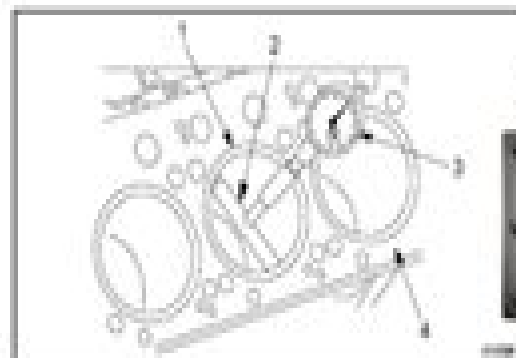


8. Measure the cylinder liner protrusion from the block. The specifications are listed in Table 1-32.

Description	Dimensions: mm (in.)
Cylinder Liner Protrusion from Block, see Figure 1-32, Ref. A	0.120-0.130 (0.009-0.010)
Height of the Cylinder Liner Gudge, see Figure 1-32	60.15-62.12 (2.367-2.446)
Depth of the Gudge Groove, see Figure 1-32	0.050-0.070 (0.001-0.003)
Thickness of the Gudge Iron	0.14-0.16 (0.005-0.006)

Table 1-32 Cylinder Liner Installation Tolerances

9. Measure the inside diameter of the cylinder liner and check for out of round, see Figure 1-37.



1. Cylinder Liner
2. Dial Gauge
3. Gudge
4. Cylinder Block

Figure 1-37 Measuring the Cylinder Liner Inside Diameter

- (a) Measure at three different locations 90 degrees apart at the area of the two O-rings.
- (b) Compare the three measurements. If they differ by more than the maximum allowable out of round listed in Table 1-32, remove the cylinder liner and inspect the two O-rings and their seating area in the cylinder block.
- (c) If the O-rings are damaged, replace them.
- (d) Check the out of round again until it meets specifications.
10. Install the piston. Refer to section 1.18.1.

1.4 EGR CYLINDER HEAD AND BLOCK

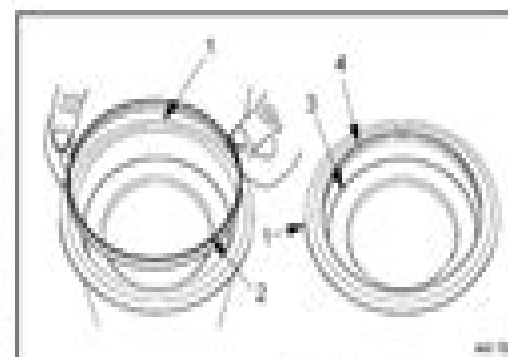
There are several major changes in the cylinder liner, block and gudge when comparing between the MBE 4000 EGR engine and the non-EGR engine.

1.4.1 EGR Cylinder Head Installation

Be aware of the following notice when installing the cylinder head on an EGR engine:

NOTICE:

Be sure the carbon scraper ring is seated in the groove on the top part of the cylinder liner before installing a new cylinder head gasket and the cylinder head, otherwise component damage can result. See Figure 1-38.



1. Cylinder Liner
2. Carbon Scraper Ring
3. Installed Piston
4. Carbon Scraper Ring seated in groove in cylinder liner

Figure 1-38 Installed Carbon Scraper Ring

NOTE:

All remaining installation procedures for the cylinder head are identical to a non-EGR engine.

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