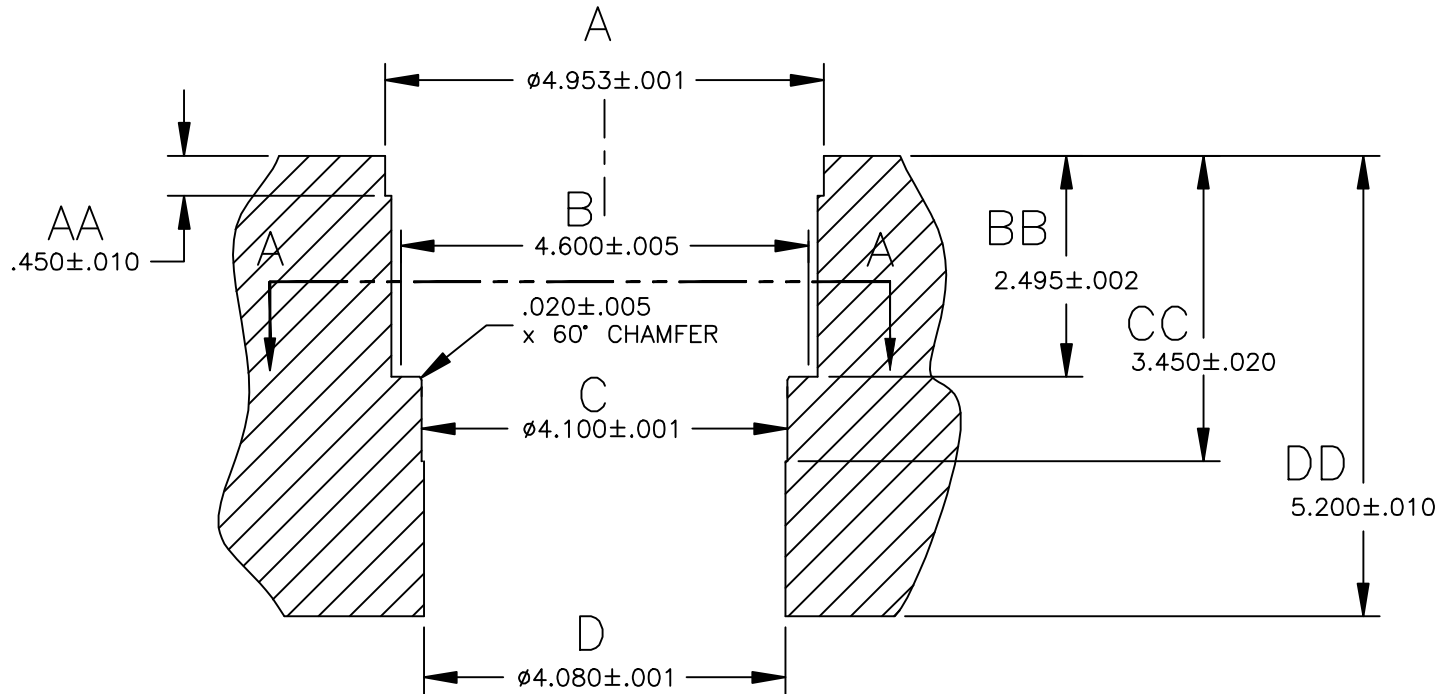



**NOTE:**

1. PRIOR TO MACHING FOR SLEEVES, BORE EXISTING CYLINDERS TO .010 OVER FINISH I.D. SIZE DOWN TO MAIN WEB FOR HONNING OVER STROKE CLEARANCE
2. MACHINE BLOCK AT BORE CENTER  $\phi 4.173/106\text{mm}$
3. MACHINE BLOCK BORES A,C,& D TO BE .001 CLEARANCE OF SLEEVE
4. APPLY A SMALL AMOUNT OF LOCTITE #518 OR #620 TO BLOCK BORES A & D AT TIME OF INSTALLATION
5. INSTALL SLEEVES AT ROOM TEMPERATURE AND CLAMP SLEEVE DOWN TO DECK UNTILL LOCTITE HAS CURED, THEN DECK AND HONE

REVISIONS			
REV	DESCRIPTION	DATE	APPROVAL



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DATE: 12/18/2012	
CHK'D BY:	TITLE: BLOCK SPECIFICATION- MERCEDES E55 ALUM V8 M.I.D.
MATERIAL:	SIZE: A
HARDNESS:	DWG NO. 900-600
SCALE: 1/2	REV: -
SHEET 1 OF 1	