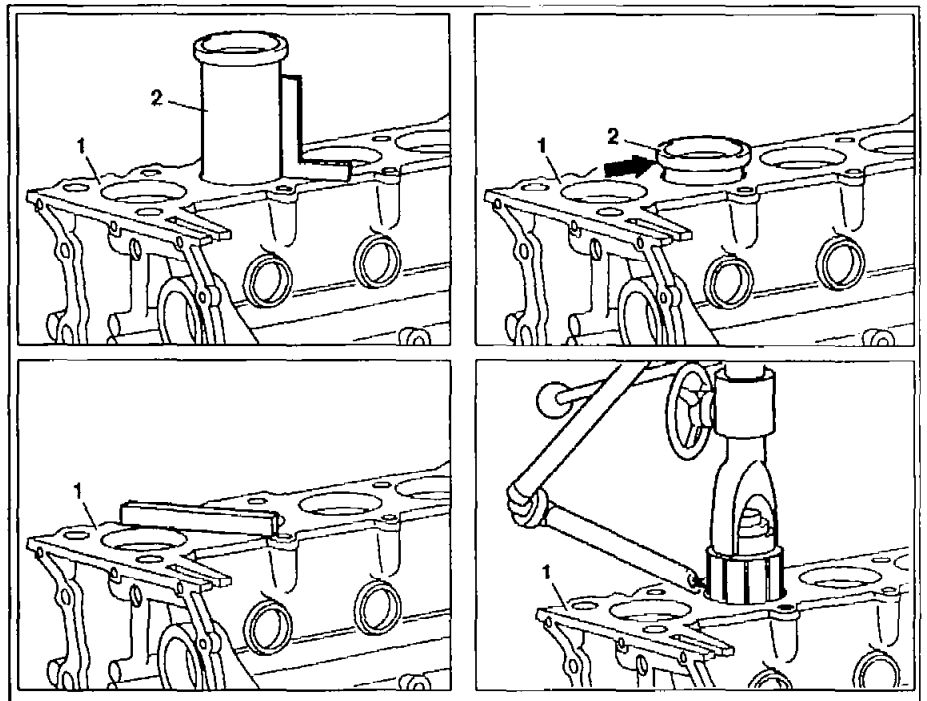


## ENGINE 601, 602, 603 (except, 602.982)

- 1 Crankcase  
2 Cylinder liner



P01.40-0302-06

| ☒   | Installing   |  |                                      |
|-----|--|--|--------------------------------------|
| 1.1 | Widen cylinder bore in crankcase (1)                                     | Engines without cylinder liners  | AR01.40-P-9271AW<br>AR01.40-P-9271AW |
| 1.2 | Remove cylinder liner to be replaced                                     | Engines with cylinder liners   | AR01.40-P-9272AW<br>AR01.40-P-9272AW |
| 2   | Place crankcase (1) onto the press and align                             |  |                                      |
| 3   | Position new cylinder liner (2) at the bore and align at right angles    |  |                                      |
| 4   | Press in cylinder liner (2)  | <p>ⓘ Use a suitable plate for pressing in. Inspect cylinder liner seat for abrasion and clean with compressed air, if necessary. After pressing in, maintain pressure on cylinder liner for a further 7 seconds or so (settling pressure).</p> |                                      |
| 5   | Machine contact surface of crankcase (1) together with timing case cover | <p>Ⓢ Keep stock removal at contact surface to the minimum possible.</p>  | AR01.40-P-9133AW<br>AR01.40-P-9133AW |
| 6   | Clean crankcase (1)  |  |                                      |
| 7   | Bore and hone cylinder bores   |  | AR01.40-P-9271AW<br>AR01.40-P-9271AW |