining	Land width (M)	mm 35
		Peak-to-valley height (RZ)	mm 0.100
		Fig. see	AR01.40-P-9271-01AW

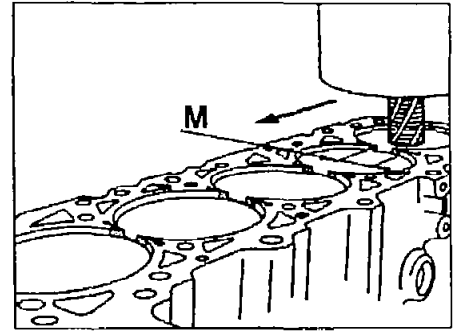
AR01.40-P-9271-01AW	Milling off land tips between the cylinders		
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Test data of crankcase

Number	Designation		Engine 601, 602.91/96, 603.91/96
BE01.40-P-1012-02D	Land width and peak to valley height between cylinder bores after machining cylinder bores	Land width (M)	mm 35
		Peak-to-valley height (RZ)	mm 0.100
		Fig. see	AR01.40-P-9271-01AW



- 1 Mill off land tips between the cylinders; pay attention to dimension (M).



D01.45-0055-01