Inspect the cylinder bore for wear or damage. Measure the cylinder I.D. in X and Y axis at three

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:

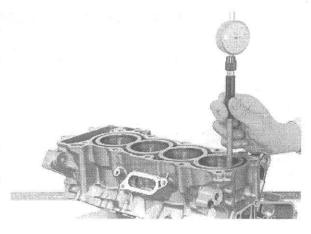
0.75 mm (0.030 in) 1.00 mm (0.039 in)

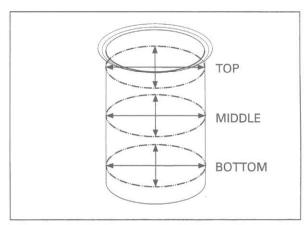
The piston to cylinder clearance for the oversize piston must be: 0.015-0.050 mm (0.0006-0.0020 in).

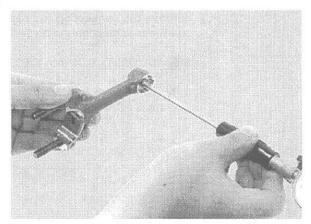
CONNECTING ROD INSPECTION

Measure the connecting rod small end I.D.

SERVICE LIMIT: 17.04 mm (0.671 in)









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)

