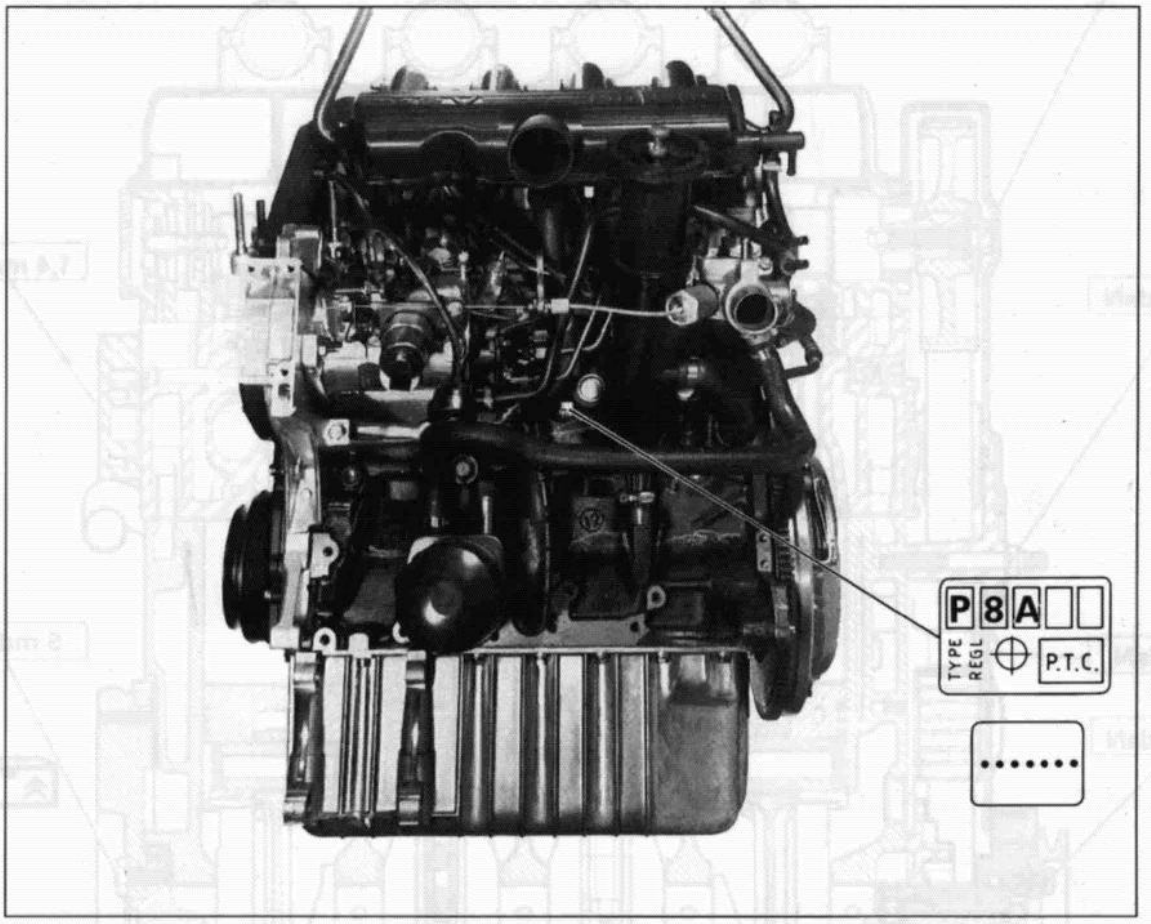
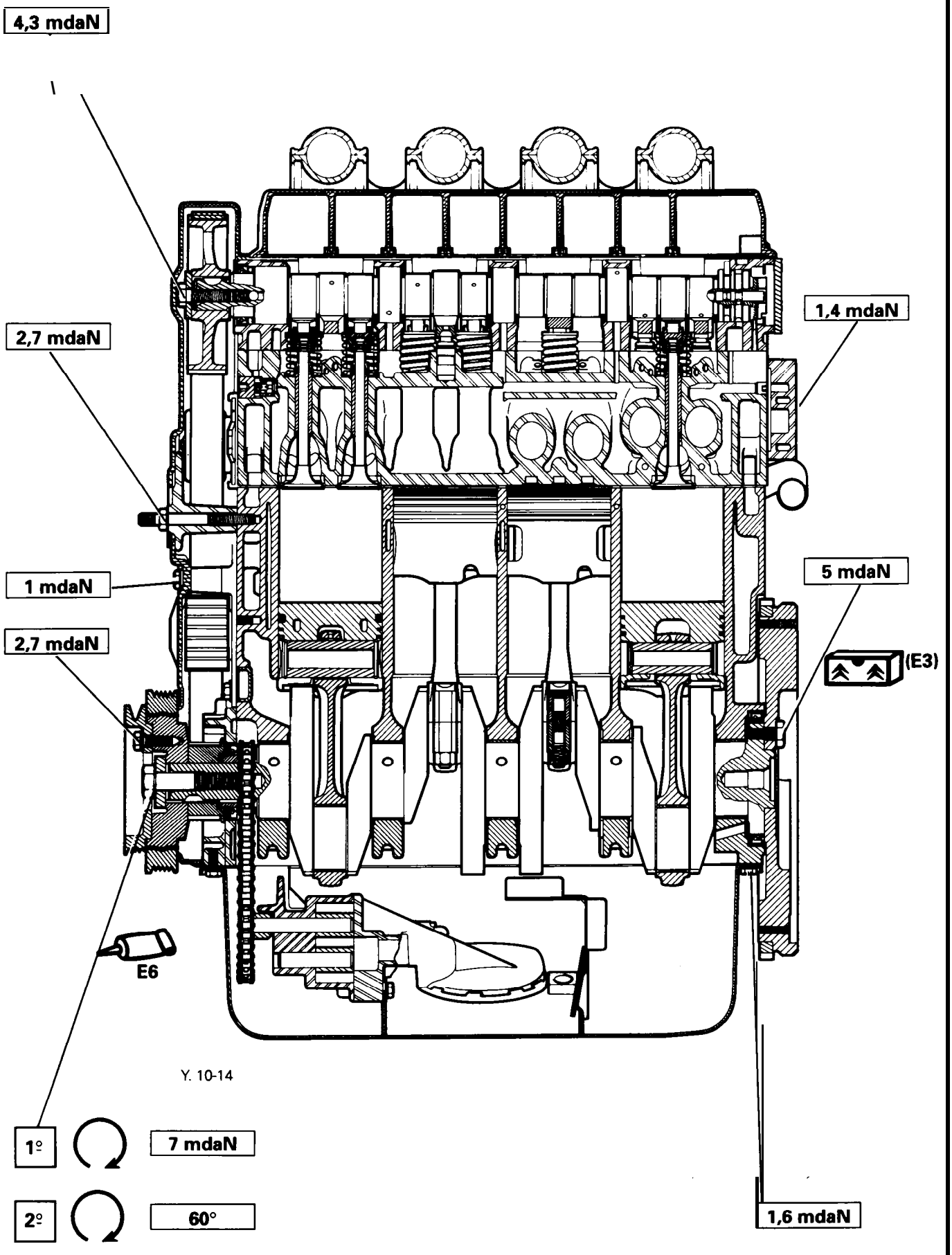
