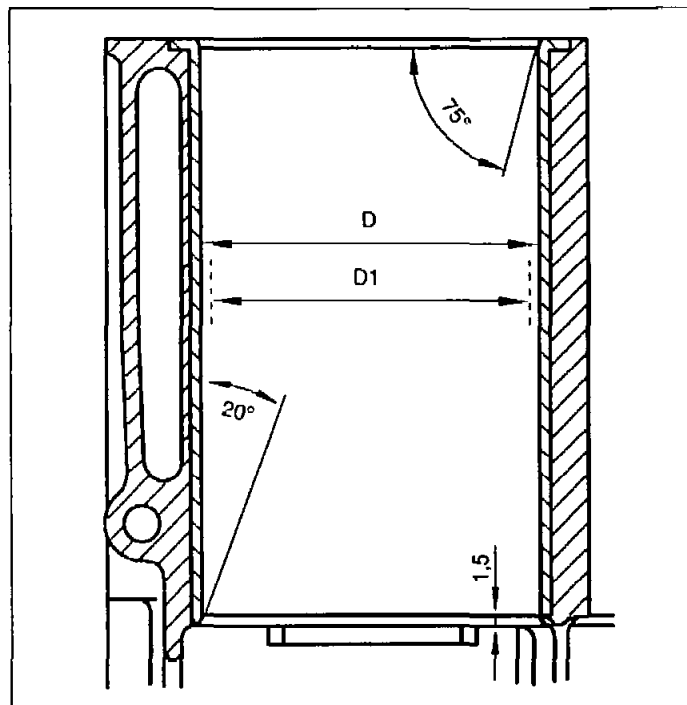



ENGINE 601, 602, 603 (except, 602.982)

D Cylinder bore diameter after polishing

D1 Bore diameter



P01.40-0303-12

Fig. item, etc.	Work instructions		
D	Cylinder bore \varnothing	measure	AR01.40-P-9202AW AR01.40-P-9202AW
D1	Bore diameter	determine and set machining tool  The bore \varnothing (D1) corresponds to the cylinder bore \varnothing (D) less the material allowance for polishing. The material allowance for polishing should be not more than 0.05 mm. Select the repair size \varnothing (D) in accordance with the pistons fitted (A, X, B)	BE01.40-P-1001-01E BE01.40-P-1002-01E BE01.40-P-1004-01E BE01.40-P-1005-01E
	Cylinder bore	chamfer	AR01.40-P-9201-01AW AR01.40-P-9291AW/2 BE01.40-P-1009-01E BE01.40-P-1010-01E
	Polishing	carry out according to specified data	BE01.40-P-1008-01E BE01.40-P-1006-01E

Test data cylinder bore

Number	Designation		Engine 601, 602 except 602.98, 603 except 603.97	Engine 603.97
BE01.40-P-1001-01E	Cylinder Ø	Standard size	mm 87.0	89.0
		Group code letter A	mm 87.000–87.006	89.000–89.006
		Group code letter X	mm 87.007–87.012	89.007–89.012
		Group code letter B	mm 87.013–87.018	89.013–89.018
BE01.40-P-1002-01E	Cylinder Ø	1st repair size	mm 87.7	-
		Group code letter A	mm 87.700–87.706	-
		Group code letter X	mm 87.707–87.712	-
		Group code letter B	mm 87.713–87.718	-
BE01.40-P-1004-01E	Cylinder bore	Permissible variation of cylinder shape (when new)	mm 0.007	0.007
		Wear limit	mm 0.05	0.05
BE01.40-P-1005-01E	Cylinder bore	Out-of-roundness	mm 0.07	0.07
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	Polishing angle	°Δ	40–60	40–60
BE01.40-P-1009-01E	Chamfer of cylinder bore at top contact surface	Chamfer width	mm 0.2–1.0	0.2–1.0
		Chamfer angle	°Δ 75	75
BE01.40-P-1010-01E	Chamfer of cylinder bore at bottom	Chamfer width	mm 1.5	1.5
		Chamfer angle	°Δ 20	20

AR01.40-P-9201-01AW	Chamfering cylinder bores	Engine 601, 602 except 602.982, 603	
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Test data of crankcase

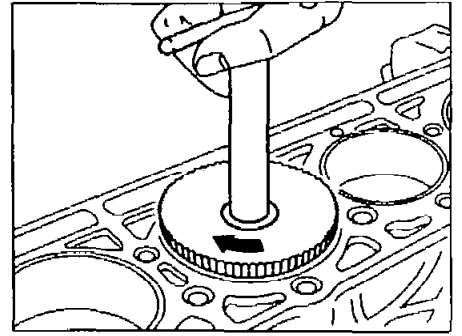
Number	Designation		Engine 601, 602.91/96, 603.91/96
BE01.40-P-1006-02D	Chamfer of cylinder bore at crankcase contact surface	mm	0.6-1×75°

Test data of crankcase

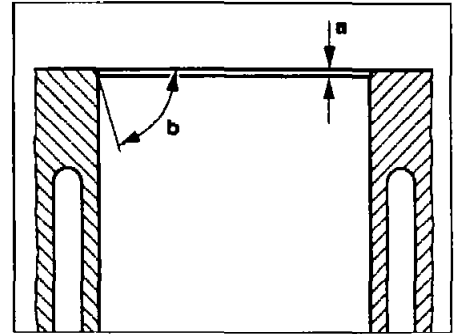
Number	Designation		Engine 603.97
BE01.40-P-1006-02D	Chamfer of cylinder bore at crankcase contact surface	mm	0.6-1×75°



- 1 After widening or machining, chamfer cylinder bores with an appropriate tool (e.g., hand milling cutter) as shown in the drawing.
- 2 Equalize bottom edge of chamfer with polishing wheel.

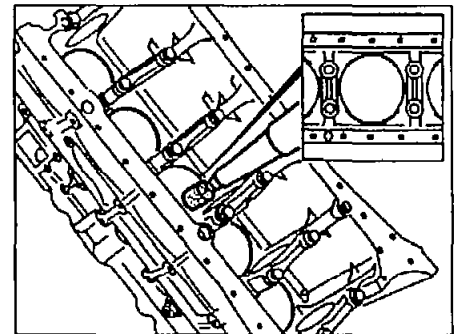


P01.40-0229-01



P01.40-2009-01

- 3 If the cylinder barrel has been machined, additionally debur bottom cylinder runout in the rock area of the pistons with a fine grindstone.



D01.40-0056-01