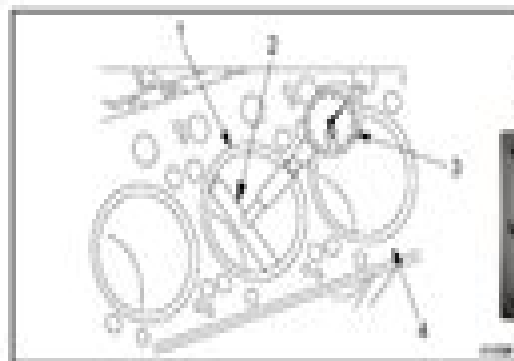


8. Measure the cylinder bore protrusion from the block. The specifications are listed in Table 1-32.

Description	Dimensions: mm (in.)
Cylinder Bore Protrusion from Block, see Figure 1-36, Ref. A	0.120-0.130 (0.008-0.010)
Height of the Cylinder Bore Gasket, see Figure 1-36	16.15-16.17 (0.636-0.636)
Depth of the Gasket Groove, see Figure 1-36	0.050-0.055 (0.0019-0.0022)
Thickness of the Gasket	0.14-0.16 (0.0055-0.0063)

Table 1-32 Cylinder Liner Installation Tolerances

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



1. Cylinder Liner
2. O-ring
3. O-ring Groove
4. Cylinder Block

Figure 1-37 Measuring the Cylinder Liner Inside Diameter

- (a) Measure at three different locations 90 degrees apart in 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 bore 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

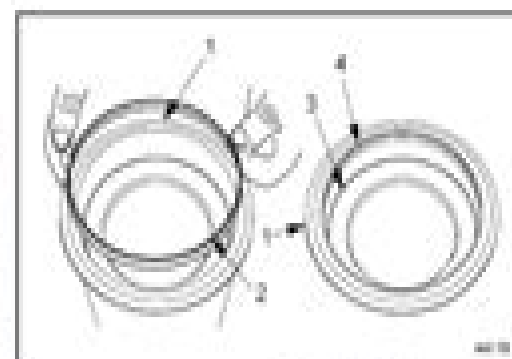
There are several major changes in the cylinder bore, block and engine before headless between the MBE 4000 EGR engine and the non-EGR engine.

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

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Michal Rosen-Zvi



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