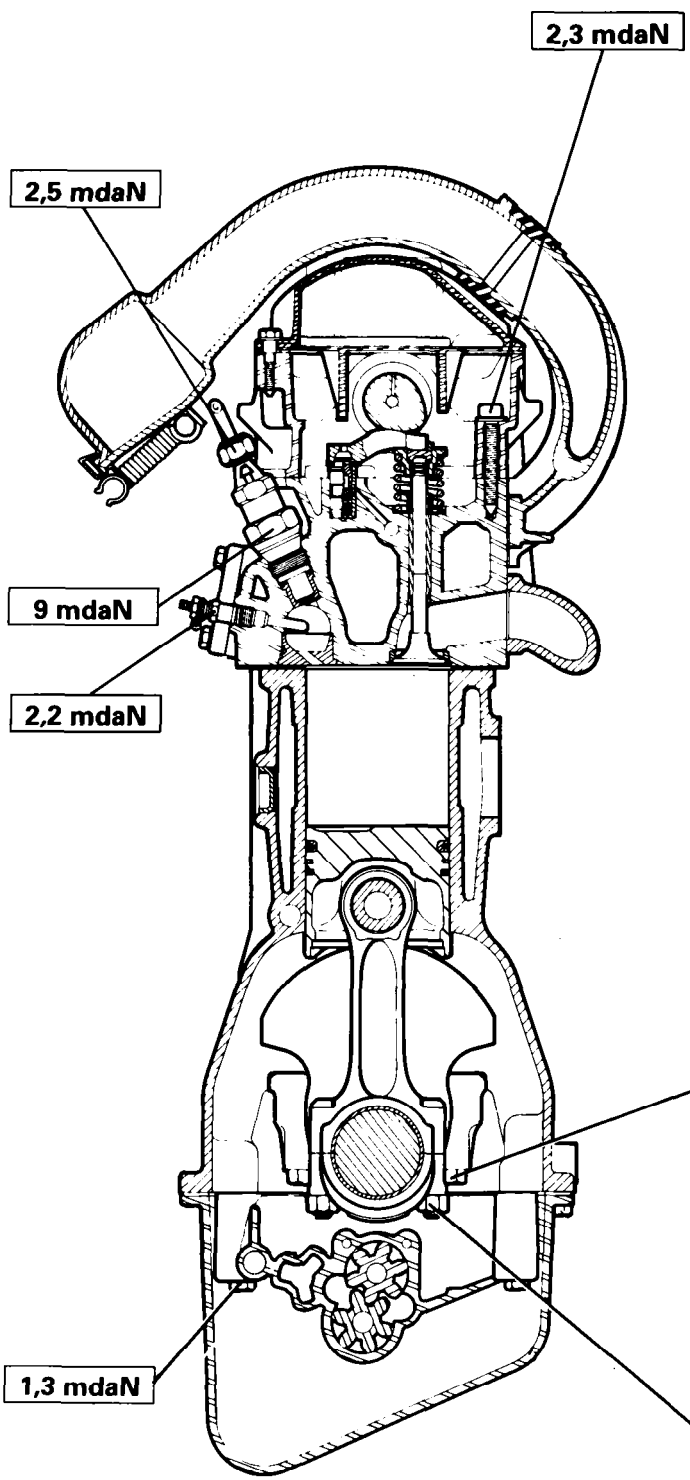


