

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

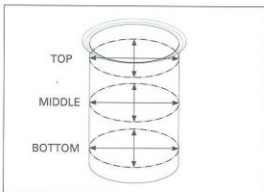
SERVICE LIMITS:

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:
0.25 mm (0.010 in)

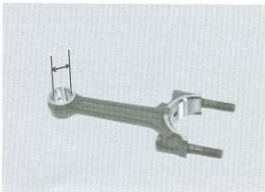
The piston to cylinder clearance for the oversize piston must be: 0.015 – 0.050 mm (0.0006 – 0.0020 in).



CONNECTING ROD INSPECTION

Measure the connecting rod small end I.D.

SERVICE LIMIT: 17.03 mm (0.670 in)



SIDE CLEARANCE INSPECTION

Measure the connecting rod side clearance.

SERVICE LIMIT: 0.30 mm (0.012 in)

If the clearance exceeds the service limit, replace the connecting rod.
 Recheck and if still out of limit, replace the crankshaft.



CRANKPIN BEARING INSPECTION

Clean off any oil from the bearing inserts and crankpin.

Carefully install the crankshaft onto the upper crankcase.

Set the connecting rods onto the crankpin.

Put a strip of plastigauge lengthwise on the crankpin, avoiding the oil hole.

