



Mercedes-Benz

service information

TO: ALL MERCEDES-BENZ PASSENGER CAR DEALERS

DATE: February 1997 (supersedes S.I. MBNA 01/9a, July 1993)

REF. NO. MBNA 01/9B

Revision: *Updated with revised engine applications and parts information.*

SUBJECT: ENGINES 116, 117, 119
REBUILDING LIGHT-ALLOY ENGINE BLOCKS
WITH ALUMINUM PISTON BORE SLEEVES

In order to reduce repair costs when rebuilding 116/117/119 light-alloy engine blocks, aluminum sleeves (refer to page 2) are now available for these engines through the PDC.

These sleeves should only be installed and machined/honed by a machine shop that is capable of carrying out this kind of work to Mercedes-Benz specifications.

The quantity of sleeves needed to repair an engine block should be ordered by your dealership and then shipped together with the block to the nearest suitable machine shop for installation and machining/honing.

Page 3 gives a listing of machine shops which have been contacted by MBNA technical personnel and are suitable and willing to perform these engine block repairs to our specifications

Order No. S-SI-MBNA-01/9B

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Technical Information

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Parts Information

Engine	Engine serial number ¹⁾	Piston bore sleeve part number	Crankcase design
116.960/961/ 962/963	-	Q 4 01 0003	Closed deck
116.965	-	Q 4 01 0002	Closed deck
117.963/967/ 968	-	Q 4 01 0004	Closed deck
119.960	-	117 011 02 10 ²⁾	Closed deck
119.971/975/ 981/985	119 011 06 01	119 011 02 10 ²⁾	Closed deck
	119 011 08 01	119 011 02 10 ²⁾	Closed deck
	119 011 10 01	119 011 02 10 ²⁾	Closed deck
	119 011 12 01	119 011 02 10 ²⁾	Closed deck
	119 011 14 01	119 011 02 10 ²⁾	Closed deck
	119 011 16 01	119 011 02 10 ²⁾	Closed deck
	119 011 18 01	119 011 02 10 ²⁾	Closed deck
	119 011 22 01	119 011 02 10 ²⁾	Open deck
119.970/972/ 974/980/982	119 011 07 01	119 011 01 10 ²⁾	Closed deck
	119 011 09 01	119 011 01 10 ²⁾	Closed deck
	119 011 11 01	119 011 01 10 ²⁾	Closed deck
	119 011 13 01	119 011 01 10 ²⁾	Closed deck
	119 011 15 01	119 011 01 10 ²⁾	Closed deck
	119 011 17 01	119 011 01 10 ²⁾	Closed deck
	119 011 19 01	119 011 01 10 ²⁾	Closed deck
	119 011 23 01	119 011 01 10 ²⁾	Closed deck
	119 011 24 01	119 011 01 10 ²⁾	Open deck

¹⁾ The number is cast on the side left behind the engine support

²⁾ The material of the piston bore sleeve is identical to the crankcase

Machining dimensions in crankcase

Piston bore sleeve ¹⁾	119 01 01 10 119 01 02 10	117 011 02 10 119 011 01 10
Basic bore for piston bore sleeve	95.500 – 95.535 mm	100.00 – 100.035 mm
Basic bore for liner collar	97.500 – 97.535 mm	102.00 – 102.035 mm
Insertion depth for liner collar seat	4.4 – 4.5 mm	4.4 – 4.5 mm

¹⁾ The piston bore sleeve in the crankcase can be widened to standard size and 1st repair size +0.5 mm.

Motor Works, Inc.
1460 Island Ave.
SAN DIEGO, CA 92101
(619) 233-8875

German Engine Rebuilding
2707 N. Orange Blossom Trail
ORLANDO, FL. 32804
(407) 423-2977

Universal Air Motive
3700 Deerfield Rd.
RIVERWOODS, IL 60015
(708) 537-4464

Mr. Myron Cottrell
4255 Co. Rd. 10 East
CHASKA, MN. 53318
(602) 448-5330

Weston Machine Co.
161 11th Street
PISCATAWAY, NJ. 08854
(908) 752-2711

Bearing Service
1040 North-West Everett St.
PORTLAND, OR. 97209
(503) 222-1366

Arthur Garage Inc.
2536 Dickinson Pkwy
CARROLLTON, TX. 75006
(214) 245-7701

Heads of America
2233 North 23rd Drive
Phoenix, AZ 85009
(602) 256-0211