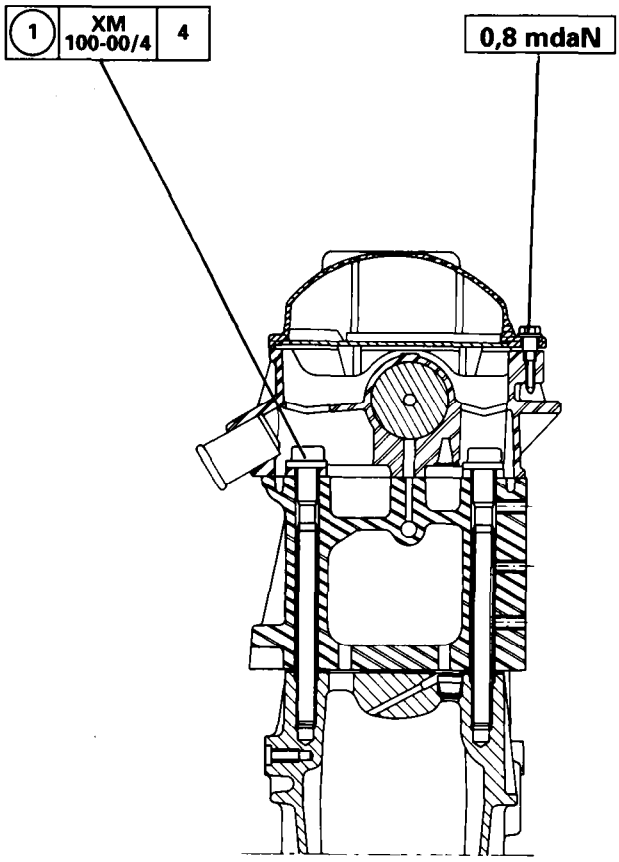
89-1237

4 CYL. P 8 A

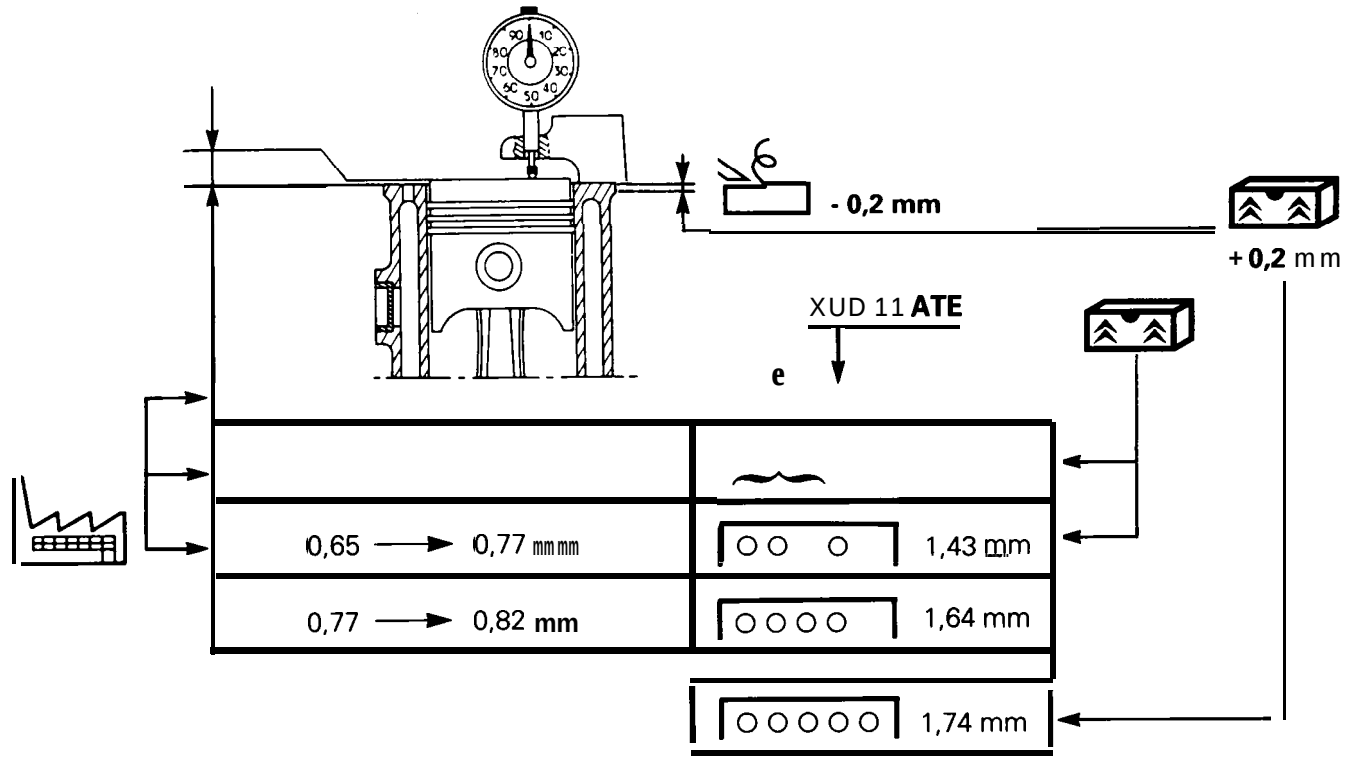

4,3 mdaN
2,7 mdaN
1 mdaN
2,7 mdaN
1,4 mdaN
5 mdaN
(E3)
E6
Y. 10-14
1º
7 mdaN
2º
60°
1,6 mdaN

