

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

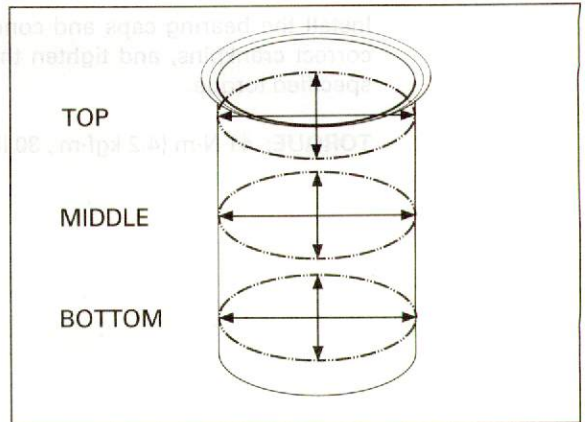
SERVICE LIMITS:

- Taper:** 0.10 mm (0.004 in)
- Out of round:** 0.10 mm (0.004 in)

The cylinder must be rebored and an oversize piston fitted if the service limits are exceeded.

The following oversize pistons are available:
0.50 mm (0.020 in)

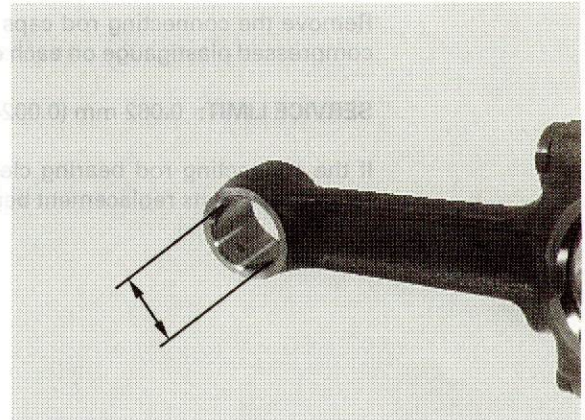
The piston to cylinder clearance for the oversize piston must be: 0.015 – 0.050 mm (0.0006 – 0.0020 in).



CONNECTING ROD INSPECTION

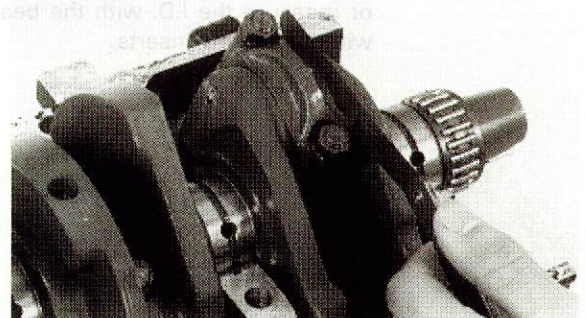
Measure the connecting rod small end I.D.

SERVICE LIMITS: 19.061 mm (0.7504 in)



Temporarily install the connecting rod to the crankshaft.
Install the bearing inserts and bearing cap, and tighten the bolts.
Measure the connecting rod side clearance.

SERVICE LIMITS: 0.30 mm (0.012 in)



CRANKPIN BEARING INSPECTION

Wipe all oil from the bearing inserts and crankpins.
Put a piece of plastigauge on each crankpin.

NOTE:

- Do not put the plastigauge over the oil hole in the crankpin.
- Do not rotate the crankshaft during inspection.

