



1

PHZ

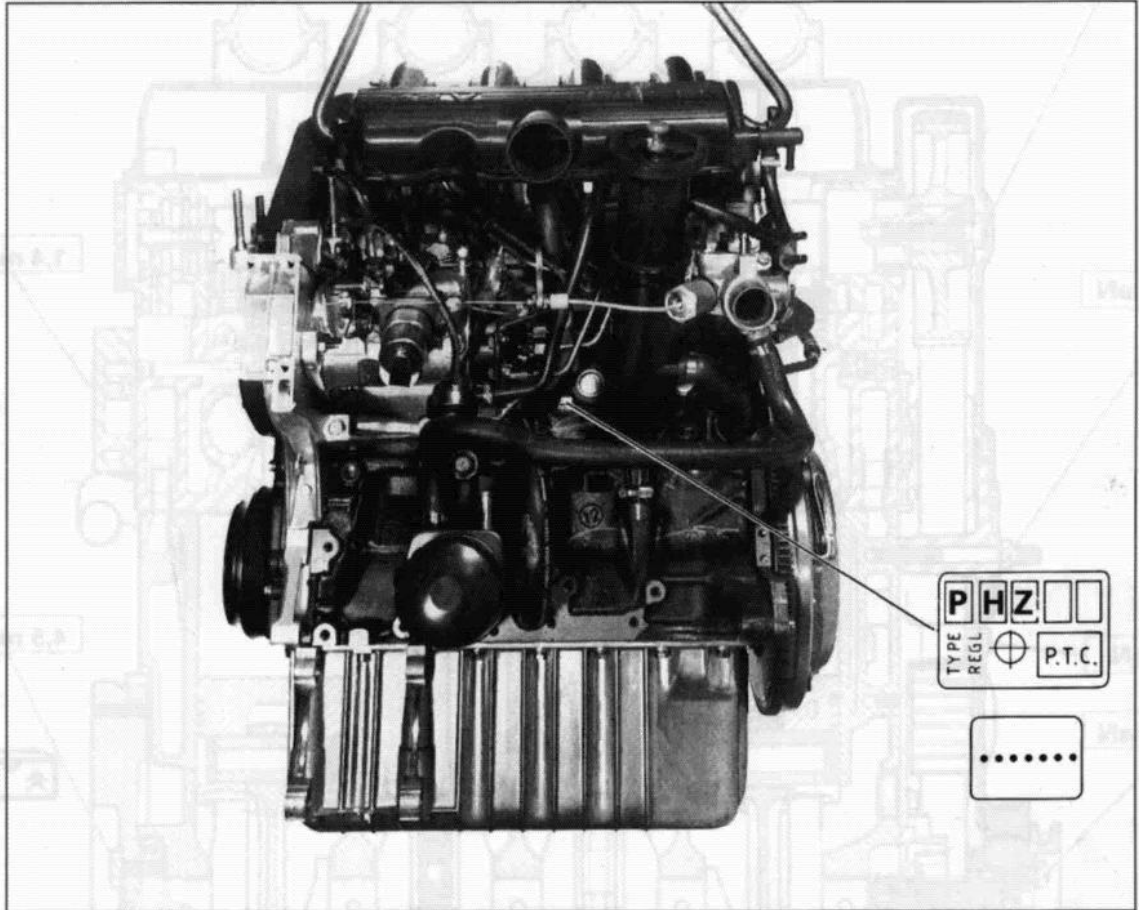


4 CYL.
XUD 11

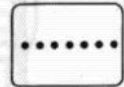


XM
100-00/10

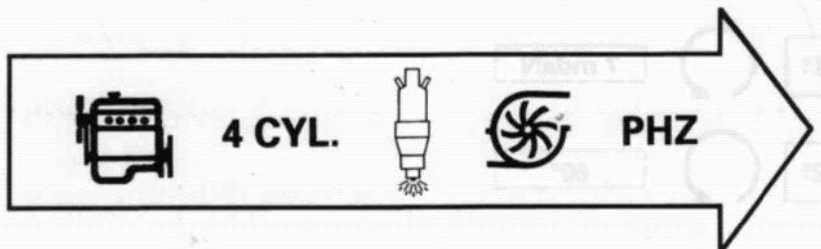
1



P	H	Z		
TYPE				
REG.				
			⊕	P.T.C.