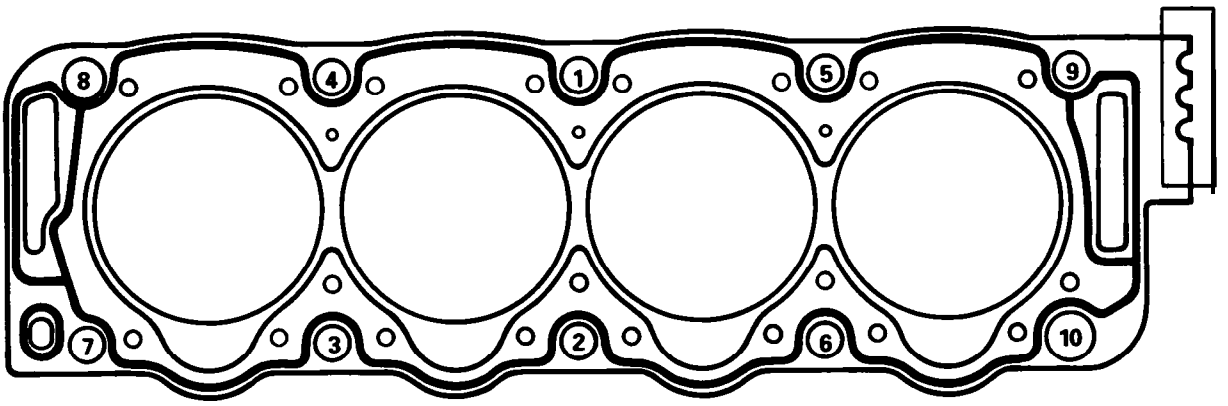

2,3 mdaN
2,5 mdaN
9 mdaN
2,2 mdaN
1,3 mdaN
1º
1,5 mdaN
2º
60°
1º
2 mdaN
2º
70°

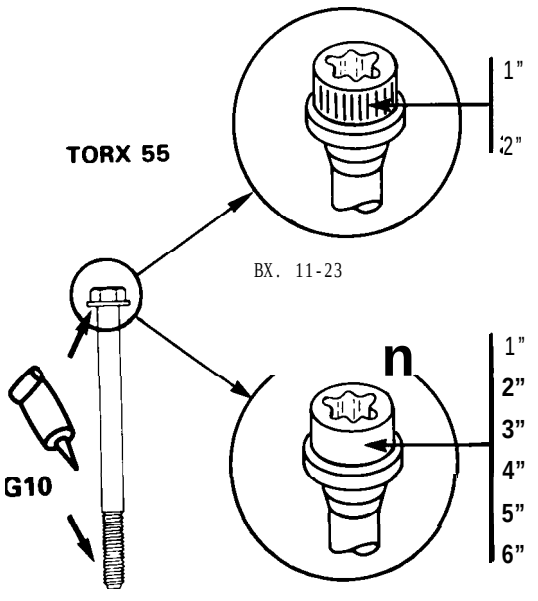
Y. 10-15


1 XM 100-00/4 4
0,8 mdaN

Y. 11-4



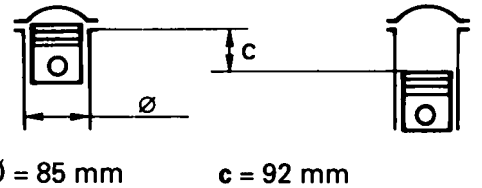




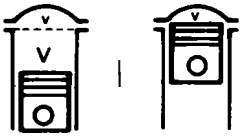
1º	7 mdaN	1.2.3... 1 0
2º	140°	1.2.3... 1 0
3º		
4º	3 H 30'	
5º	90° – 7 mdaN	1.2.3... 10
6º	140°	1.2.3... 10

