

TO: OUR MERCEDES-BENZ PASSENGER CAR DEALERS

DATE: August 1994

REF. NO. 01 32

SUBJECT: DIESEL ENGINES 602.96, 603.96/97 ←
REBUILDING ENGINE BLOCK WITH CYLINDER SLEEVES

In the event of an engine rebuild, cylinder sleeves may be subsequently installed in these engines. To do so, bore out the standard cylinder bores, install sleeves, rebore to standard size and install standard-size pistons. Engines with 87 mm diameter cylinder bores must be bored to 90 mm and those with 89 mm diameter cylinder bores must be bored to 91.5 mm (see table below).

⚠ NOTE!

Repair stages (i.e. boring out cylinder bore sleeve) are not available for these engines. For further information regarding work procedure, see SMS, Job no. 01-110 or 01-115).

Dimensions for Machining Standard Bore

Engine	602.961.962 603.960.961	603.970.971
Cylinder bore diameter	87 mm	89 mm
Bore diameter (D, Figure 1)	92.7 ± 0.05 mm	94.2 ± 0.05 mm
Bore diameter (D1, Figure 1)	90.6 ± 0.05 mm	92.1 ± 0.1 mm
Bore diameter (D2, Figure 1)	90.0 – 90.035 mm	91.500 – 91.535 mm
Cylinder bore sleeve seat to center of main bearing bore (T, Figure 1)	231.0 – 231.2 mm	231.0 – 231.2 mm
Cylinder bore sleeve seat depth (T1, Figure 1)	1.0 – 1.2 mm	1.0 – 1.2 mm