

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.

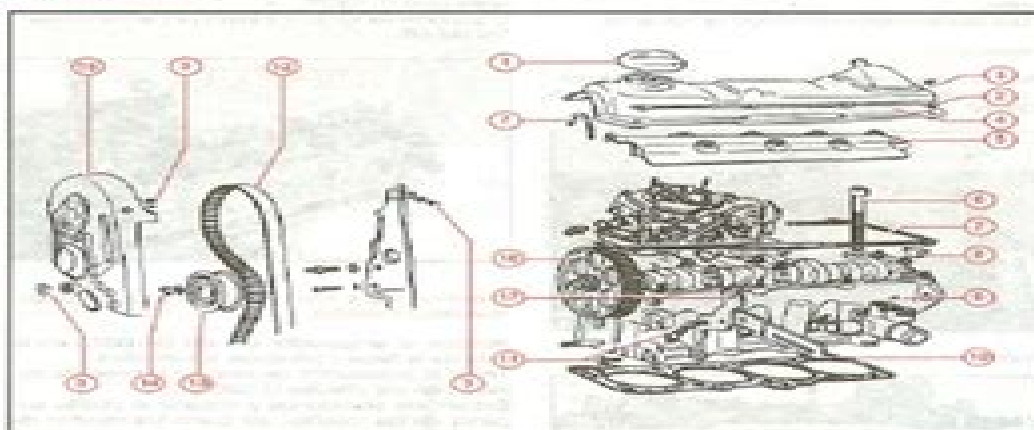
Ejecutar la medición con un calibre de espesores.
El juego axial máximo permitido es de 0,27 mm.

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.
No girar el cigüeñal.
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.
Acotar 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 del distribuidor de encendido, el cable de alta tensión de la bobina y conectarlo a masa.



Aplicar el compresómetro 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 17-18P	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.

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