→ P 8 A = XUD11ATE ←

2088 **cm³** × 4 × 12



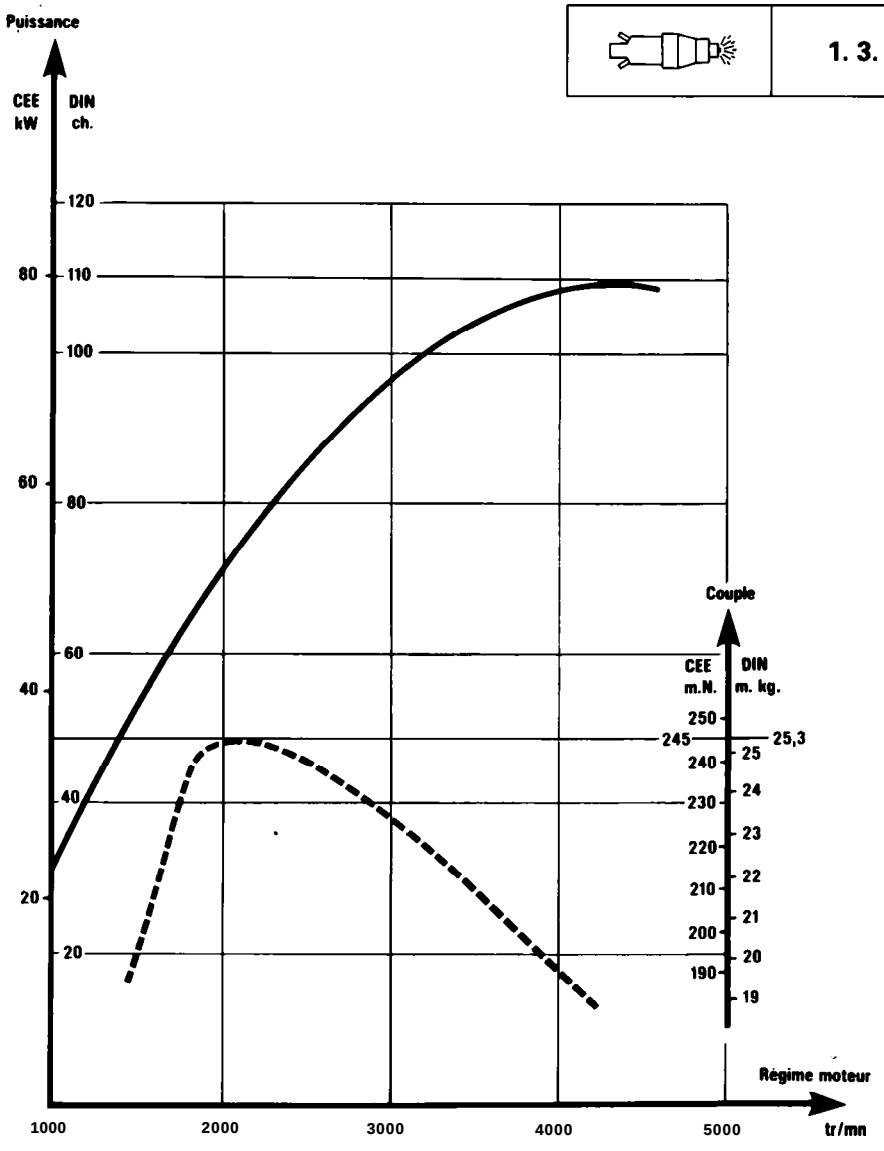
Ø = 85 mm **c** = 92 mm



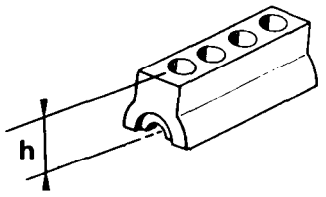
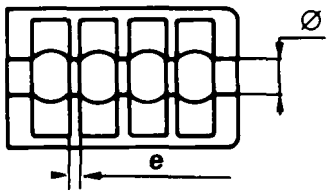
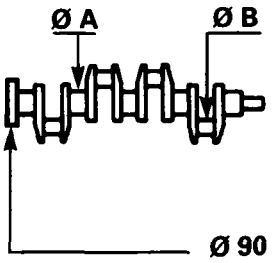
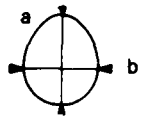
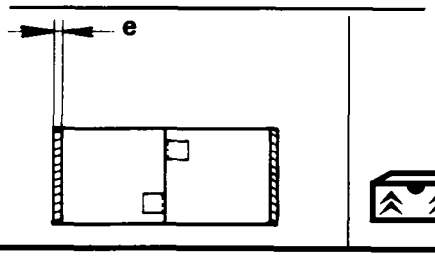
21,5 / 1

GAZOLE

1. 3. 4. 2



10-12

		h = 235 ± 0,05 mm
		h - 0,2 mm h = 234,80 Mini
		Ø = 63,750 - 0,019 / 0 mm e = 21,82 ± 0,05 mm
		A: 60 0 / -0,019 mm B: 50 0 / -0,016 mm
		A: 59,7 0 / -0,019 mm B: 49,7 0 / -0,016 mm
 a – b	- 0,2	0,007 mm 0,007 mm
		1,842 mm J 1,992 mm B 1,977 mm B

(D) Nach dem schleifen unbedingt neu nitrieren

(DK) Efter afdrejning/bearbejdning skalder foretages hædning af emnet ved illeld af nitrening

(E) Hacer imperativamente una nitruracion ionica después de la rectificacion

(GB) It is imperative to carry out an ionic nitriding after repair resurfacing

(I) Eseguire obbligatoriamente una nitrurazione ionica dopo la rettifica

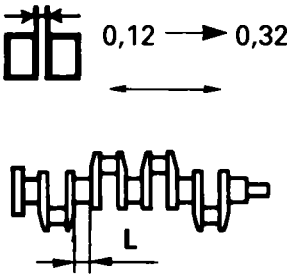
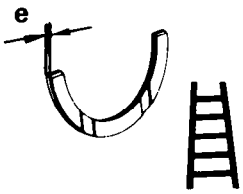
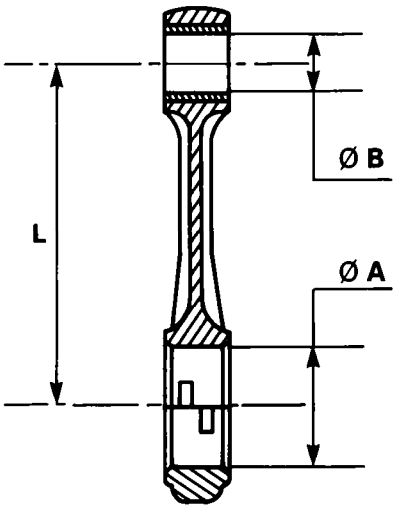
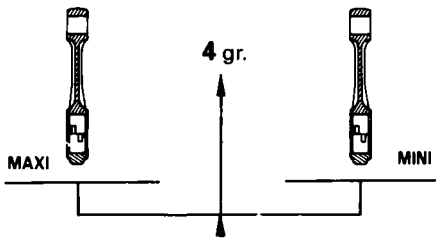
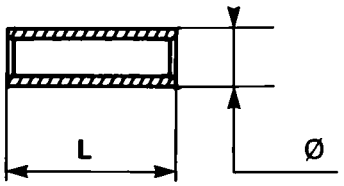
(NL) Het is noodzakelijk na opzuivering te nitreren

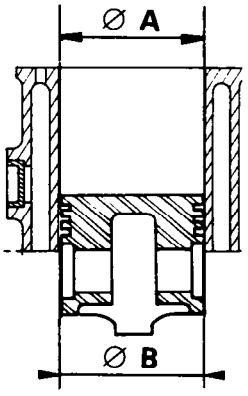
(P) Fazer impérativamente una nitruracäo ionica após rectificacäo

(S) Efter bearbetning är det absolut nödvändigt att härda materialet med hjäld av nitrering

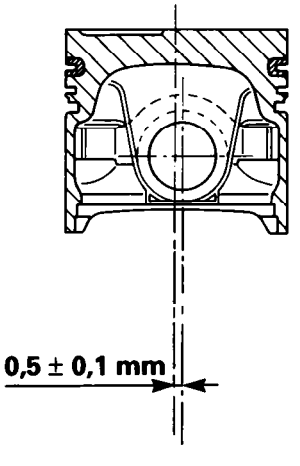
(SF) Kappale on ehdottomasti typetyskarkaistava käsittelyn jäl.Keen

