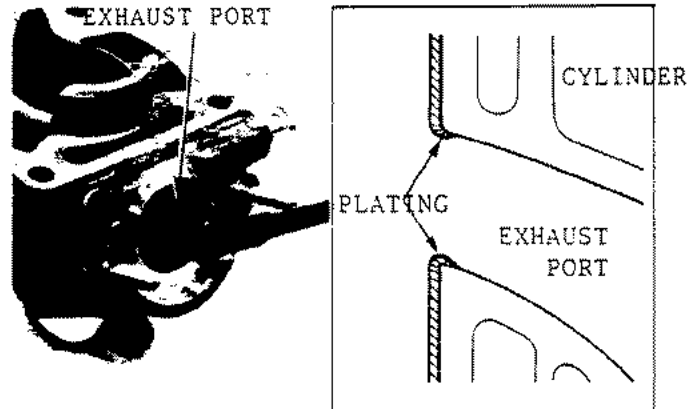


CYLINDER INSPECTION

Clean exhaust port of carbon deposits

* When removing carbon deposits from cylinder and exhaust port entrance, be careful not to cause damage

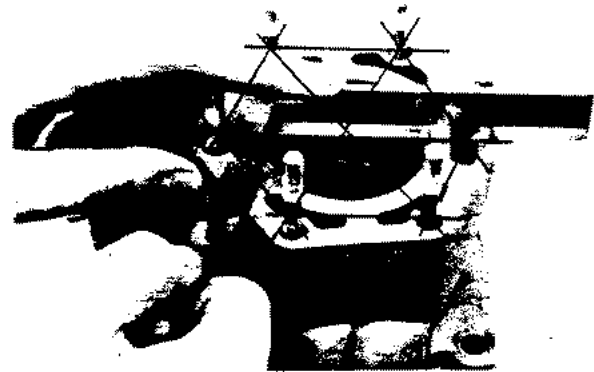


Inspect cylinder upper face warpage with a straight edge and thickness gauge

Service Limit: 0.05mm

inspect cylinder and piston for damage & wear

Measure the internal diameter at right angles to the piston pin direction (X-Y) at top, middle and lower 6 points
Each measurements largest value is the cylinder I.D. valve



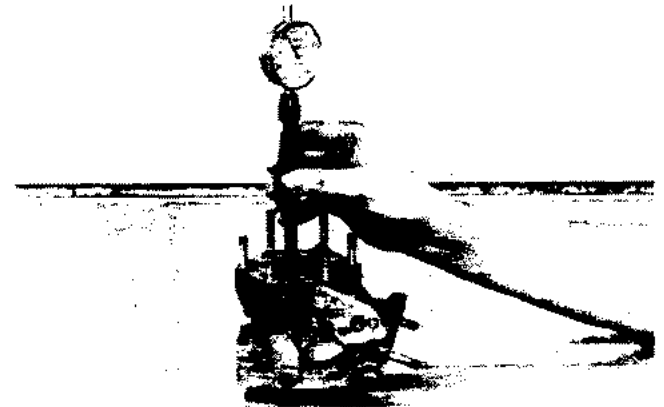
Service limit: Mark A 54.085mm] Replace
Mark B 54.080mm] - if
Mark C 54.075mm] above

Check the cylinder-to -piston clearance
Identify the largest clearance

Service limit: 0.08mm (replace if above)

Measure the piston O.D. (7.7)

After measuring each valve calculate the circular and cylindrical diameters, and obtain the largest degree of difference at each point (X,Y) at top, middle and bottom



Circular: 0.05mm (replace if above)
Cylindrical: 0.05mm (replace if above)

* When replacing cylinder, always select the matching piston and assemble

Cylinder replace warning: Relating to marks (7-8)

