

Control del juego de acoplamiento entre los segmentos y las ranuras del pistón.



Realizar la operación mediante un calibre de espesores.
Antes de efectuar el control limpiar la superficie del pistón.
El valor del juego debe ser de:
- Segmentos nuevos de 0,02 a 0,05 mm.

Armado del conjunto biela-bulón-pistón.



Montar el conjunto biela-bulón-pistón.
Observar la posición de montaje de la biela con respecto al pistón.
La flecha de la superficie superior del pistón mira hacia el lado de los tetones de fundición y de la marca efectuada en el lateral de la biela con su correspondiente cilindro.



Montar el bulón mediante el tal U-20006.
Si penetra con fuerza sostener el pistón a unos 60°.
Colocar los anillos de seguridad.
Montar los segmentos en el pistón con las pinzas adecuadas.
Colocar los segmentos desbastados entre sí 120° y teniendo en cuenta que la marca "TOP" va de mirar hacia la cabeza del pistón.



Montar los conjuntos en el bloque de forma que la numeración de los cilindros se corresponda con la de los cilindros.
Antes del montaje lubricar las partes interesadas con aceite motor.
Las flechas grabadas en el pistón señalan hacia la parte de transmisión.
Ejecutar el montaje con una abrazadera reguladora.

Control del juego axial de la biela.

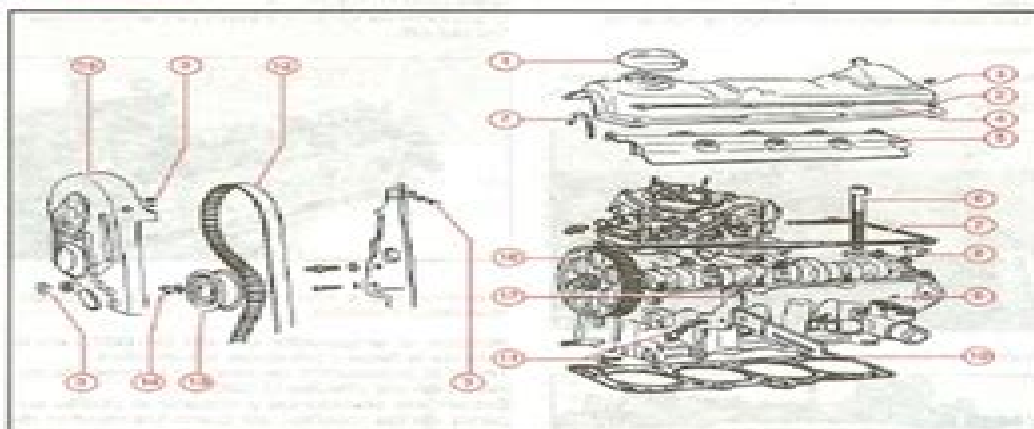
Efectuar la medición con un calibre de espesores.
El juego axial máximo permitido es de 0,27 mm.

Control del juego radial de la biela.

Con el motor montado puede efectuarse la operación de control del juego utilizando Plastigage.
Desmontar el sombrerete de biela.
Limpiar cuidadosamente el semicójnate y la muñequilla de biela.
Colocar sobre la muñequilla o el semicójnate un cordón de Plastigage en sentido axial.
Montar el sombrerete de biela y apretar al par de 3,0 daN.m.
Desmontar el sombrerete de biela.
Comprobar la anchura del cordón de Plastigage con la escala de medición.
El límite de desgaste tolerado nos proporciona un juego máximo de 0,12 mm.
Una vez efectuada la comprobación montar los sombreretes de biela.
Ajustar las superficies de apoyo y apretar al par de 3,0 daN.m + 90°.

CULATA

Características



- 1.- Tapón.
- 2.- Listón de apoyo.
- 3.- Tuerca 1,0 daN.m.
- 4.- Tapa de culata.
- 5.- Fleja de condensación vapores.
- 6.- Tornillo de culata (9,0 daN.m + 180°).
- 7.- Junta de tapa de culata.
- 8.- Tapón.
- 9.- Culata.
- 10.- Junta de culata.
- 11.- Tornillos (2,5 daN.m).
- 12.- Correa dentada de la distribución.
- 13.- Rodillo tensor.
- 14.- Tuerca fijación rodillo tensor (4,5 daN.m).
- 15.- Protección superior de la correa dentada.
- 16.- Piñón de mando del árbol de distribución.
- 17.- Embudo fijación alternador.

