

Cylinder Block and Liners

CYLINDER BLOCK AND LINERS

Flanged cast iron liners of the 'dry' type are fitted and they are an interference fit in the cylinder block parent bore, see Data.

Check the cylinder block for cracks or other damage and check the top deck for distortion in the same way as in the "Cylinder Head" Section.

Check the cylinder liners for score marks, waviness and wear, Fig. 1. The measurements should be taken in the X—X and Y—Y axes at each of the three positions, upper, middle and lower, see Fig. 2.

If the wear of any cylinder liner exceeds 0,15 mm (0.006 in) then **all** the liners should be rebored and honed to the next practical oversize.

Oversize pistons and rings are available for plus
 0,254 mm (0.010 in)
 0,508 mm (0.020 in)
 0,762 mm (0.030 in)

Always rebores **ALL** six liners to the same size, even if only one of them requires such work.

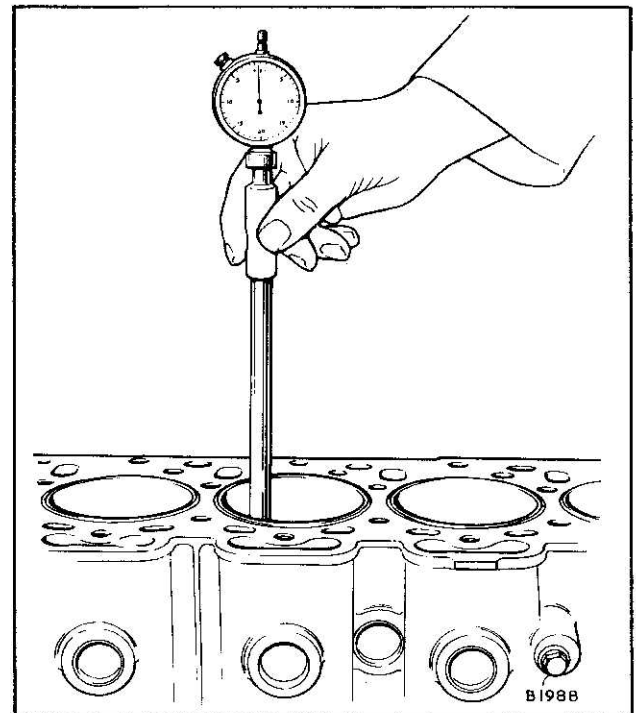


Fig. 1

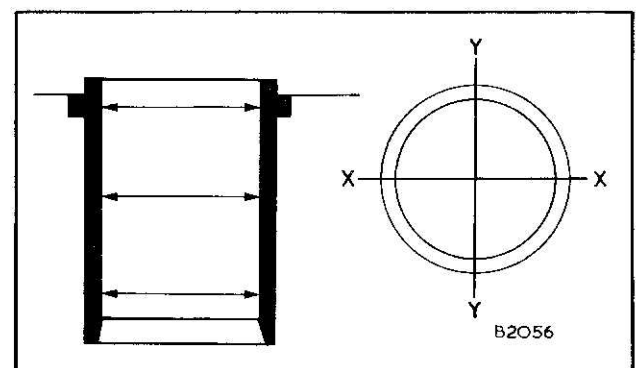


Fig. 2

To Renew Cylinder Liner

Using the liner replacer/remover tool, press out liner.

Clean the cylinder block parent bore and the liner recess.

Lightly lubricate the new liner and press in fully, in one continuous operation.

Check the liner height in relation to the cylinder block top face, see Fig. 3.

Bore and hone the liner to the dimensions given in Data.

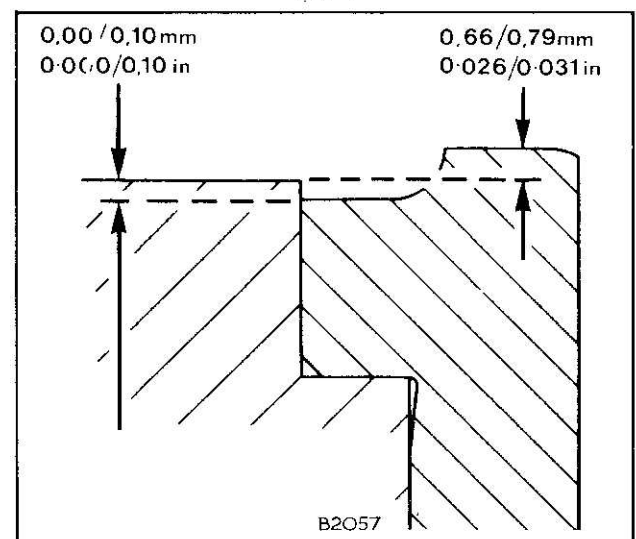


Fig. 3