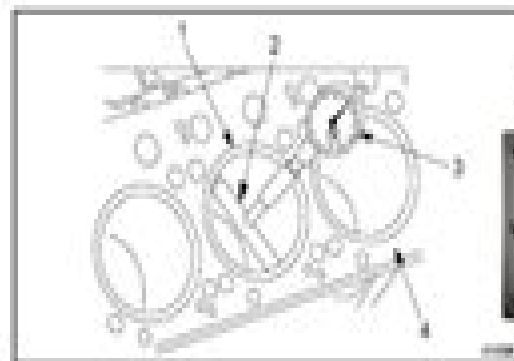


8. Measure the cylinder liner protrusion from the block. The specifications are listed in Table 1-32.

Description	Dimensions: mm (in.)
Cylinder Liner Protrusion from Block, see Figure 1-32, Ref. A	0.120-0.130 (0.008-0.010)
Height of the Cylinder Liner Gudge, see Figure 1-32	61.15-62.12 (2.367-2.446)
Depth of the Gudge Groove, see Figure 1-32	0.050-0.055 (0.0019-0.0022)
Thickness of the Gudge Iron	0.14-0.16 (0.0055-0.0063)

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 Gage
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

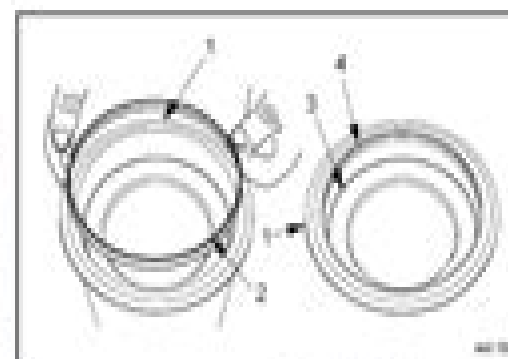
There are several major changes in the cylinder liner, block and gudge lifter assemblies between the MBE 4000 EGR engine and the non-EGR engine.

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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1. Understanding the eBook Mbe 4000 Shop Manual
 - The Rise of Digital Reading Mbe 4000 Shop Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying Mbe 4000 Shop 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 Mbe 4000 Shop Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from Mbe 4000 Shop Manual
 - Personalized Recommendations
 - Mbe 4000 Shop Manual User Reviews and Ratings
 - Mbe 4000 Shop Manual and Bestseller Lists
5. Accessing Mbe 4000 Shop Manual Free and Paid eBooks
 - Mbe 4000 Shop Manual Public Domain eBooks
 - Mbe 4000 Shop Manual eBook Subscription Services
 - Mbe 4000 Shop Manual Budget-Friendly Options
6. Navigating Mbe 4000 Shop Manual eBook Formats
 - ePub, PDF, MOBI, and More
 - Mbe 4000 Shop Manual Compatibility with Devices
 - Mbe 4000 Shop Manual Enhanced eBook Features
7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Mbe 4000 Shop Manual
 - Highlighting and Note-Taking Mbe 4000 Shop Manual
 - Interactive Elements Mbe 4000 Shop Manual
8. Staying Engaged with Mbe 4000 Shop Manual

- Joining Online Reading Communities
- Participating in Virtual Book Clubs
- Following Authors and Publishers Mbe 4000 Shop Manual
- 9. Balancing eBooks and Physical Books Mbe 4000 Shop Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Mbe 4000 Shop Manual
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Mbe 4000 Shop Manual
 - Setting Reading Goals Mbe 4000 Shop Manual
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Mbe 4000 Shop Manual
 - Fact-Checking eBook Content of Mbe 4000 Shop 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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