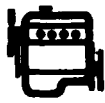


89-1237



2

XM
100-00/10



4 CYL.

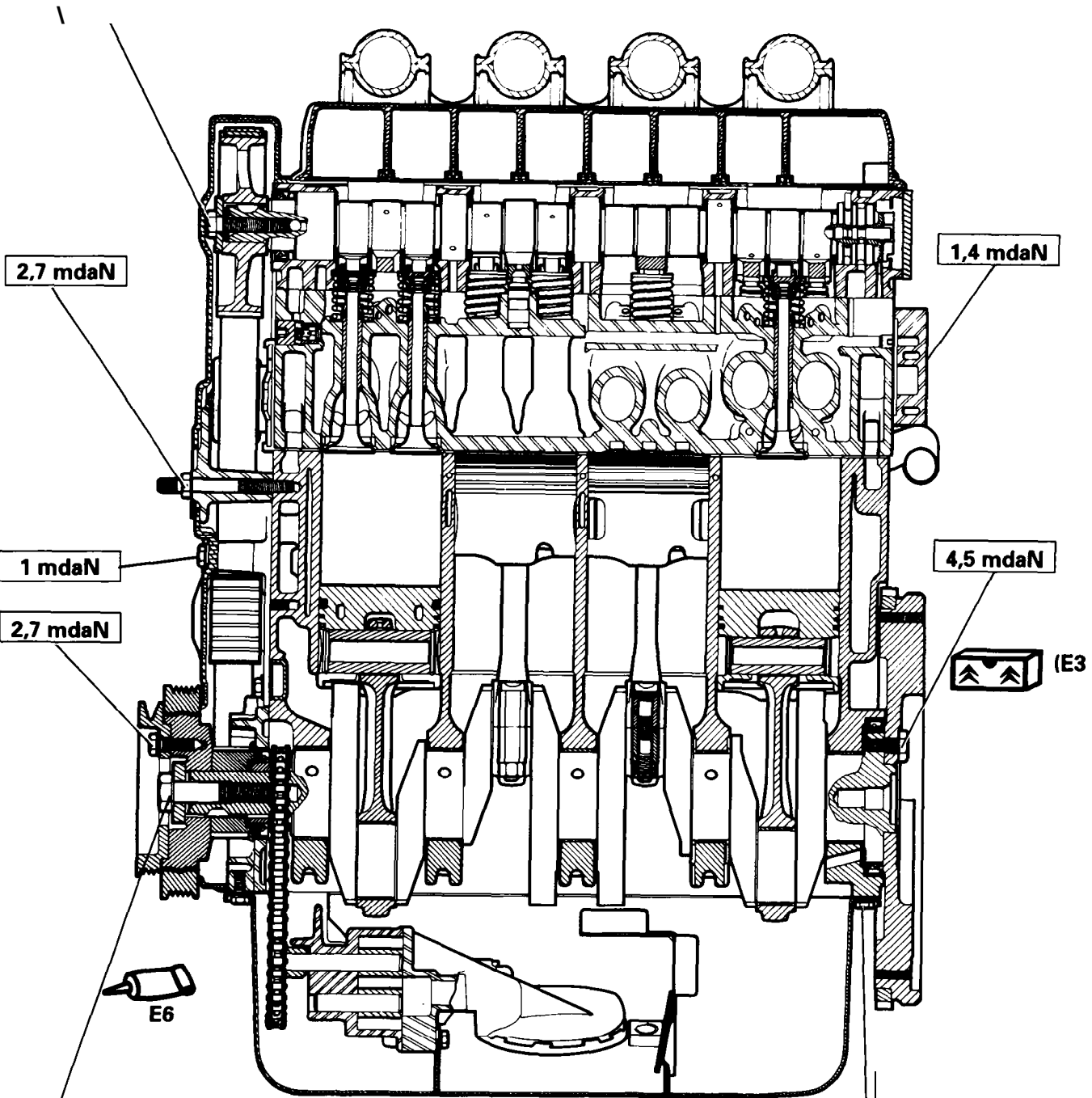


PHZ

