



Inspection

Cylinder

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: 81.545 mm (3.2104 in)

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

Service limit:

Taper: 0.05 mm (0.002 in)

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

Inspect the top of the cylinder for warpage.

Service limit: 0.05 mm (0.002 in)



Piston/Piston Ring

Remove the carbon deposits from the piston head or piston ring grooves using old piston rings.

Inspect the piston for damage and the ring grooves for wear.



Temporarily install the piston rings to their proper position with the mark facing up.

Measure the piston ring groove clearance with the rings pushed into the grooves.

Service limit:

Top: 0.125 mm (0.0049 in)

Second: 0.075 mm (0.003 in)

Inspect the piston ring grooves for wear or damage.