

Inspect the cylinder bore for wear or damage.
 Measure the cylinder I.D. in X and Y axis at three levels.
 Take the maximum reading to determine the cylinder wear.

SERVICE LIMIT: 65.10 mm (2.563 in)

Calculate the piston-to-cylinder clearance.
 Take a maximum reading to determine the clearance.
 Refer to page 11-6 for measurement of the piston O.D.

SERVICE LIMIT: 0.10 mm (0.004 in)

Calculate the taper and out of round at three levels in X and Y axis, Take the maximum reading to determine them.

SERVICE LIMITS:

- Taper:** 0.10 mm (0.004 in)
- Out of round:** 0.10 mm (0.004 in)

The cylinder must be rebored and an oversize piston fitted if the service limits are exceeded.

The following oversize pistons are available:

- 0.75 mm (0.030 in)
- 1.00 mm (0.039 in)

The piston to cylinder clearance for the oversize piston must be: 0.015–0.050 mm (0.0006–0.0020 in).

CONNECTING ROD INSPECTION

Measure the connecting rod small end I.D.

SERVICE LIMIT: 17.04 mm (0.671 in)

Temporarily install the connecting rod to the crankshaft.
 Install the bearing inserts and bearing cap, and tighten the bolts.
 Measure the connecting rod side clearance.

SERVICE LIMIT: 0.30 mm (0.012 in)

