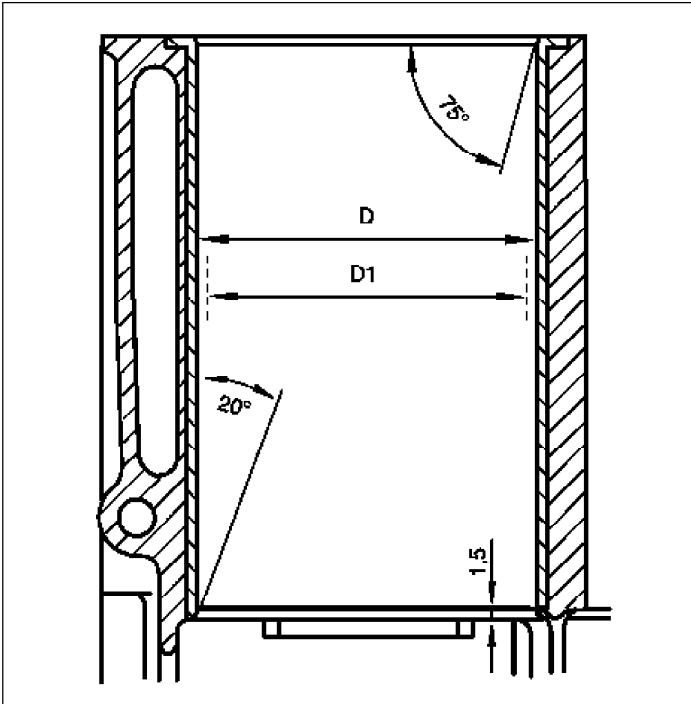


ENGINE 601, 602, 603 (except 602.982)

D Cylinder bore diameter after honing
D1 Bore diameter



P01.40-0303-12

Fig. item, etc.	Work instructions		
D	Cylinder bore dia.	Measure	AR01.40-P-9202AW
D1	Bore diameter	Ascertain, and adjust machine tool accordingly <i>i</i> The bore dia. (D1) equals the cylinder bore dia. (D) minus the material feed for the honing process. The material feed for honing should be no greater than max. 0.05 mm. The repair size dia. (D) is to be selected according to the existing pistons (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
	Honing	Perform according to specified data	*BE01.40-P-1009-01E *BE01.40-P-1008-01E *BE01.40-P-1007-01E *BE01.40-P-1006-01E

Test values for cylinder bore

Number	Designation		Engines 601, 602 except 602.98, 603 except 603.97	Engine 603.97
BE01.40-P-1001-01E	Cylinder liner dia.	Standard dimension	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 liner dia.	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 liner	Permissible deviation from true cylinder (new condition)	mm	0.007	0.007
		Wear limit	mm	0.05	0.05
BE01.40-P-1005-01E	Cylinder liner	Out-of-roundness	mm	0.07	0.07
BE01.40-P-1006-01E	Cylinder liner	Basic peak-to-valley height (R3 Z)	mm	0.002...0.005	0.002...0.005
BE01.40-P-1007-01E	Honing angle		°	40...60	40...60
BE01.40-P-1008-01E	Chamfer at top of cylinder liner	Chamfer width	mm	0.2...1.0	0.2...1.0
		Chamfer angle	°	75	75
BE01.40-P-1009-01E	Chamfer at bottom of cylinder liner	Chamfer width	mm	1.5	1.5
		Chamfer angle	°	20	20