

## Checking Cylinders

Special Tools: P 13c Cylinder gauge setting ring

### Cast Iron Cylinders

The following tables are valid only for the 1600 engine which is equipped with cast iron cylinders.

Wear limit for piston to cylinder wall clearance is 0.2 mm (.0078 in.). This clearance may not be measured by a feeler gauge but must be determined by measuring both piston and bore.

#### Standard Size

Group	Cylinder Tolerance	Piston size
-1	82.485 82.494	82.44
0	82.495 82.504	82.45
+1	82.505 82.514	82.46

The measurement should be taken approx. 30 mm ( $1\frac{3}{16}$  in.) from the bottom of the bore.

Measurement should be made using a standard bore gauge and setting ring P 13c.

#### First Oversize

Group	Cylinder Tolerance	Piston size
-1 KD	82.985 82.994	82.94
0 KD	82.995 83.004	82.95
+1 KD	83.005 83.014	82.96

These tables show which cylinder and piston sizes fit together.

The piston to cast iron cylinder wall clearance is 0.041 to 0.059 mm (.0016 to .0023 in.).

Cylinders worn close to the wear limit should be replaced.

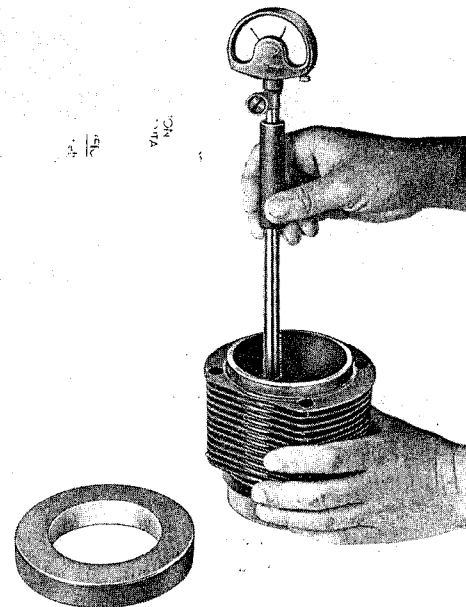


Fig. 166