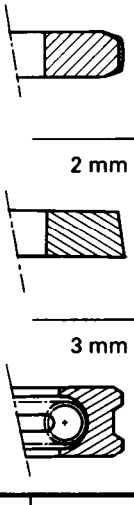
(F) Faire impérativement une nitruration ionique après rectification

0,12 → 0,32 mm 		$25{,}70\ ^{+0,05}_{0}$ mm
	1	**25,90** mm
	2	**26,00** mm
	3	**26,10** mm
		**1,85** mm
	1	**1,95** mm
	2	**2,00** mm
	3	**2,05** mm
		$Ø\ A = 53{,}695\ ^{+0,013}_{0}$ mm $Ø\ B = 30{,}00\ ^{+0,020}_{+0,007}$ mm L = 145 mm
		
		$L = 71{,}5\ ^{0}_{-0,3}$ mm $Ø = 30\ ^{0}_{-0,006}$ mm

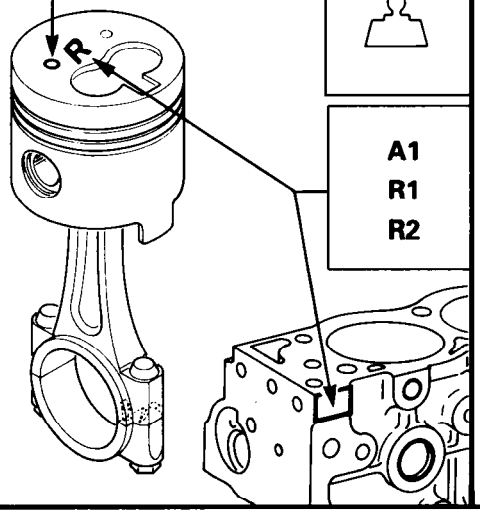


Ø A		85 $^{+0,018}_{0}$ mm
	R1	85,250 $^{+0,018}_{0}$ mm
	R2	85,600 $^{+0,018}_{0}$ mm
Ø B		84,920 ± 0,009 mm
	R1	85,170 ± 0,009 mm
	R2	85,520 ± 0,009 mm

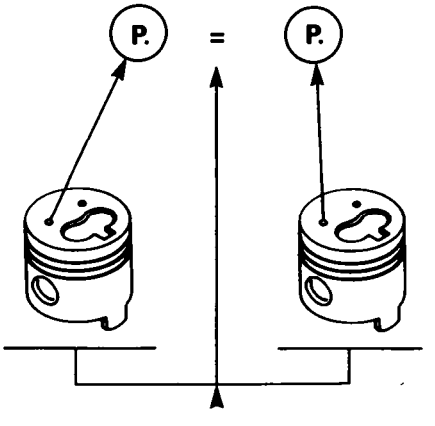


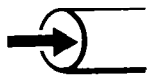
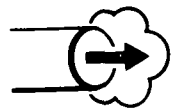
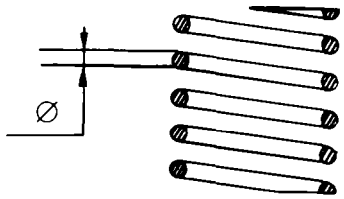
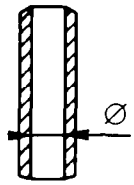
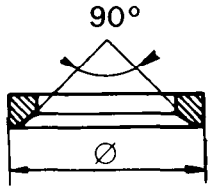
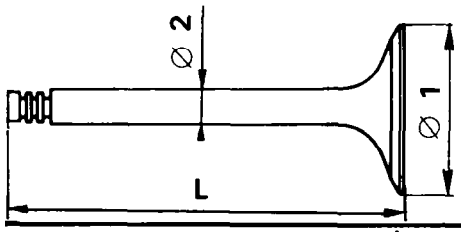
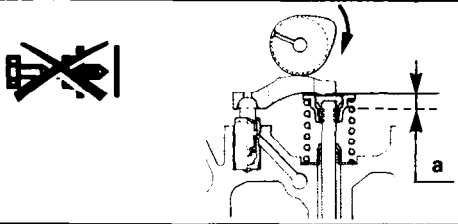
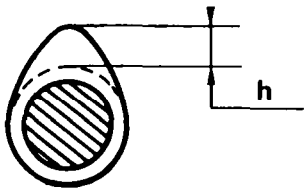


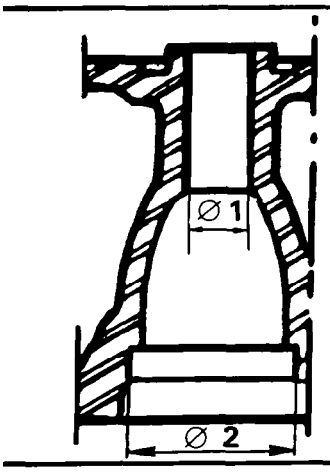
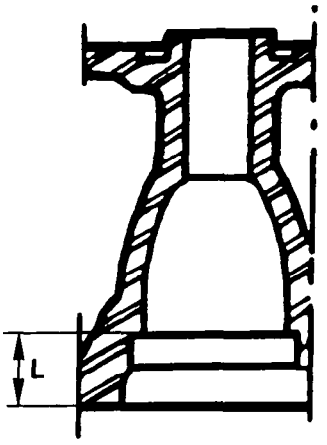
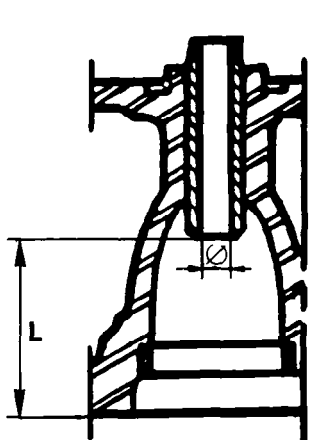
3 mm			
	R1	V	0,30 / 0,50
	R2	V V	
2 mm		V	0,30 / 0,50
	R1	V Bl	
	R2	V Bl Bl	
3 mm		V	0,25 / 0,50
	R1	V B	
	R2	V B B	

