

- 2) Piston diameter inspection
Measure the piston at the skirt. (Fig. 39)

Item	Standard value	Serviceable limit	
Piston diameter	CB100 CL100 SL100	50.47–50.49mm (1.987–1.988 in.)	50.3mm (1.980 in.)
	CB125S CD125S SL125	55.97–55.99mm (2.2035–2.2043 in.)	55.80mm (2.1968 in.)

Replace if beyond the serviceable limit.

- 3) Measure the piston ring side clearance using a thickness gauge. Replace the piston ring or piston if beyond the serviceable limit.

Item	Standard value	Serviceable limit
Piston ring side clearance	0.025–0.030mm (0.0008–0.0011 in.)	0.7mm (0.0275 in.)

- 4) Piston ring gap

Insert the piston ring into the cylinder so that it is normal to the cylinder axis and then measure the ring gap using a thickness gauge. (Fig. 40)

Item	Standard value	Serviceable limit
Top and second rings	0.15–0.35mm (0.0059–0.0138 in.)	0.5mm max. (0.0197 in.)
Oil ring	0.15–0.04mm (0.0059–0.0158 in.)	0.5mm max. (0.0197 in.)

Replace if beyond the serviceable limit.

C. Reassembly

- 1) Assemble the piston ring on the piston.

Note:

The ring marking located adjacent to the ring gap should be toward the top. (Fig. 41)

When installing new piston rings, roll the rings over their respective piston ring grooves to make sure that the ring side clearances are adequate. Rings should roll smoothly.

- 2) Install the piston. (Fig. 42)

Note:

Install the piston so that the IN marking on the piston head is toward the rear.

Replace all piston pin clips with new items.

- 3) Space the piston ring gaps equally apart (120°) and then install the cylinder.

Note:

Do not forget to install the two dowel pins in the mounting base.

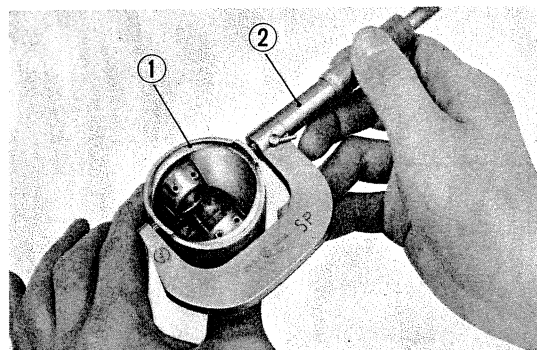


Fig. 39 Piston diameter measurement
① Piston ② Micrometer

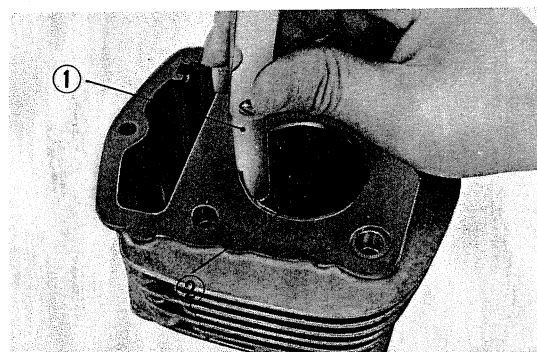


Fig. 40 Piston ring gap measurement
① Thickness gauge ② Piston ring

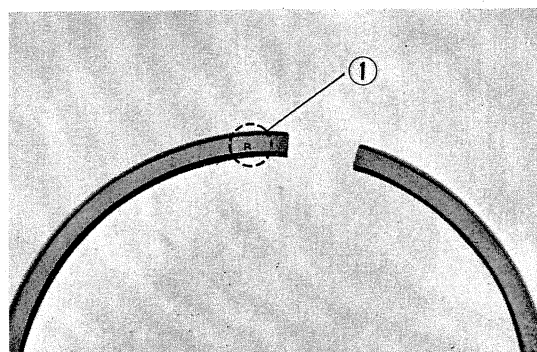


Fig. 41 ① Piston ring marking

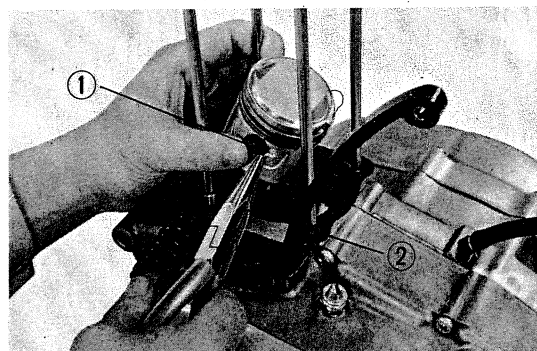


Fig. 42 Piston installation
① Piston pin clips ② Long nose pliers