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)

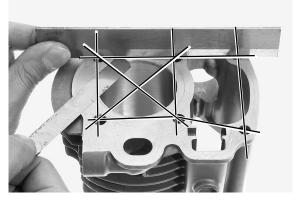
0.75 mm (0.030 in)

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.

