



Cylinder Bore Repair Options for Komatsu 95 Series Diesel Engines

The AERA Technical Committee offers the following information for consideration for cylinder bore repair for Komatsu 95 Series diesel engines. This information should be referenced anytime major engine repair is occurring.

The engine block used in the 95 Series of engines is a parent bore block which does not use a liner/sleeve at original manufacture. Many versions of these engines are built and most offer oversize bore pistons of .020" (.500 MM) and .040" (1.000 MM). If any of the blocks are worn beyond .040" (1.000 MM), the repair liner/sleeve is the required option for future use. Several aftermarket suppliers offer liner/sleeves and standard pistons for these engines.

All versions offer a sleeve repair which could be considered a repair sleeve even though it incorporates an upper sleeve flange. Two sleeve options can be used, depending on the final bored diameter. Refer to the graphics shown below to assist in repairing worn bores for these engines.

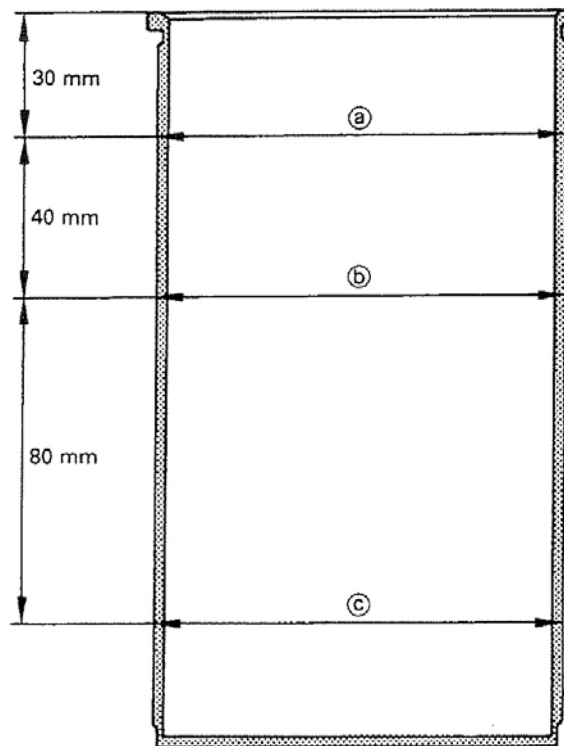


Figure 1. Measurement Locations



Choose the liner/sleeve A or B which best matches the final bored diameters shown in the chart below.

Outside diameter of cylinder liner

Unit: mm

Part No.	Category mark		Measurement location			[Remark] Machined dimension of cylinder
	Letter	Line	Ⓐ	Ⓑ	Ⓒ	
6207-21-2110 ※ 6354-21-2210	A	I	98 +0.020 +0.005	98 +0.025 -0.010	98 +0.025 -0.020	98 +0.0125 0
6207-21-2120 ※ 6354-21-2220	B	II	98 +0.035 +0.020	98 +0.040 +0.005	98 +0.040 -0.005	98 +0.0250 +0.0125

※: For alcohol engine

(continued on the next page)

• Honing

At this position, measure the diameter into two directions as shown in the diagram below, and stamp at the position in Fig. 2 according to the average diameter.

