

**Data**

Standard dimension		92.00
		92.02
Repair stages		92.50
		92.52
		93.00
		93.02
Max. wear limits of cylinder bores in forward or transverse direction at upper reversing point of 1st piston ring		0.10
Piston clearance	when new	0.02–0.03
	wear limit	0.08

**Machining tolerances**

Permissible deviation from cylinder shape	when new	0.013
	wear limit	0.05
Permissible deviation from square with reference to cylinder height		0.05
Mean roughness (Rz)		0.003–0.005
Permissible waviness		50 % of roughness
Chamfer of cylinder bores		refer to Fig., item 2

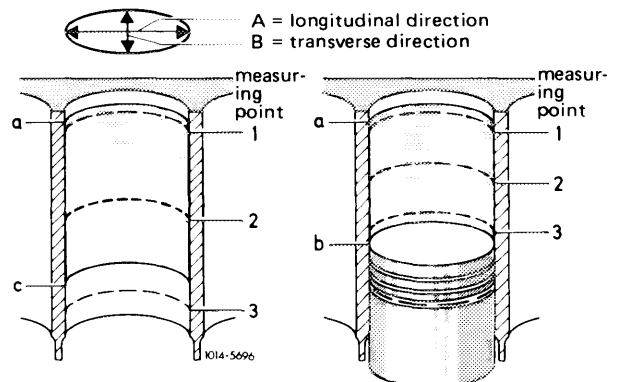
**Note**

In addition to a visual checkup, in particular in the event of complaints about "high oil consumption", measuring of cylinder bores is unavoidable.

1 Measure cleaned cylinder bores with an internal measuring instrument at measuring points 1, 2 and 3 in longitudinal direction A (piston pin center line) and in transverse direction B.

On the installed piston, the measuring point 3 is just above the piston, which should be at TDC.

- a upper reversing point of 1st piston ring
- b BDC of piston
- c lower reversing point of oil wiper ring



2 Chamfer cylinder bores after boring.

For honing, the material allowance should not exceed 0.05 mm.

