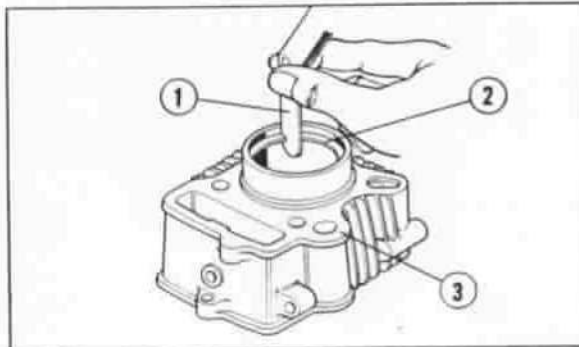
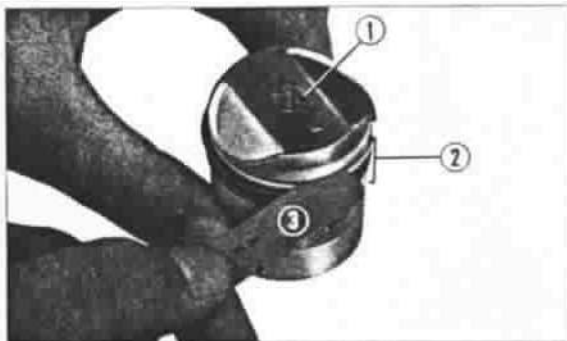




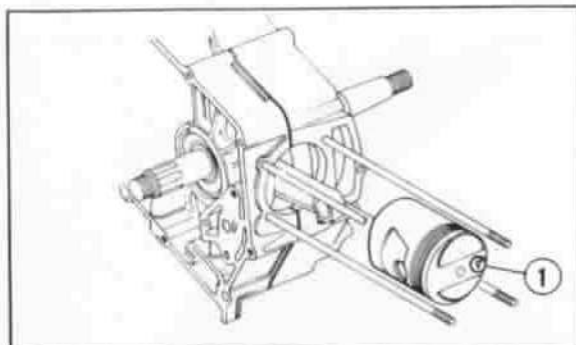
① Micrometer ② Piston diameter
Fig. 30



① Thickness gauge ② Piston ring ③ Cylinder
Fig. 31



① Piston ② Piston rings ③ Thickness gauge
Fig. 32



① Arrow mark
Fig. 33

C. Inspection

1. Measuring the piston

Measure the piston diameter at the piston skirt at right angle to the piston pin axis using a micrometer (Fig. 30).

Standard Value	Serviceable Limit
1.5346~1.5354 (38.98~39.00 mm)	Replace if under 1.73 (38.88 mm)

2. Measuring the piston ring end gap

Insert the piston ring into the cylinder skirt and measure the ring end gap with a thickness gauge (Fig. 31).

Standard Value	Serviceable Limit
0.004~0.012 (0.1~0.3 mm)	Replace if over 0.02 (0.5 mm)

Note :

For preventing damage to the piston ring the piston is an available and convenient tool to insert the ring into the cylinder.

3. Measuring the piston ring side clearance

Measure the clearance between the piston ring and piston land with a thickness gauge (Fig. 32).

Item	Standard Value	Serviceable Limit
Top and second rings	0.0006~0.0018 (0.015~0.045 mm)	Replace if over 0.0039 (0.1 mm)
Oil ring	0.0004~0.0018 (0.010~0.045 mm)	Replace if over 0.0039 (0.1 mm)

4. Piston and piston ring are available in four standard oversizes of 0.01 (0.25 mm) up to 0.04 (1.0 mm)

D. Reassembly

Perform the reassembly in the reverse order of disassembly as described on page 9~10 and 13~14.

Note :

When assembling the piston to the connecting rod, make sure that the arrow marked on the piston head is pointing downward. (Fig. 33)