



- Cut off the section of the housing gasket protruding around the cylinder flange and mount 2 dowels.
- Apply sealing compound to the sections near the chain tunnel and mount the cylinder base gasket.

#### NOTE:

- To facilitate the installation of the cylinder, it is recommended to place a rubber band (see illustration) around the timing chain guide and the timing chain tensioner.
- Oil the piston, adjust the piston rings (piston rings must be turned 120° against each other) and mount the piston mounting ring.
- Only for 640 LC4 engines a black cylinder base gasket (0,7 mm thickness) is used, the other LC4 engines need the green gasket (0,5mm thickness).

- Slide the cylinder over the piston and remove the mounting ring.

#### CAUTION

APPLY PARTICULAR CARE WHEN MOUNTING THE CYLINDER! THE OIL SCRAPER RING IS EXTREMELY FRAGILE.

- Hook in the preassembled microfilter with the holding device onto the rear stud and mount the collar nuts (1) at the cylinder base.
- Tighten collar nuts with 40 Nm crosswise.
- Then mount the bracket (2) and attach the microfilter.

NOTE: The upper edge of the piston is higher than the upper edge of the cylinder when the cylinder is screwed down.

#### Mounting the cylinder head

- Check both dowels within the cylinder for proper fit.
- Mount cylinder head gasket and fit cylinder head.
- Oil the 4 bolt (threads and contact surfaces of bolt head) and then mount with new copper seal rings.

NOTE: To be able to increase the tightening torque, copper seal rings will replace the steel washers starting with the 2004 model.

- Tighten the collar screws crosswise in 2 stages up to the specified torque of 50 Nm (53 Nm starting with the 2004 model). Tighten the collar screws to 10 Nm during the first stage.

- Mount M8 collar nuts (3) on the front and rear side of cylinder and tighten.
- Mount and tighten bolts (4).
- Put a new seal ring on the chain guide bolt (5) and degrease the thread.
- Apply Loctite 243 to the thread of the chain guide bolt, mount and tighten it (30 Nm).

#### CAUTION

BEFORE MOUNTING THE CHAIN GUIDE BOLT MAKE SURE THAT THE OPENING OF THE TIMING CHAIN GUIDE IS VISIBLE THROUGH THE THREADED HOLE. IF THIS IS THE CASE THE CHAIN GUIDE BOLT CAN EASILY BE MOUNTED WITHOUT EXERTING EXCESSIVE FORCE.

# How To Rebuild 660 Engine Manual

**Jicheng Xie**



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