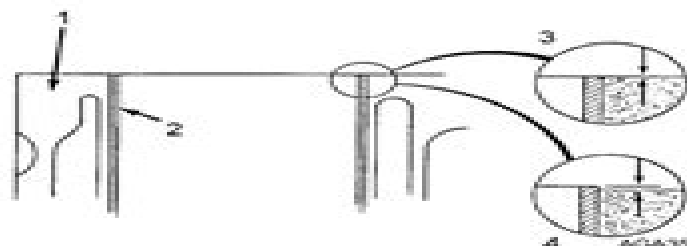


Spray oil on the outside of the cylinder sleeve or on the inside of the cylinder bore in the block.

Place the cylinder sleeve in the block and press the sleeve into place. The pressing load should be 2200 to 4400 lb. (1000 to 2000 kg).

The top of the cylinder sleeve must be flush with the top of the block. The cylinder sleeve cannot protrude above the top of the block at all.



1.	Cylinder Block
2.	Cylinder Sleeve
3.	The cylinder sleeve must be flush.
4.	The cylinder sleeve cannot protrude above the block.

Figure 53: Cylinder Sleeve Installation

d. Bore and hone each cylinder sleeve to obtain the correct piston clearance.

4. Measure each piston. Bore and hone each cylinder to obtain the correct piston to cylinder wall clearance (see Specifications).



CAUTION: The pistons will vary slightly in diameter. Therefore, each piston must be measured and each cylinder must be bored and honed to match each piston.

The final surface finish in the cylinders should have an RA (Roughness Average) of 10 to 35 micro inches (0.25 to 0.90 microns).

5. Measure the front camshaft bearing insert. If the front camshaft bearing insert is larger than 1.7756 in. (45.100 mm) on Tier 1 and earlier engines, 1.7768 in. (45.130 mm) on Tier 2 engines, or has a damaged surface, remove the bearing insert with a bearing driver. If the block will be boiled out, remove the bearing insert and all the core plugs.

NOTE: The middle and rear camshaft bearings do not have bearing inserts.

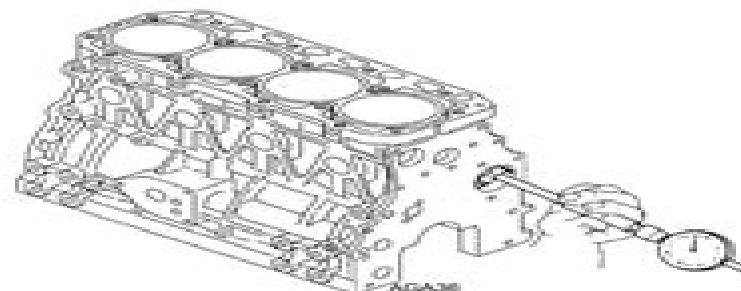


Figure 54: Measuring Front Camshaft Bearing Insert

6. This engine does not have middle and rear camshaft bearing inserts. The bearing surfaces for middle and rear camshaft bearings are machined into the block. Measure the middle and rear camshaft bearings. If the middle or rear camshaft bearings are larger than 1.7756 in. (45.100 mm), or if the surfaces have been damaged significantly, replace the block.

Minor damage to the middle and rear camshaft bearings can be cleaned up with a brake cylinder hone. The middle and rear camshaft bearings should also be lightly honed after the block has been boiled out.

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Michal Rosen-Zvi



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