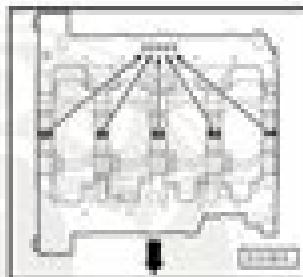


Cylinder block

The identification of the cylinder block can optionally point towards the sealing surface of the oil pan (various points in direction of travel) or can be offset on the front side of the cylinder block (gearbox side).

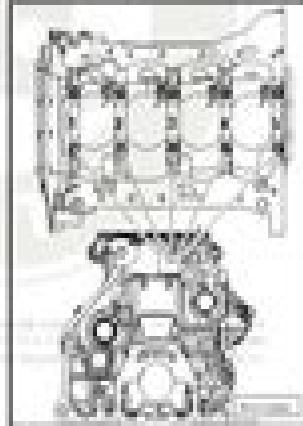


The identification on the cylinder block is valid for the upper bearing shell (bearing shell for the cylinder block).

- Note the characters and select the colour coding to be marked by referring to the table.

Crankshaft

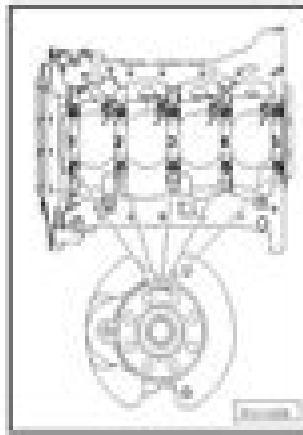
Identification character: Lower bearing shell for the upper bearing shell (bearing shell for the cylinder block).



The identification on the crankshaft is valid for the lower bearing shell (bearing shell for bearing cover).

- Note the characters and select the colour coding to be marked by referring to the table.

Letter	Bearing colour coding
B	black
R	red
B	blue
G	yellow
W	white



4 Pistons and connecting rods

4.1 Summary of components

1 - Crankshaft bolt, 80 Nm + torque + further + 90° (1/2 turn)

- Q replace
- Q oil drain and contact surface

2 - Crank bearing cap

- Q Check fitting position
- Q as a result of the caps separated in the cracking process, the cover fits only in one position and only to the relevant cover!
- Q mark matching cylinder side
- Q Fitting position: Markings all point towards the belt pulley side

3 - Bearing shells

- Q pay attention to correct installation position [a.2000.11](#)
- Q do not use up-used bearing shells
- Q Add play when new: 0.10...0.30 mm
- Q Wear limit: 0.4 mm

4 - Pressure relief valve, 27 bar

- Q Opening pressure: 0.10...0.15 MPa (1.0...1.5 bar) overpressure

5 - Oil injection nozzle

- Q for piston cooling

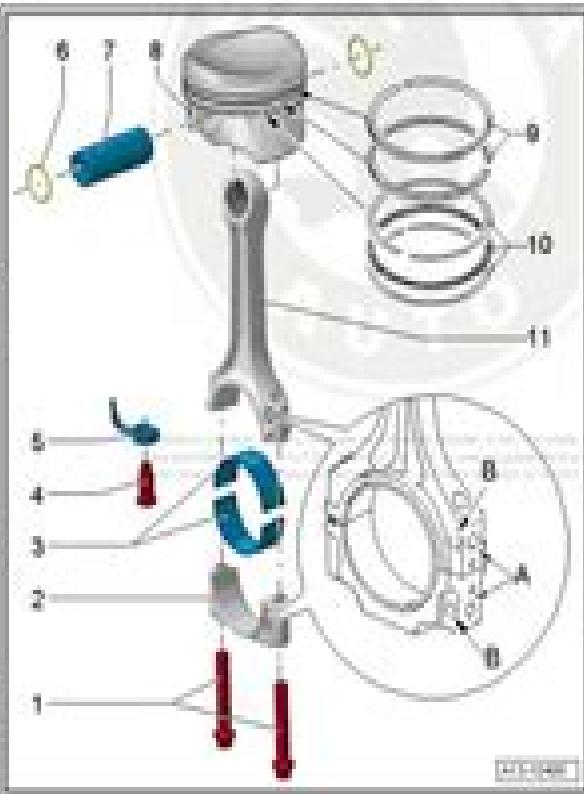
6 - Crimp

7 - Piston pins

- Q if stiff, heat piston to 60°C
- Q use tool A/FH 222 A for removing and installing

8 - Piston

- Q mark installation position and matching cylinder
- Q stamp on the piston crown faces towards the belt pulley side
- Q use piston ring tensioning strap for installing
- Q check [a.2000.42](#)
- Q inspect cylinder bore [a.2000.42](#)
- Q Piston Ø 82.465 mm (nominal dimension)
- Q Cylinder Ø 82.51 mm (nominal dimension)



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