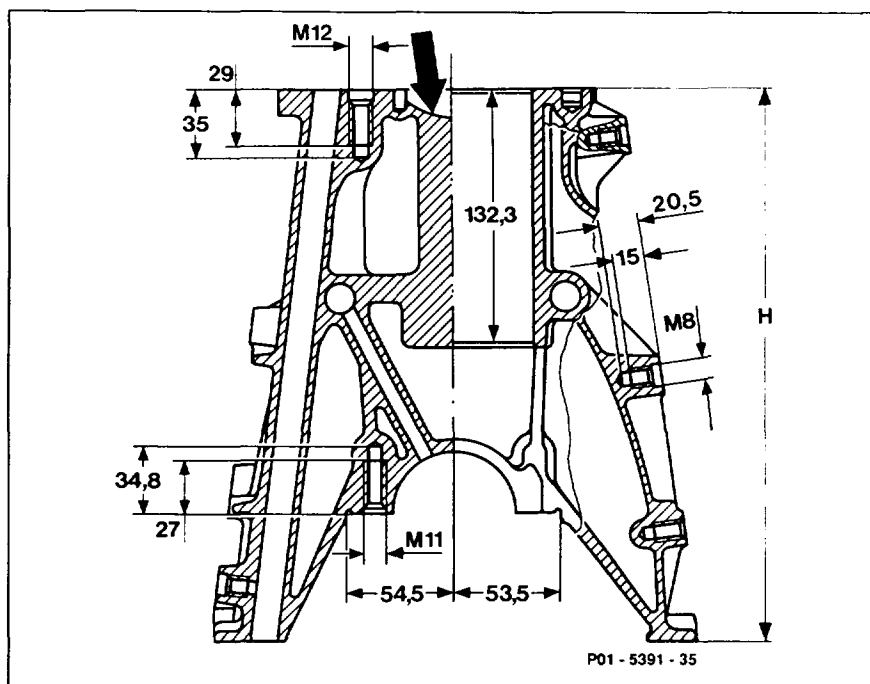


## 01-1200 Facing crankcase contact surface

Preceding work:  
Engine disassembled

Operation no. of operation texts and work units or standard texts  
and flat rates



Crankcase engine 103.980

### Data

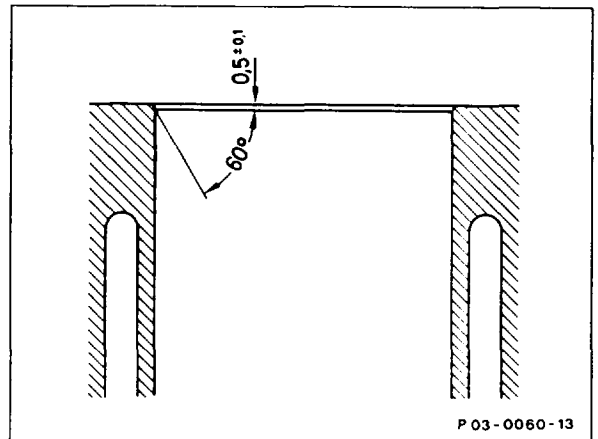
Height "H" of crankcase when new	282.25 - 282.35	
Minimum height after necessary stock removal <sup>1)</sup>	281.95	
Permissible unevenness	top crankcase contact surface	0.03
	bottom crankcase contact surface	0.04
Permissible deviation of parallelism of top to bottom crankcase contact surface in longitudinal direction	0.1	
Peak-to-valley height (Rz)	top crankcase contact surface	0.005 - 0.020
	bottom crankcase contact surface	0.025
Test pressure with air under water in bar gauge	1.5	
Chamfer of cylinder bores	see note	

<sup>1)</sup> The stock removal at the crankcase and cylinder head of an engine must together be not more than 0.5 mm (see 01-4180).

**Note**

Face crankcase together with timing case cover.

After facing the cylinder bores, chamfer according to sketch.



Chamfer cylinder bores with a suitable handmilling cutter as shown in the sketch. Smooth bottom edge of chamfer with polishing stone.

If the crankcase contact surface is remachined, the timing of the camshaft must be checked (05-2150) and the piston projection checked (03-3160).