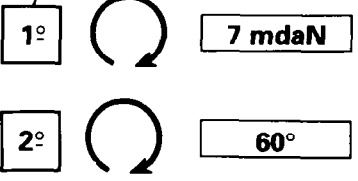
1



4.3 mdaN

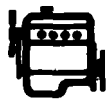


Y. 10-14





1



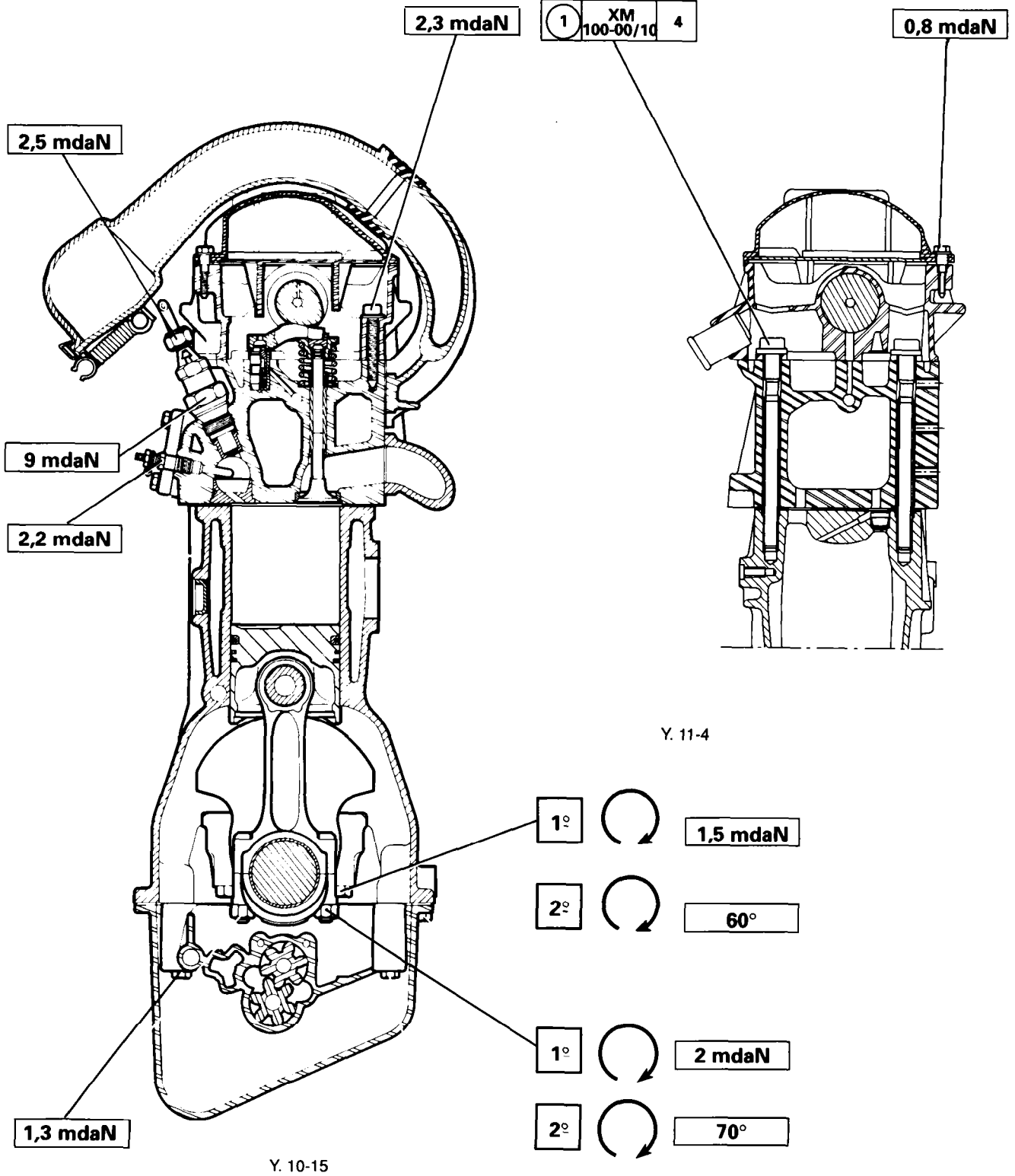
4 CYL.

