

## INSPECTION

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

Take the maximum reading to determine the cylinder wear.

**SERVICE LIMIT: 50.10 mm (1.972 in)**

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

**SERVICE LIMIT:**

**Taper: 0.05 mm (0.002 in)**

**Out of round: 0.05 mm (0.002 in)**

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

The following oversize pistons/piston rings are available:

**0.25 mm (0.010 in)**

**0.50 mm (0.020 in)**

**0.75 mm (0.030 in)**

**1.00 mm (0.039 in)**

The piston to cylinder clearance for the oversize piston must be: 0.005 – 0.035 mm (0.0002 – 0.0014 in).

Check the cylinder for warpage with a straight edge and feeler gauge in the directions shown.

**SERVICE LIMIT: 0.05 mm (0.002 in)**

## INSTALLATION

Install the dowel pins and a new gasket.

