GLOBAL WARRANTY

FORM

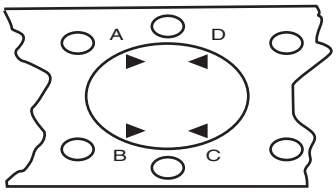
Cylinder Liner Measurement

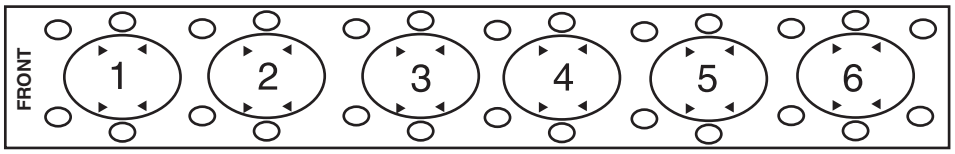
Liner Projection Measurement Worksheet

Date	Meter (Mi/Km)	VIN / Truck Serial No.	Engine Serial No.

Hours

NOTE Tolerances and Dimensions listed in SEBF9008 supersede this form





Liner Projection Measurements

Identify Block Machine Process

_____ A or B

A) Counterbore with Shims (In-Frame Process):
Max 0.1500 mm (0.0060 in)
Min **0.0889 mm (0.0035 in)**

B) Machine Top Deck (With Insert / Out of Frame Process):
Max 0.150 mm (0.006 in)
Min **0.025 mm (0.001 in)**

1A	3A	5A
1B	3B	5B
1C	3C	5C
1D	3D	5D
Sum Cyl 1	**Sum cyl 3**	**Sum cyl 5**
Avg cyl 1	**Avg cyl 3**	**Avg cyl 5**
2A	4A	6A
2B	4B	6B
2C	4C	6C
2D	4D	6D
Sum Cyl 2	**Sum cyl 4**	**Sum cyl 6**
Avg cyl 2	**Avg cyl 4**	**Avg cyl 6**

Global Warranty Form (7/18)
https://warranty.cat.com/wtyguide

Dealer and Dealers are defined as any Cat Authorized Dealer or Cat Authorized Repair Representative.

MAX Variation Each Cylinder

Max 0.051 mm (0.002 in)

Max 1A-1D	
Min 1A-1D	
Variation	
Max 2A-2D	
Min 2A-2D	
Variation	
Max 3A-3D	
Min 3A-3D	
Variation	
Max 4A-4D	
Min 4A-4D	
Variation	
Max 5A-5D	
Min 5A-5D	
Variation	
Max 6A-6D	
Min 6A-6D	
Variation	

MAX Variation of AVG Between Adjacent Liners

Max 0.051 mm (0.002 in)

AVG Liner 1	
AVG Liner 2	
Variation	
AVG Liner 2	
AVG Liner 3	
Variation	
AVG Liner 3	
AVG Liner 4	
Variation	
AVG Liner 4	
AVG Liner 5	
Variation	
AVG Liner 5	
AVG Liner 6	
Variation	

MAX Variation of AVG

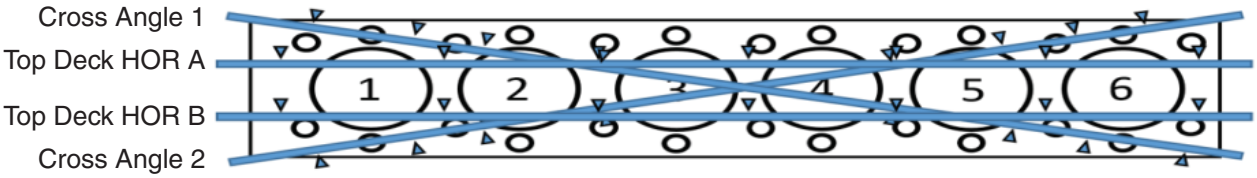
Under each cylinder head
Max 0.102 mm (0.004 in)

Max AVG 1-6	
Min AVG 1-6	
Variation	

Cylinder Block Flatness

The total flatness of the top contact surface of the cylinder block must be within 0.10 mm (0.004 inch). The flatness must also be within 0.05 mm (0.002 inch) for any 150 mm (6 inch) section of the surface.

	Overall Flatness	Max for any 6 " Span
Max Variation in Flatness - Cross Angle 1		
Max Variation in Flatness - Cross Angle 2		
Max Variation in Flatness - HOR A		
Max Variation in Flatness - HOR B		



Technician Signature

Print Name