

## 01-1100 Installing cylinder liners

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### Cylinder liners

Engine	Crankcase cast number 1)	Cylinder liner part number 2)	Crankcase design
119.960	-	117 011 02 10	"closed deck"
119.971/975/ 981/985	119 011 06 01	119 011 02 10	"closed deck"
	119 011 08 01	119 011 02 10	"closed deck"
	119 011 10 01	119 011 02 10	"closed deck"
	119 011 12 01	119 011 02 10	"closed deck"
	119 011 14 01	119 011 02 10	"closed deck"
	119 011 16 01	119 011 02 10	"closed deck"
	119 011 18 01	119 011 02 10	"closed deck"
	119 011 22 01	119 011 02 10	"open-deck"
119.970/972/ 974/980/982	119 011 07 01	119 011 01 10	"closed deck"
	119 011 09 01	119 011 01 10	"closed deck"
	119 011 11 01	119 011 01 10	"closed deck"
	119 011 13 01	119 011 01 10	"closed deck"
	119 011 15 01	119 011 01 10	"closed deck"
	119 011 17 01	119 011 01 10	"closed deck"
	119 011 19 01	119 011 01 10	"closed deck"
	119 011 23 01	119 011 01 10	"closed deck"
	119 011 24 01	119 011 01 10	"open-deck"

1) The number is cast on the side left behind the engine support

2) The material of the cylinder liner is identical to the crankcase

### Machining dimensions in crankcase

Cylinder liner 3)	119 01 02 10	117 011 02 10 119 011 01 10
Basic bore for cylinder liner	95.500 – 95.535	100.00 – 100.035
Basic bore for liner collar	97.500 – 97.535	102.00 – 102.035
Insertion depth for liner collar seat	4.4 – 4.5	4.4 – 4.5

3) The cylinder liner in the crankcase can be widened 3) to standard size and 1st repair size +0.5 mm (01-1120).

