ACROSS

1. The block deck must be resurfaced in a surfacing machine that can control the amount of metal removed when it is necessary to match the size of the combustion chambers, this procedure is called __________.  
8. The process of using a course and fine stone is called __________.  
10. During manufacture, all oil holes, called the ___ ______, are drilled from outside the block.  
13. Cylinder blocks with deep gouges may be able to be salvaged by ________ the cylinder.  
14. Coolant flows around the cylinder sleeve, so this type of sleeve is called a __________ _________.  
15. Main bearing bores are called _________.

DOWN

1. Sleeves that are not in contact with the coolant passages are called ______________.  
2. The hone is stroked up and down in the cylinder as it rotates to produce a ______________ on the cylinder wall which aids in proper ring break-in.  
3. After oil holes are drilled, the unneeded open ends may be capped by pipe plugs, steel balls, or cup-type soft plugs, often called ____________.  
4. Coolant passages around the cylinders are often called the ____________.  
5. A ________ is a structural member that attaches to the bottom of the block and supports the crankshaft.  
6. The size of the abrasive is called the ________.  
7. Another name for freeze plugs are __________.  
9. Blocks are often of the ____________ design, which means that the cylinder, water jacket, main bearing supports, and oil passages are all cast as one structure for strength and quietness.  
11. The cylinder head is fastened to the top surface of the block, called the ________.  
12. Many engines use a ________ which ties all of the main bearing caps together to add strength to the lower part of the block.