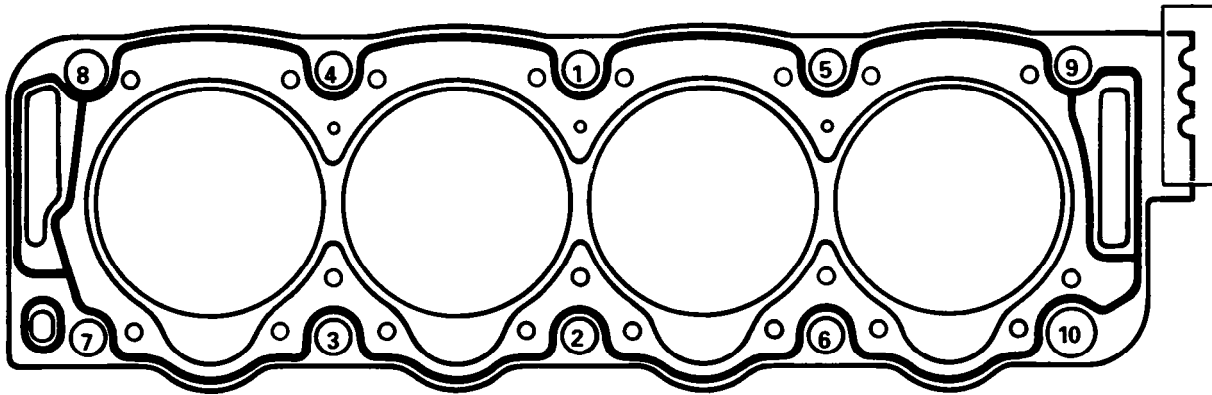
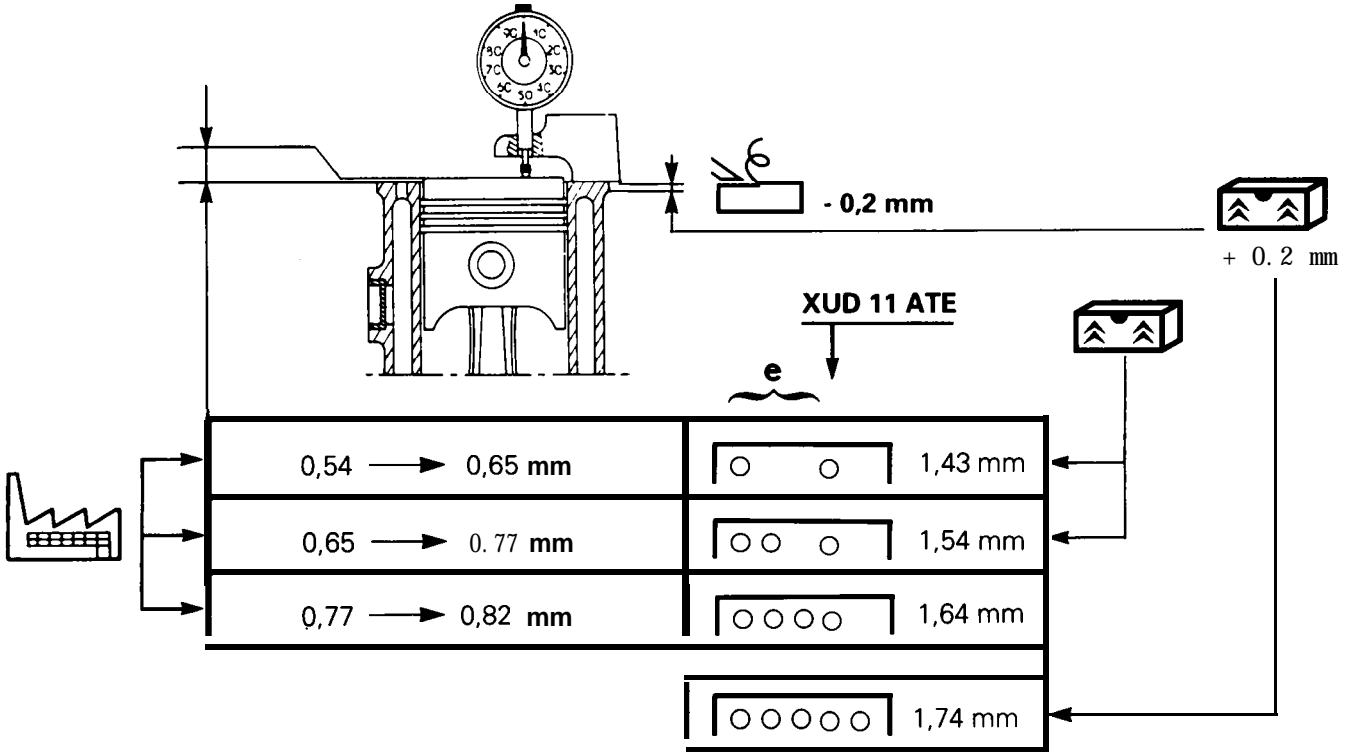
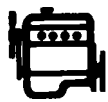


PHZ

XM
100-00/10

3





TORX 55

BX. 11-23

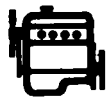
G10

BX. 11-22

1"			7 mdaN	1.2.3... 10
2"			140°	1.2.3... 10
3"				
4"				
5"			90° - 7 mdaN	1.2.3... 10
6"			140°	1.2.3... 10



1



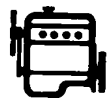
4 CYL.



