

CRANKCASE/PISTON/CYLINDER

Measure the piston pin bore.

SERVICE LIMIT: 19.03 mm (0.749 in)

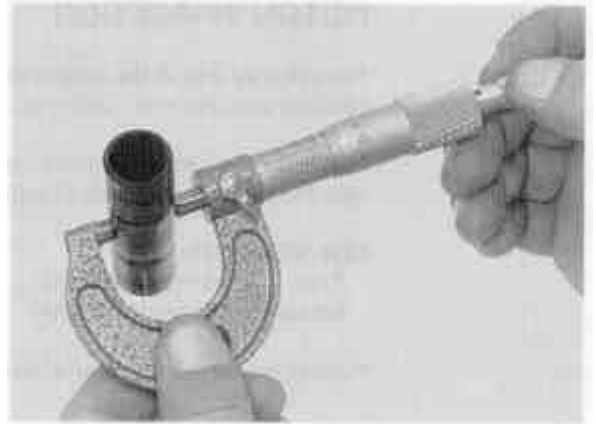


Measure the O.D. of the piston pin.

SERVICE LIMIT: 18.984 mm (0.7474 in)

Calculate the piston-to-piston pin clearance.

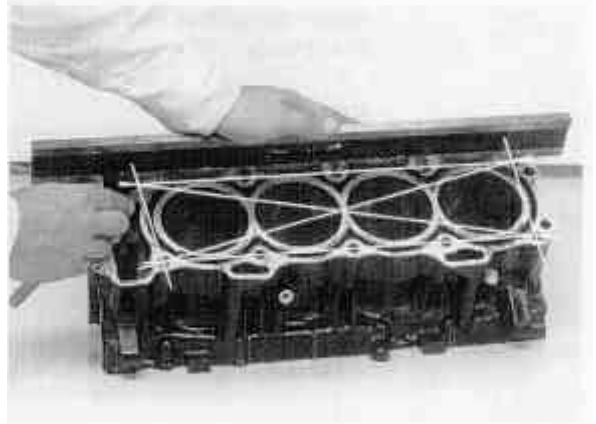
STANDARD: 0.002–0.014 mm (0.0001–0.0006 in)



CYLINDER INSPECTION

Inspect the top of the cylinder for warpage.

SERVICE LIMIT: 0.05 mm (0.002 in)



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: 79.10 mm (3.114 in)

Calculate the piston-to-cylinder clearance.
Take a maximum reading to determine the clearance.
Refer to page 11-5 for measurement of the piston O.D.

STANDARD: 0.010–0.045 mm (0.0004–0.0018 in)

