Data

Height of new crankcase	213.1—213.2
Min. height after removal of necessary material	212.8
Permissible deviation from parallel of upper parting surface in relation to lower parting surface in longitudinal direction	0,1
Permissible deviation from flatness of upper parting surface	0,03
Mean height of roughness of upper parting surface	0,005—0,020
Leak test with 1.5 bar air gauge pressure under water. Permissible leak rate in cc/min	10
Chamfer of cylinder bores	see note

Piston spacing in relation to parting surface

Engines with		normal compression		USA version and low compression	
Distance between piston crown and crankcase mating surface	Standard size piston	Below	min. 0.20 max. 0.70	above 0.25 below 0.15	
	Oversizes + 0.5 and 1.0	Below	min. 1.0 max. 1.5	below	min. 0.55 max. 0.95

Conventional tools

Surface grinding machine	e.g. made by Ruaro u. Fi., Schio/Italy Scledum, type RTY
Knife-edge straightedge approx. 750 mm long	

Note

Chamfer cylinder bores after grinding.

Adjust valve timing (05—215), if crankcase mating surface has been machined.