PHZ

XM
100-00/10

5



PHZ

=

XUD11ATE/Y

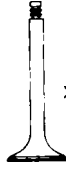
←



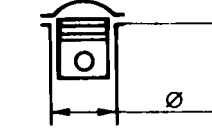
2088 cm³



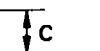
× 4



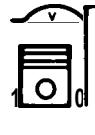
× 12



Ø = 85 mm



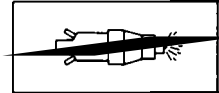
c = 92 mm



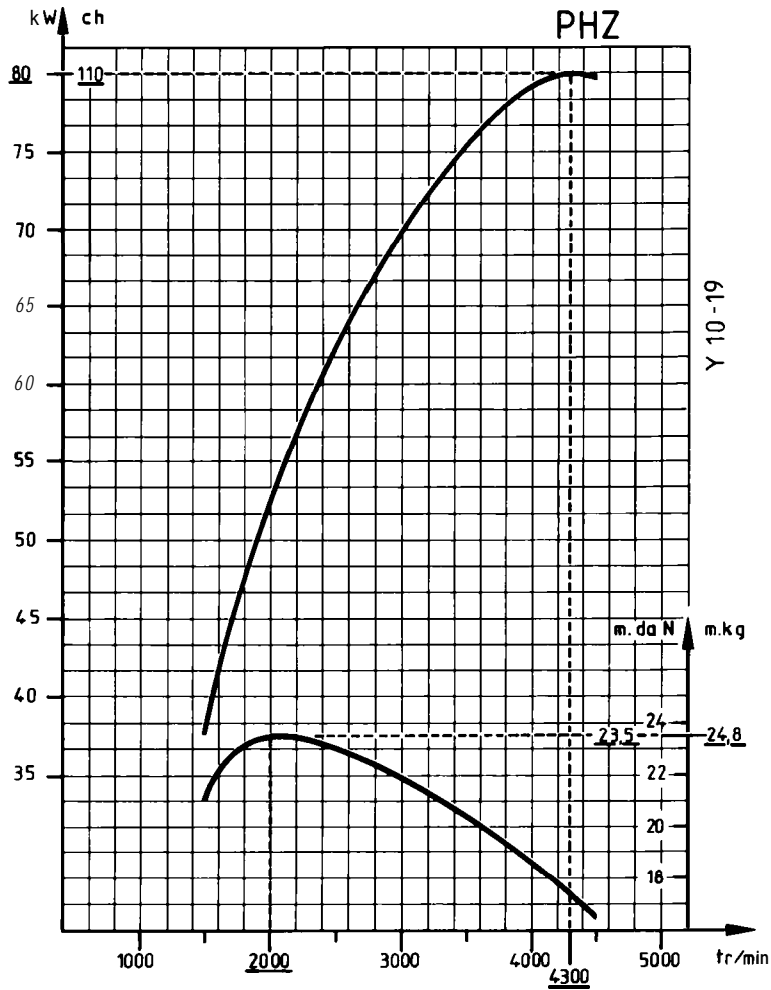
20,5/1



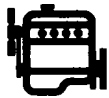
GAZOLE

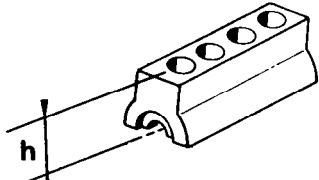

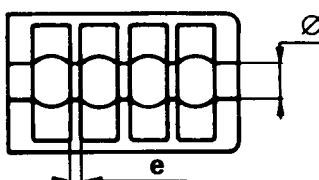
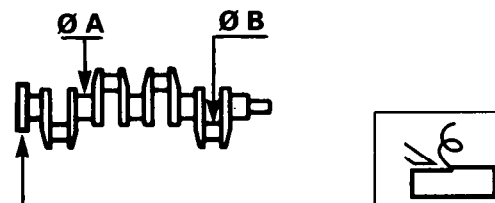






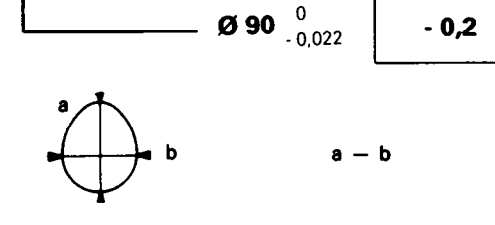


1.



