

- Diameter 94 mm of collar seating
Measure with precision caliper gauge (diameter of 94.000 to 94.054 mm in several directions, as per enclosure 5.3).
- Chamfer in receiving bore 94 mm
Visual check/continue run. This chamfer is important for proper seating of the liner collar (see enclosure 5.4).

5.2 Assembling slip fit liner

Attention: The slip fit liner, part No. 0417 0347 EB 0136-04, has a wall thickness of 1.5 mm. Storage, packaged or loose, only in upright position.

- Prior to installation, oil slip fit liner (motor oil) and then wipe off with clean rag.

- Place liner in upright position (check at 4 points with square) and then press down with thumb as far as it will go without tilting. Depending on the tolerance status of bore/liner, it may be necessary to press liner down as far as it will go by slightly knocking on wood block placed on liner using hammer shunt.



5.3 Checking slip fit liner (inserted)

- Protrusion of liner collar above crankcase surface should be 0.01 to 0.06 mm as per enclosure 5.4.
Check protrusion with precision depth gauge and magnetic stand at several points on the periphery of the collar. A liner protrusion true to drawing is vital for tight liner fit and tightness of the cylinder head gasket.
- Internal diameter/circularity of the slip fit liner is determined after installation of the fresh machined liner and the dimensional accuracy of the receiving bore. Thus only random measurement checks are required. On each crankcase with installed slip fit liner one cylinder only need be checked. The check is carried out similarly to the measurement program under section 5.1 (receiving bore 94 mm; diameter/circularity) on 3 measuring planes and in several measuring directions, during this procedure the crankshaft bearing cap must also be tightened according to specification.
As per enclosure 6, diameter = 91.000 to 91.020 mm and circularity $\phi = 0.010$ mm.

6. Drawings with dimensions

The form and location tolerances are identified in the sketches (date to DIN 7184 (corresponding to ISO R 1101) and dimensioned. See enclosure 5.5.

Enclosures:

- 6.1 Specimen of a measuring data sheet for receiving bore/liner diameter
- 6.2 Slip fit liner, part No. 0417 0347 EB 0136-04
- 6.3 Crankcase - remachining
 - longitudinal section
 - cross section
 - detail "liner collar seating"
- 6.4 Crankcase
 - with assembled slip fit liner
 - detail "protrusion"
- 6.5 Annex
 - Notes on location and form tolerances
 - Examples of measuring tools and gauges listed in section 2.2 and designation

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1. Understanding the eBook F11011 Repair Manual
 - The Rise of Digital Reading F11011 Repair Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying F11011 Repair Manual
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an F11011 Repair Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from F11011 Repair Manual
 - Personalized Recommendations

- FL1011 Repair Manual User Reviews and Ratings
- FL1011 Repair Manual and Bestseller Lists
- 5. Accessing FL1011 Repair Manual Free and Paid eBooks
 - FL1011 Repair Manual Public Domain eBooks
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 - FL1011 Repair Manual Budget-Friendly Options
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 - ePub, PDF, MOBI, and More
 - FL1011 Repair Manual Compatibility with Devices
 - FL1011 Repair Manual Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of FL1011 Repair Manual
 - Highlighting and Note-Taking FL1011 Repair Manual
 - Interactive Elements FL1011 Repair Manual
- 8. Staying Engaged with FL1011 Repair Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers FL1011 Repair Manual
- 9. Balancing eBooks and Physical Books FL1011 Repair Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection FL1011 Repair Manual
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine FL1011 Repair Manual
 - Setting Reading Goals FL1011 Repair Manual
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of FL1011 Repair Manual
 - Fact-Checking eBook Content of FL1011 Repair Manual

- Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
- 14. Embracing eBook Trends
 - Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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