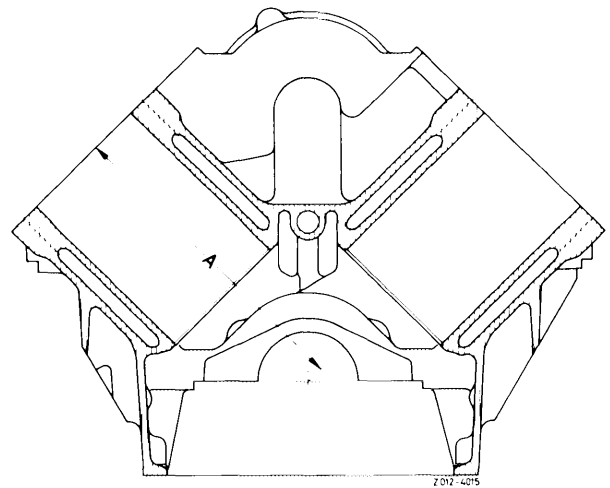


## 01–120 Facing cylinder crankcase parting surface

### Data

Engine	116	117
Height "A" of cylinder crankcase when new	215.85–216.0	244.85–245.0
Minimum height following required removal of material <sup>1)</sup>	215.65	244.65
Permissible deviation from parallel of upper parting surfaces in relation to crankshaft center	in longitudinal direction	0.08
	in transverse direction	0.05
Permissible deviation from flat of upper parting surface		0.02
Mean roughness (Rz) of upper parting surface		0.02
Test pressure in coolant chamber with air under water in bar gauge pressure		3
Distance from piston crown to parting surface of crankcase		refer to 03–316
Chamfer of cylinder bores		refer to note

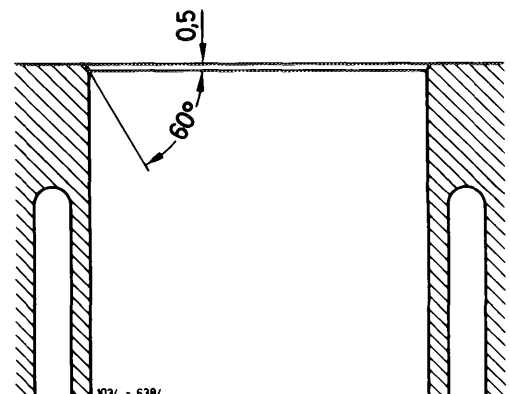
<sup>1)</sup> Material removal on cylinder crankcase and on cylinder head of an engine should together not exceed max. 0.5 mm (refer to 01–418).

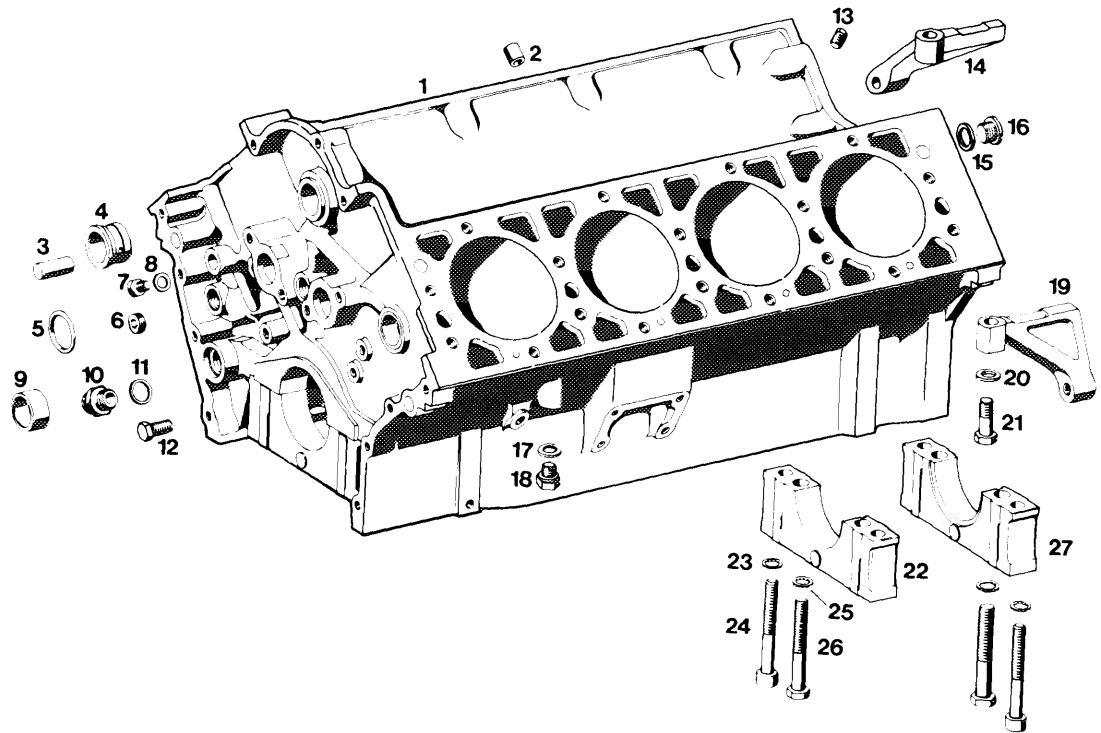


### Note

Chamfer cylinder bores after facing.

If the cylinder crankcase parting surface has been reconditioned, reset the timing (05–215).





1032-7932

- |    |   |    |   |
|----|---|----|---|
| 1  | Cylinder crankcase                      | 15 | Sealing ring                            |
| 2  | Set sleeves (4 each)                    | 16 | Screw plug                              |
| 3  | Cyl. pin 12h 8 x 14                     | 17 | Sealing ring                            |
| 4  | Bearing bushing guide wheel             | 18 | Plug AM 14 x 1.5                        |
| 5  | Sealing ring                            | 19 | Supporting angle left                   |
| 6  | Tapered plug                            | 20 | Washer A 10.5                           |
| 7  | Closing plug M 8 x 1                    | 21 | Screw M 10 x 40                         |
| 8  | Sealing ring                            | 22 | Crankshaft bearing cap                  |
| 9  | Bearing bushing intermediate gear shaft | 23 | Washer                                  |
| 10 | Screw connection                        | 24 | Hex. socket screw M 10 x 75             |
| 11 | Sealing ring                            | 25 | Washer                                  |
| 13 | Closing plug                            | 26 | Hex. screw M 12 x 80                    |
| 14 | Supporting angle right                  | 27 | Crankshaft bearing cap (fitted bearing) |