Control de la presión de compresión

Condiciones de prueba:

- Temperatura del aceite motor: 30° C mínimo.
- Mariposa de gases completamente abierta.
- Buja en buen estado.
- Buja separada.

Desconectar el distribuidor de encendido, el cable de alta tensión de la bobina y conectarlo a masa.



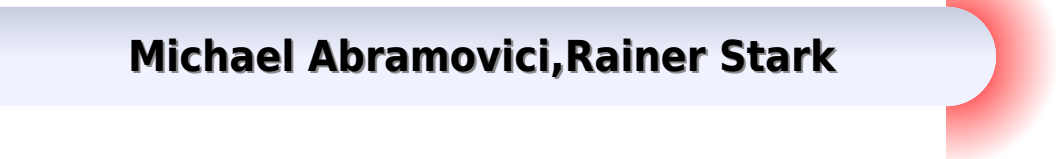
Aplicar el compresor VAG 1381 en el lugar de la buja.
Accionar el motor de arranque hasta que el verificador no indique aumentos adicionales de presión.
Los valores de compresión (bar) deben estar comprendidos entre:

Motor	Nuevo	Mínimo
E2 17-18°	9 a 12	7
2E	10 a 13	7,5

La diferencia máxima admisible entre todos los cilindros no debe ser superior a 3 bares.

Toledo 1993 Owners Manual

Michael Abramovici, Rainer Stark



Toledo 1993 Owners Manual:

Lloyd's Register OneOcean's Guide to Port Entry 1993-94 Kenya-Zaire Lloyd's Register Foundation, 1993-01-01 First published in 1971 these Guides provide invaluable information on thousands of commercial ports and terminals across the globe They are compiled and published annually by LR OneOcean whose years of global maritime experience allows them to provide expert and innovative solutions that enhance efficiency sustainability and overall industry success The Guides cover a significant geographical breadth and the most recent volume includes information on over 12 500 ports harbours and terminals worldwide These are fully indexed and contain detailed port plans and mooring diagrams *Official Gazette of the United States Patent and Trademark Office* ,2001 **Transputer Applications and Systems '94** A. De Gloria, M. R. Jane, D. Marini, 1994 Proceedings Parallel Computing **Proceedings at the 16th International Communication Satellites** AIAA, 1996 This collection of papers presented during the sessions at the 16th ICSSC includes topics such as geo launch vehicles high power RF components satellites in the NII GII domestic and regional systems modulation and coding authorized PCS systems military systems geosynchronous power systems **Asset Forfeiture** ,1998 **Moody's Manual of Railroads and Corporation Securities** ,1924 *Monthly Catalogue, United States Public Documents* ,1993 Monthly Catalog of United States Government Publications ,2000 **NASA Technical Memorandum** ,1994 WALNECK'S CLASSIC CYCLE TRADER, MAY 1993 Causey Enterprises, LLC, *Security Owner's Stock Guide* ,1993 **Moody's Manual of Industrial and Miscellaneous Securities** ,1924 **Scientific and Technical Aerospace Reports** ,1995 Lists citations with abstracts for aerospace related reports obtained from world wide sources and announces documents that have recently been entered into the NASA Scientific and Technical Information Database **Smart Product Engineering** Michael Abramovici, Rainer Stark, 2013-03-14 The collection of papers in this book comprises the proceedings of the 23rd CIRP Design Conference held between March 11th and March 13th 2013 at the Ruhr Universit t Bochum in Germany The event was organized in cooperation with the German Academic Society for Product Development WiGeP The focus of the conference was on Smart Product Engineering covering two major aspects of modern product creation the development of intelligent smart products as well as the new smart approach of engineering explicitly taking into account consistent systems integration Throughout the 97 papers contained in these proceedings a range of topics are covered amongst them the different facets and aspects of what makes a product or an engineering solution smart In addition the conference papers investigate new ways of engineering for production planning and collaboration towards Smart Product Engineering The publications provide a solid insight into the pressing issues of modern digital product creation facing increasing challenges in a rapidly changing industrial environment They also give implicit advice how a smart product or engineering solution processes methods and tools needs to be designed and implemented in order to become successful *Encyclopedia of American Civil Liberties* Paul Finkelman, 2021-02-25 Originally published in 2006 the Encyclopedia of American Civil

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