10-19



	$h = 235 \pm 0,05 \text{ mm}$													
	$h - 0,2 \text{ mm}$ $h = 234,80 \text{ Mini}$													
	$\varnothing = 63,750 - \begin{matrix} 0, \\ 0,019 \end{matrix} \text{ mm}$ $e = 21,82 \pm 0,05 \text{ mm}$													
	<table border="1"> <thead> <tr> <th>A</th> <th>B</th> </tr> </thead> <tbody> <tr> <td>$60 - \begin{matrix} 0, \\ 0,019 \end{matrix} \text{ mm}$</td> <td>$50 - \begin{matrix} 0, \\ 0,016 \end{matrix} \text{ mm}$</td> </tr> <tr> <td>$59,7 - \begin{matrix} 0, \\ 0,019 \end{matrix} \text{ mm}$</td> <td> $49,7 - \begin{matrix} 0, \\ 0,016 \end{matrix} \text{ mm}$</td> </tr> </tbody> </table>	A	B	$60 - \begin{matrix} 0, \\ 0,019 \end{matrix} \text{ mm}$	$50 - \begin{matrix} 0, \\ 0,016 \end{matrix} \text{ mm}$	$59,7 - \begin{matrix} 0, \\ 0,019 \end{matrix} \text{ mm}$	 $49,7 - \begin{matrix} 0, \\ 0,016 \end{matrix} \text{ mm}$	<table border="1"> <thead> <tr> <th>A</th> <th>B</th> </tr> </thead> <tbody> <tr> <td>$60 - \begin{matrix} 0, \\ 0,019 \end{matrix} \text{ mm}$</td> <td>$50 - \begin{matrix} 0, \\ 0,016 \end{matrix} \text{ mm}$</td> </tr> <tr> <td>$59,7 - \begin{matrix} 0, \\ 0,019 \end{matrix} \text{ mm}$</td> <td> $49,7 - \begin{matrix} 0, \\ 0,016 \end{matrix} \text{ mm}$</td> </tr> </tbody> </table>	A	B	$60 - \begin{matrix} 0, \\ 0,019 \end{matrix} \text{ mm}$	$50 - \begin{matrix} 0, \\ 0,016 \end{matrix} \text{ mm}$	$59,7 - \begin{matrix} 0, \\ 0,019 \end{matrix} \text{ mm}$	 $49,7 - \begin{matrix} 0, \\ 0,016 \end{matrix} \text{ mm}$
A	B													
$60 - \begin{matrix} 0, \\ 0,019 \end{matrix} \text{ mm}$	$50 - \begin{matrix} 0, \\ 0,016 \end{matrix} \text{ mm}$													
$59,7 - \begin{matrix} 0, \\ 0,019 \end{matrix} \text{ mm}$	 $49,7 - \begin{matrix} 0, \\ 0,016 \end{matrix} \text{ mm}$													
A	B													
$60 - \begin{matrix} 0, \\ 0,019 \end{matrix} \text{ mm}$	$50 - \begin{matrix} 0, \\ 0,016 \end{matrix} \text{ mm}$													
$59,7 - \begin{matrix} 0, \\ 0,019 \end{matrix} \text{ mm}$	 $49,7 - \begin{matrix} 0, \\ 0,016 \end{matrix} \text{ mm}$													
	<table border="1"> <thead> <tr> <th>A</th> <th>B</th> </tr> </thead> <tbody> <tr> <td>$0,007 \text{ mm}$</td> <td>$0,007 \text{ mm}$</td> </tr> <tr> <td>$1,842 \text{ mm}$</td> <td>$1,827 \text{ mm } \boxed{J}$</td> </tr> <tr> <td>$1,992 \text{ mm } \boxed{B}$</td> <td>$1,977 \text{ mm } \boxed{B}$</td> </tr> </tbody> </table>		A	B	$0,007 \text{ mm}$	$0,007 \text{ mm}$	$1,842 \text{ mm}$	$1,827 \text{ mm } \boxed{J}$	$1,992 \text{ mm } \boxed{B}$	$1,977 \text{ mm } \boxed{B}$				
A	B													
$0,007 \text{ mm}$	$0,007 \text{ mm}$													
$1,842 \text{ mm}$	$1,827 \text{ mm } \boxed{J}$													
$1,992 \text{ mm } \boxed{B}$	$1,977 \text{ mm } \boxed{B}$													



(D) Nach dem schleifen unbedingt neu nitrieren



(DK) Efter afdrejning/bearbejdning skal der foretages hænding af emnet ved illeld af nitrening

(E) Hacer imperativamente una nitruración iónica después de la rectificación

(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 nitrenen

(P) Fazer impérativamente uma nitruração iónica após rectificação

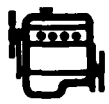
(S) Efter bearbetning är det absolut nödvändigt att härda materialet med hjäld av nitrening

