

- 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. Ex enclosure 6.3.

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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