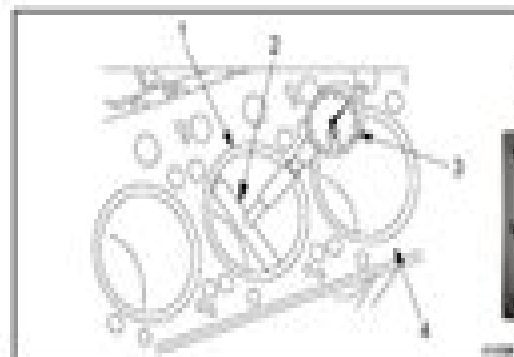


8. Measure the cylinder liner protrusion from the block. The specifications are listed in Table 1-32.

| Description                                                   | Dimensions: mm (in.)      |
|---------------------------------------------------------------|---------------------------|
| Cylinder Liner Protrusion from Block, see Figure 1-36, Ref. A | 0.120-0.130 (0.008-0.010) |
| Height of the Cylinder Liner Gudge, see Figure 1-36           | 60.15-62.12 (2.367-2.446) |
| Depth of the Gudge Bush, see Figure 1-36                      | 0.050-0.070 (0.001-0.003) |
| Thickness of the Gudge Bush                                   | 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 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

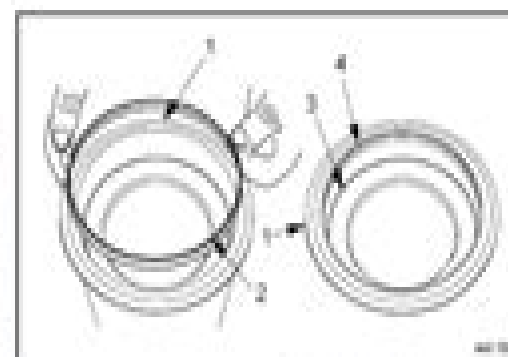
There are several major changes in the cylinder liner, block and gudge when comparing between the MBE 4000 EGR engine and the non-EGR engine.

### 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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**SJ Ball**



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