(SF) Kappale on ehdottomasti työtyskarkaistava käsittelyn jäl.Keen

(F) Faire impérativement une nitruration ionique après rectification



1



4 CYL.

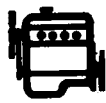


PHZ

XM
100-00/10

7

		<p>$25,70^{+0,05}_0$ mm</p> <table border="1"> <tr><td>1</td><td>25,90 mm</td></tr> <tr><td>2</td><td>26,00 mm</td></tr> <tr><td>3</td><td>26,10 mm</td></tr> </table>	1	25,90 mm	2	26,00 mm	3	26,10 mm		
1	25,90 mm									
2	26,00 mm									
3	26,10 mm									
		<table border="1"> <tr><td></td><td>1,85 mm</td></tr> <tr><td>1</td><td>1,95 mm</td></tr> <tr><td>2</td><td>2,00 mm</td></tr> <tr><td>3</td><td>2,05 mm</td></tr> </table>		1,85 mm	1	1,95 mm	2	2,00 mm	3	2,05 mm
	1,85 mm									
1	1,95 mm									
2	2,00 mm									
3	2,05 mm									
	<p>$\text{Ø A} = 53,695^{+0,013}_0$ mm</p> <p>$\text{Ø B} = 30,00^{+0,020}_{+0,007}$ mm</p> <p>L = 145 mm</p>									
	<p>L = $71,5^0_{-0,3}$ mm</p> <p>$\text{Ø} = 30^0_{-0,006}$ mm</p>									



	Ø A		$85^{+0,018}_0$ mm	
		A1	$85,030^{+0,018}_0$ mm	
		R1	$85,250^{+0,018}_0$ mm	
		R2	$85,600^{+0,018}_0$ mm	
	Ø B		84,920 ± 0,009 mm	
		A1	84,950 ± 0,009 mm	
		R1	85,170 ± 0,009 mm	
		R2	85,520 ± 0,009 mm	

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

			P1 - P2 - P3 - P4	
			A1 R1 R2	



1



4 CYL.






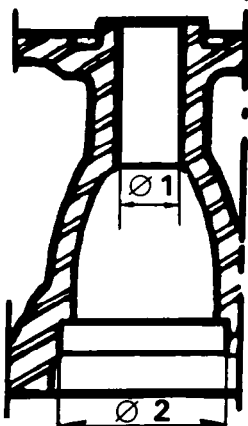


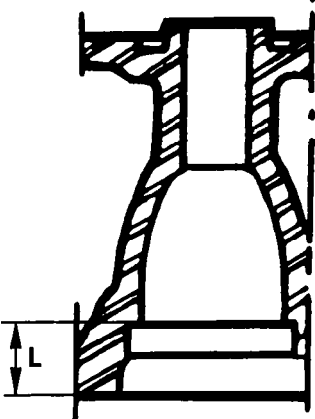

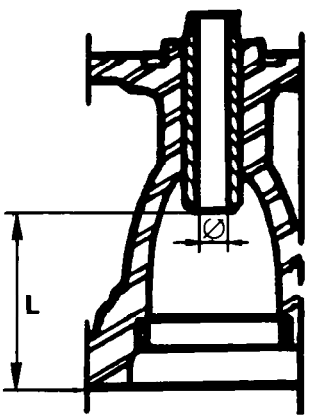

PHZ

XM
100-00/10

9

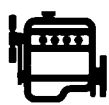
	x 12	3,5 mm	3,5 mm
		13 ^{+ 0,059} _{+ 0,048} mm	13 ^{+ 0,059} _{+ 0,048} mm
	1	13,290 ⁰ _{- 0,011} mm	13,290 ⁰ _{- 0,011} mm
	2	13,590 ⁰ _{- 0,011} mm	13,590 ⁰ _{- 0,011} mm
	1	35 ^{+ 0,137} _{+ 0,112} mm	35 ^{+ 0,137} _{+ 0,112} mm
	2	35,30 ^{+ 0,137} _{+ 0,112} mm	35,30 ^{+ 0,137} _{+ 0,112} mm
	Ø 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



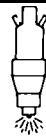
		  		
	Ø 1		12,981 $\begin{smallmatrix} +0,032 \\ 0 \end{smallmatrix}$ mm	12,981 $\begin{smallmatrix} +0,032 \\ 0 \end{smallmatrix}$ mm
		1	13,211 $\begin{smallmatrix} +0,032 \\ 0 \end{smallmatrix}$ mm	13,211 $\begin{smallmatrix} +0,032 \\ 0 \end{smallmatrix}$ mm
		2	13,511 $\begin{smallmatrix} +0,032 \\ 0 \end{smallmatrix}$ mm	13,511 $\begin{smallmatrix} +0,032 \\ 0 \end{smallmatrix}$ 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 $\begin{smallmatrix} +0,022 \\ 0 \end{smallmatrix}$ mm	Ø = 8,02 $\begin{smallmatrix} +0,022 \\ 0 \end{smallmatrix}$ mm
			L = 41 ± 0,5 mm	L = 41 ± 0,5 mm