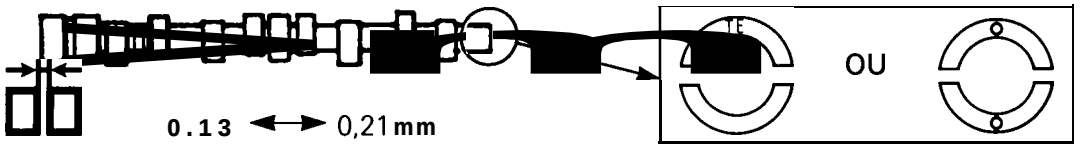


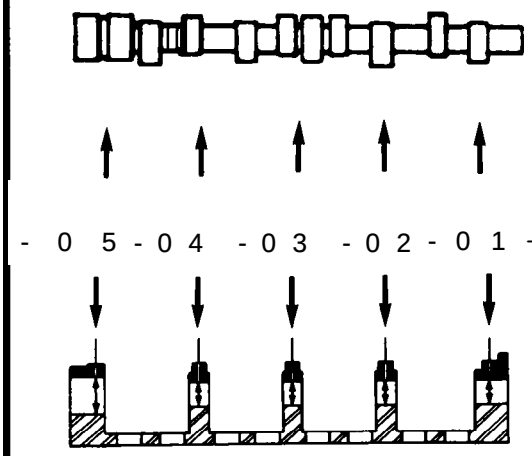
P1 - P2 - P3 - P4



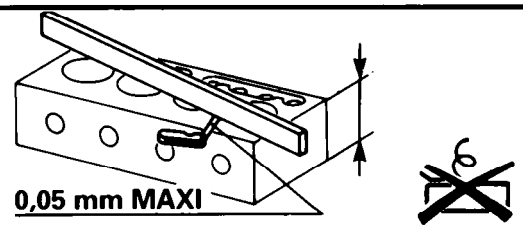
			
	x 12	3,5 mm	3,5 mm
 		13 $^{+0,059}_{+0,048}$ mm	13 $^{+0,059}_{+0,048}$ mm
	1	13,290 $^{0}_{-0,011}$ mm	13,290 $^{0}_{-0,011}$ mm
	2	13,590 $^{0}_{-0,011}$ mm	13,590 $^{0}_{-0,011}$ mm
 		35 $^{+0,137}_{+0,112}$ mm	35 $^{+0,137}_{+0,112}$ mm
	1	35,30 $^{+0,137}_{+0,112}$ mm	35,30 $^{+0,137}_{+0,112}$ mm
	2	35,50 $^{+0,137}_{+0,112}$ mm	35,50 $^{+0,137}_{+0,112}$ mm
	Ø 1	33,9 mm	33,9 mm
	Ø 2	8,005 $^{0}_{-0,015}$ mm	7,975 $^{0}_{-0,015}$ mm
	L	122,3 mm	121,9 mm
		8,40 mm	9,25 mm
		4,84 mm	5,28 mm

	Ø 1		12,981 $^{+0,032}_{0}$ mm	12,981 $^{+0,032}_{0}$ mm
		1	13,211 $^{+0,032}_{0}$ mm	13,211 $^{+0,032}_{0}$ mm
		2	13,511 $^{+0,032}_{0}$ mm	13,511 $^{+0,032}_{0}$ mm
	Ø 2		35 ± 0.025 mm	35 ± 0,025 mm
		1	35,30 ± 0.025 mm	35,30 ± 0,025 mm
		2	35,50 ± 0,025 mm	35,50 ± 0,025 mm
			8,15 ± 0,15 mm	8,55 ± 0.15 mm
		1	8,35 ± 0,15 mm	8,75 ± 0,15 mm
		2	8,35 ± 0,15 mm	8,75 ± 0,15 mm
			Ø = 8,02 $^{+0,022}_{0}$ mm	Ø = 8,02 $^{+0,022}_{0}$ mm
			L = 41 ± 0.5 mm	L = 41 ± 0.5 mm

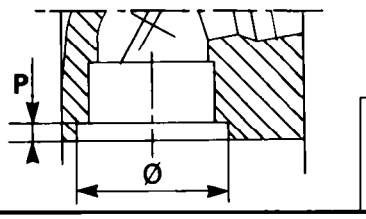




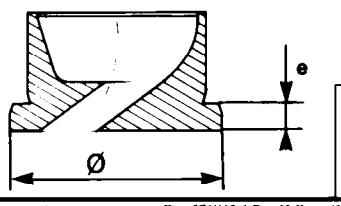
Ø 1	42,55	- 0,025 - 0,050	mm
Ø 2	43,7	- 0,025 - 0,050	mm
Ø 3	44,85	- 0,025 - 0,050	mm
Ø 4	46	- 0,025 - 0,050	mm
Ø 5	47,15	- 0,025 0	mm
Ø 1	42,565	+ 0,025 0	mm
Ø 2	43,715	+ 0,025 0	mm
Ø 3	44,865	+ 0,025 0	mm
Ø 4	46,015	+ 0,025 0	mm
Ø 5	47,165	+ 0,025 0	mm



