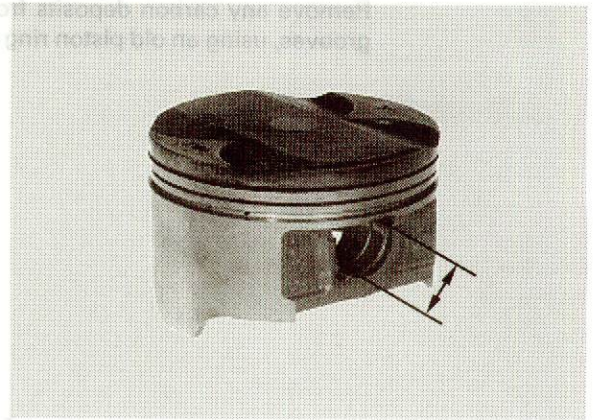


## CRANKCASE/PISTON/CYLINDER

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.

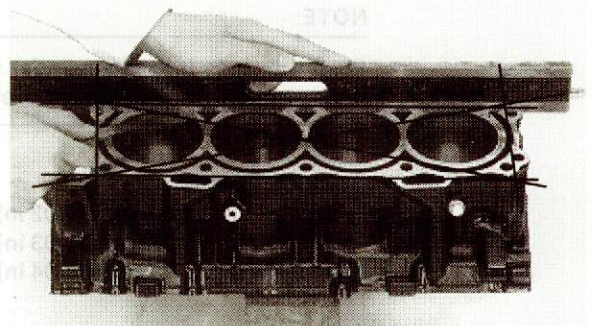
**STANDARD:** 0.002 – 0.014 mm (0.0001 – 0.0006 in)



### 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)

