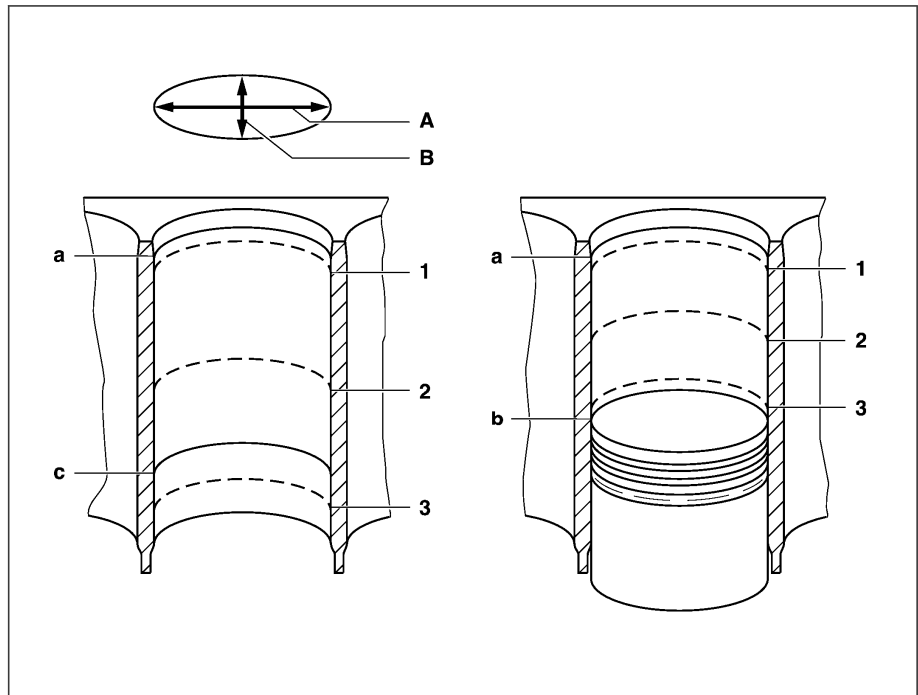


AR01.40-P-9202T	Measure cylinder bores	12.07.2022
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
- Engine 626
- Engine 646.8
- Engine 646.951/961/962/963/966
- Engine 647.961
- Engine 648.960
- Engine 651

- 1 Cylinder bore measuring point
- 2 Cylinder bore measuring point
- 3 Cylinder bore measuring point
- A Longitudinal direction
- B Transverse direction
- a Upper reversal point of 1st piston ring
- b Bottom dead center of piston
- c Bottom reversal point of oil scraper ring



P01.40-0228-06

Picture no., etc.	Work notes		
1, 2, 3	Cylinder bore measuring points	Engine 646 ⓘ Measure cleaned cylinder bores with inside caliper at cylinder bore measuring points (1, 2, 3) in longitudinal direction (A) and transverse direction (B). ⓘ Engine 646.8 Engine 646.951/961/962/963/966 Cylinder liner dia. ⓘ Cylinder liner Cylinder liner ⓘ Cylinder liner Cylinder liner ⓘ Mount dial indicator	BE01.40-P-1001-01M BE01.40-P-1002-01M BE01.40-P-1003-01M 001 589 93 21 00
1, 2, 3	Cylinder bore measuring points	Engine 647, 648	

		<p> Measure cleaned cylinder bores with inside caliper at cylinder bore measuring points (1, 2, 3) in longitudinal direction (A) and transverse direction (B).</p> <p> Cylinder liner</p> <p> Cylinder liner</p> <p> Cylinder liner dia.</p> <p> Mount dial indicator</p>	<p>BE01.40-P-1004-01E</p> <p>BE01.40-P-1003-01E</p> <p>BE01.40-P-1001-01E</p> <p>001 589 93 21 00</p>
1, 2, 3	Cylinder bore measuring points	<p>Engine 651</p> <p> Measure cleaned cylinder bores with inside caliper at cylinder bore measuring points (1, 2, 3) in longitudinal direction (A) and transverse direction (B).</p> <p> Cylinder liner dia.</p> <p> Mount dial indicator</p>	<p>BE01.40-P-1001-01O</p> <p>001 589 93 21 00</p>
1, 2, 3	Cylinder bore measuring points	<p>Engine 626</p> <p> Measure cleaned cylinder bores with inside caliper at cylinder bore measuring points (1, 2, 3) in longitudinal direction (A) and transverse direction (B).</p> <p> Dia. of cylinder bore</p> <p> Mount dial indicator</p>	<p>BE01.40-P-1001-01T</p> <p>001 589 93 21 00</p>

 Check values for cylinder bore

Number	Designation	Engine 647, 648		
BE01.40-P-1001-01E	Cylinder liner dia.	Standard dimension	mm	88,0
		Group code letter A	mm	88,000...88,006
		Group code letter X	mm	88,006...88,012
		Group code letter B	mm	88,012...88,018

 Check values for cylinder bore

Number	Designation			Engine 646.951/961/962 /963/966	Engine 646.8
BE01.40-P-1001-01M	Cylinder liner dia.	Standard dimension	mm	88,0	88,0
		Group code letter A	mm	88,000...88,006	88,000...88,006
		Group code letter X	mm	88,006...88,012	88,006...88,012
		Group code letter B	mm	88,012...88,018	88,012...88,018
		Repair stage 1 Cylinder group +5	mm	88,050	88,050
		Repair stage 2 Cylinder group +10	mm	88,100	88,100
		Repair stage 3 Cylinder group +50	mm	88,500	–

 Check values for cylinder bore

Number	Designation			Engine 651
BE01.40-P-1001-01O	Cylinder liner dia.	Standard dimension	mm	83,007
		Group code letter X	mm	83,000...83,014
		Repair stage 1 cylinder group +60	mm	83,600...83,660

 Check values for cylinder bore

Number	Designation			Engine 626
BE01.40-P-1001-01T	Dia. of cylinder bore	Standard size	mm	80,004...80,034
		Out-of-roundness (in new condition)	mm	0,01
		Wear limit in longitudinal and transverse direction	mm	0,03

 Check values for cylinder bore

Number	Designation			Engine 646.951/961/962 /963/966	Engine 646.8
BE01.40-P-1002-01M	Cylinder liner	Wear limit in longitudinal and transverse direction	mm	0,020	0,020

 Check values for cylinder bore

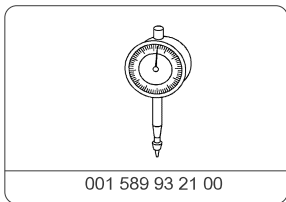
Number	Designation			Engine 647, 648
BE01.40-P-1003-01E	Cylinder liner	Wear limit in longitudinal and transverse direction	mm	0,020

 Check values for cylinder bore

Number	Designation	Engine 646.951/961/962 /963/966	Engine 646.8
BE01.40-P-1003-01M	Cylinder liner	Permissible difference of cylinder shape (when new) mm	0,000...0,007
			0,000...0,007

 Check values for cylinder bore

Number	Designation	Engine 647, 648
BE01.40-P-1004-01E	Cylinder liner	Permissible difference of cylinder shape (when new) mm
		0,000...0,007
		Wear limit mm
		—



Mount dial indicator