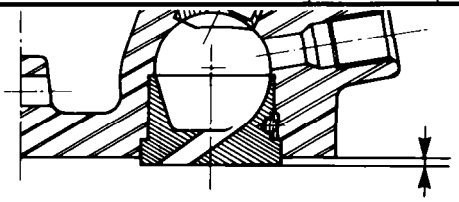
h = 110 ± 0,05 mm



	Ø	P
	34 + 0,039 0 mm	4 + 0,01 - 0,04 mm
1	34,4 + 0,039 0 mm	4,2 + 0,01 - 0,04 mm
2	34,6 + 0,039 0 mm	4,3 + 0,01 - 0,04 mm

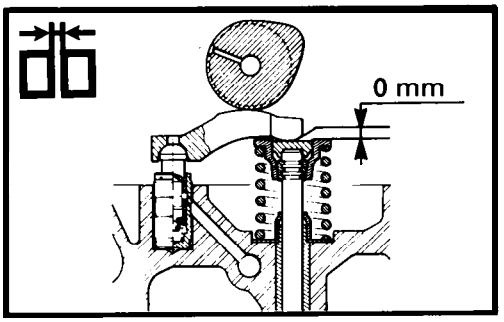


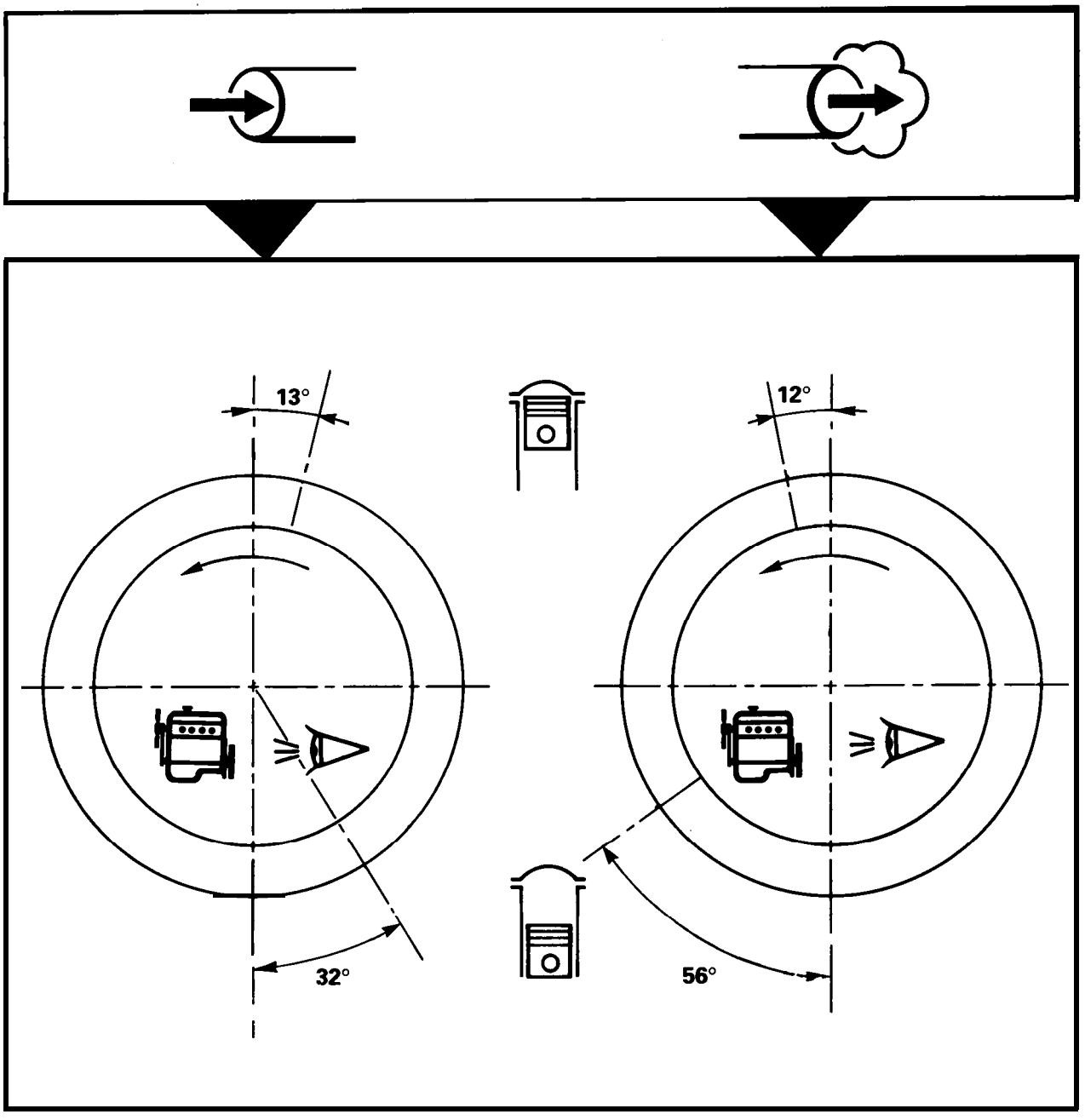
	Ø	e
	34,25 + 0,039 0 mm	4,075... 4,115 ± 0,005 mm
1	34,45 + 0,039 0 mm	4,215 ± 0,005 mm
2	34,65 + 0,039 0 mm	4,315 ± 0,005 mm



0 ⟷ 0,03 mm MAXI

// | 0,015


0 mm


13°
12°
32°
56°