## Data

Engine Height ,,A'' of the crankcase when new Minimum height of the necessary material removal <sup>1</sup> )		116.96	117.96	
		216.35-216.45	245.35-245.45	
		216.20	245.20	
Permissible deviation from the parallel of the upper mating surfaces to the crankshaft center	in longitudinal direction	n 0.08		
	in transverse direction	0.05		
Permissible deviation from evenness of the upper mating surfaces		0.02		
Mean roughness (Rz) of the upper mating surfaces		0.0060.016		
Test pressure: water jacket with air under water in bar		3	3	
Distance from piston crown to crankcase mating surface		see O	see 03-316	
Cylinder bore chamfer		see Note		

<sup>1</sup>) The total material removed from crankcase and cylinder head of an engine may not exceed 0.5 mm (see 01--418).



## Note

After facing the surfaces, chamfer the cylinder bores. Smooth out the lower edge of the chamfer with a polishing stone.

If the crankcase mating surface was remachined, the valve timing has to be adjusted again (05-215).