1



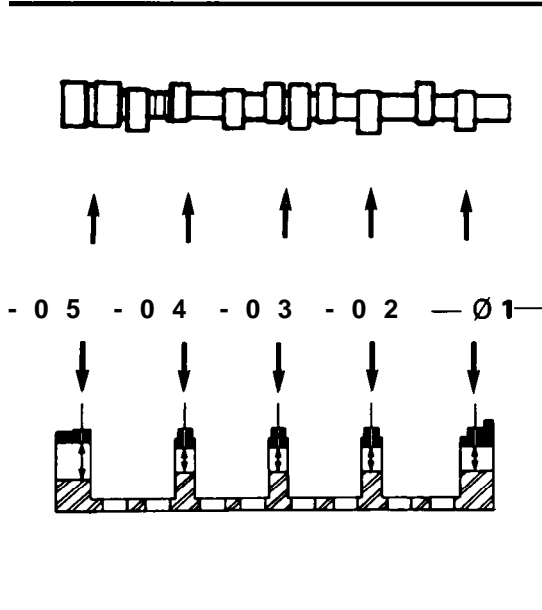
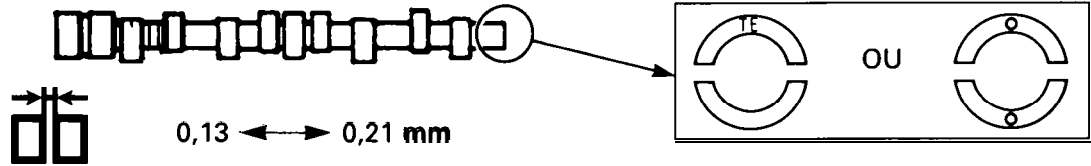
4 CYL.



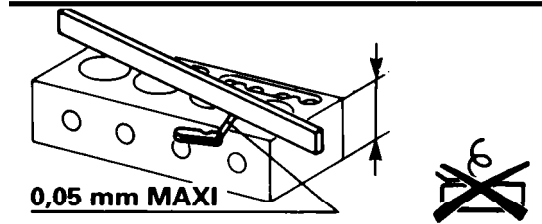
PHZ

XM
100-00/10

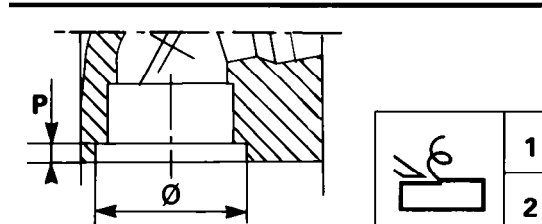
11



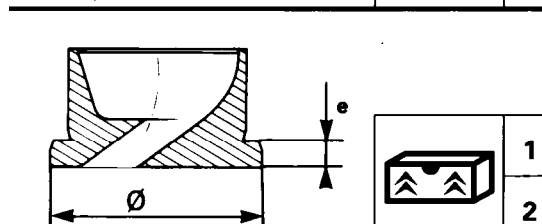
Ø 1	42,55	- 0,025 - 0,050	mm
Ø 2	43,7	- 0,025 - 0,050	mm
Ø 3	44,85	- 0,025 - 0,050	mm
Ø 4	46	- 0,025 - 0,050	mm
Ø 5	47,15	- 0,025 - 0,050	mm
Ø 1	42,565	+ 0,025 0	mm
Ø 2	43,715	+ 0,025 0	mm
Ø 3	44,865	+ 0,025 0	mm
Ø 4	46,015	+ 0,025 0	mm
Ø 5	47,165	+ 0,025 0	mm



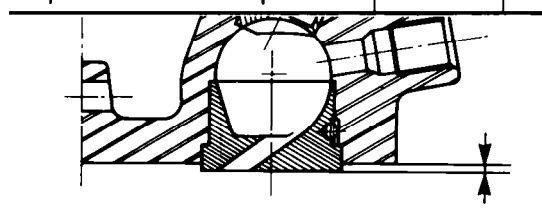
$h = 110 \pm 0,05$ mm			
-----------------------	--	--	--



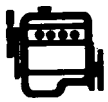
Ø	P		
34	+ 0,039 0 mm	4	+ 0,01 - 0,04 mm
34,4	+ 0,039 0 mm	4,2	+ 0,01 - 0,04 mm
34,6	+ 0,039 0 mm	4,3	+ 0,01 - 0,04 mm



Ø	e		
34,25	+ 0,039 0 mm	4,075... 4,115	$\pm 0,005$ mm
34,45	+ 0,039 0 mm	4,215	$\pm 0,005$ mm
34,65	+ 0,039 0 mm	4,315	$\pm 0,005$ mm



$0 \longleftrightarrow 0,03$ mm MAXI			
// 0,015			



4 CYL.



PHZ

