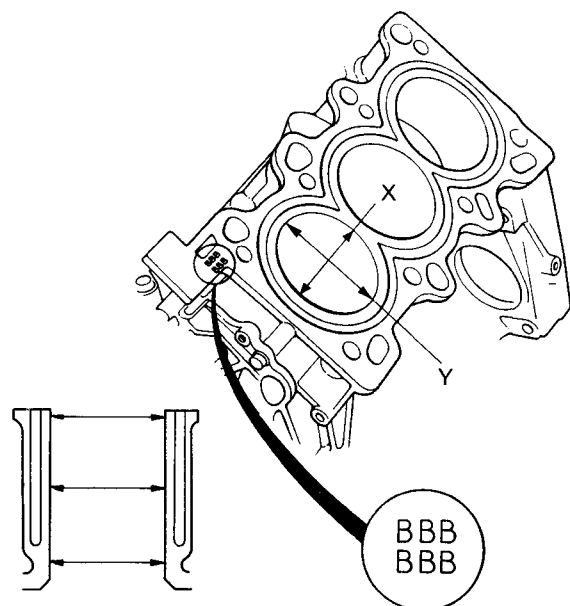




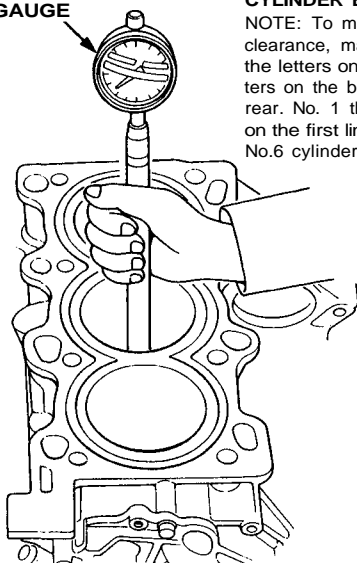
# Cylinder Block

## Inspection

1. Measure wear and taper in directions X and Y at three levels in each cylinder as shown.



CYLINDER BORE GAUGE



### CYLINDER BORE SIZES (A or B)

NOTE: To maintain proper piston clearance, match these letters with the letters on the pistons. The letters on the block read from front to rear. No. 1 through No. 3 cylinders on the first line and No.4 through No.6 cylinders on the second line.

Cylinder Bore Size

	Standard (New)	Service Limit
A	90.010 — 90.020 mm (3.5437 — 3.5441 in)	90.070 mm (3.5461 in)
B	90.000 — 90.010 mm (3.5433 — 3.5437 in)	90.070 mm (3.5461 in)

### Oversize

0.25: 90.250 — 90.270 mm (3.5531 — 3.5539 in)

0.50: 90.500 — 90.520 mm (3.5630 — 3.5638 in)

### Bore Taper

Limit: (Difference between first and third measurement) 0.05 mm (0.002 in)

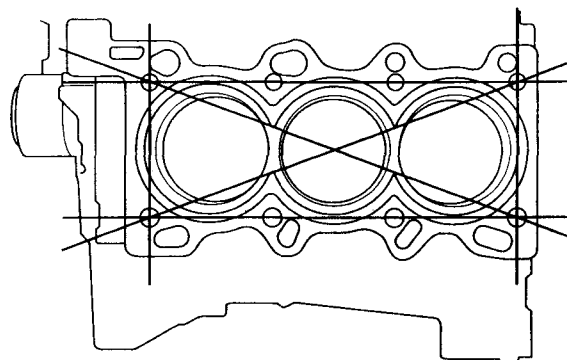
- If measurements in any cylinder are beyond Oversize Bore Service Limit, replace the cylinder block.
- If block is to be rebored, refer to Piston Clearance Inspection (page 7-12) after reboring.

NOTE: Scored or scratched cylinder bores must be honed.

Reboring Limit: 0.5 mm (0.02 in)

2. Check the top of the block for warpage. Measure along the edges and across the center as shown.

### SURFACES TO BE MEASURED



### Cylinder Block Warpage:

Standard (New): 0.07 mm (0.003 in) max.

Service Limit: 0.10 mm (0.004 in)

### PRECISION STRAIGHT EDGE

