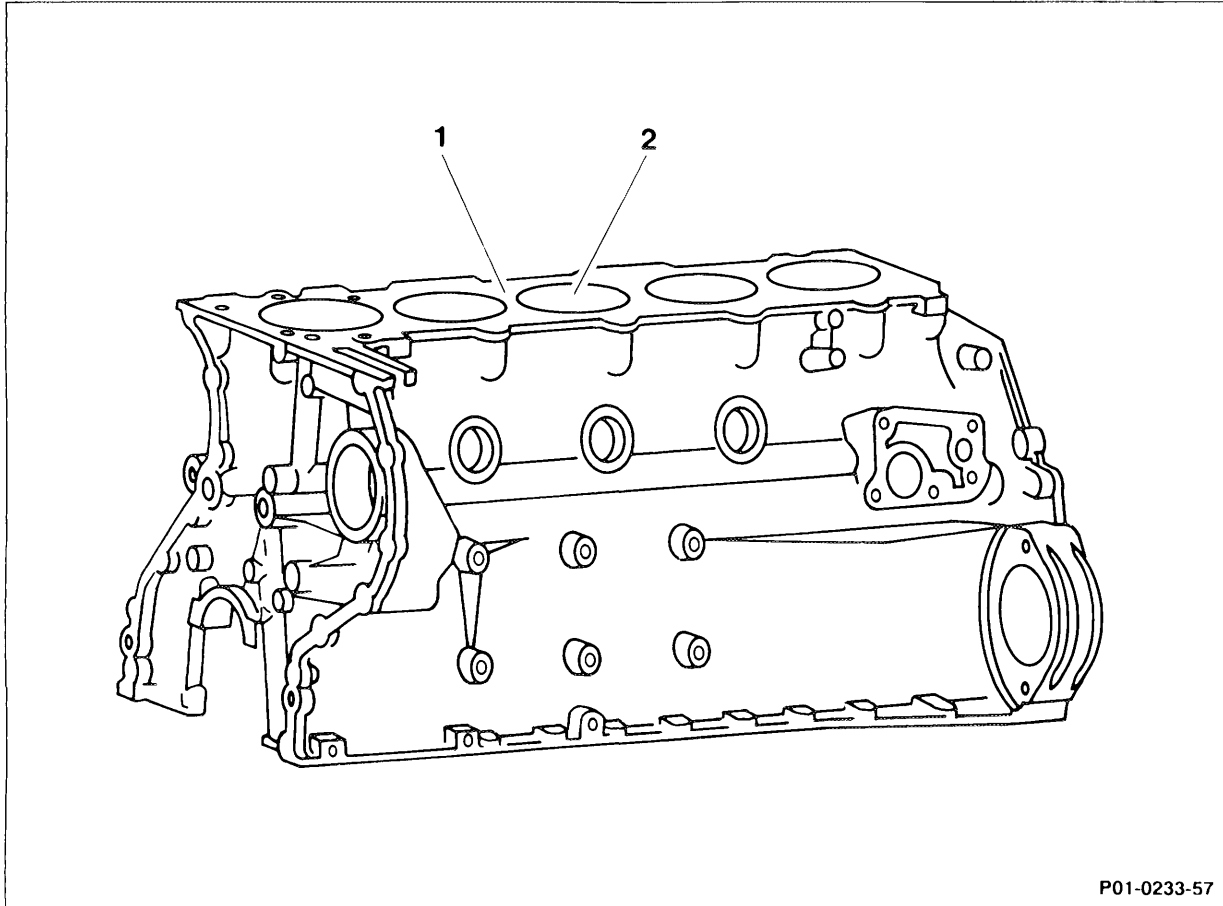


01-120 Planing crankcase parting surface

Preliminary operations:

Piston extension checked and pistons removed (03-316).



P01-0233-57

Parting surface (1) plane according to operating instructions for planing tool used.

Note

Observe specified dimensions and machining data!

Cylinder bores (2) chamfer at top of cylinder.

After reassembly check engine timing (05-215).

Data

Height of block in new state from center of main bearing bore	234.97 – 235.03	
Minimum height after required material removal from center of main bearing bore	234.60	
Permissible unevenness of parting surface	in longitudinal direction	0.06
	in transverse direction	0.06
Permissible roughness of upper parting surface	0.006 – 0.016	
Permissible deviation in parallel between upper parting surface and lower parting surface in longitudinal direction	0.05	
Chamfer of cylinder bores	see figure	
Distance between piston crown and block parting surface	Projection max. 0.965	
	Projection min. 0.735	

Cylinder bore chamfer

