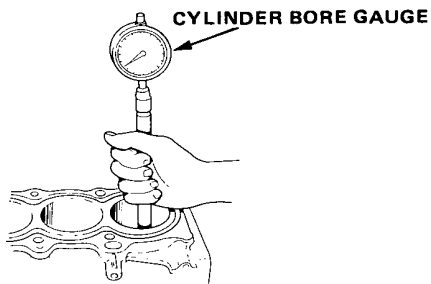
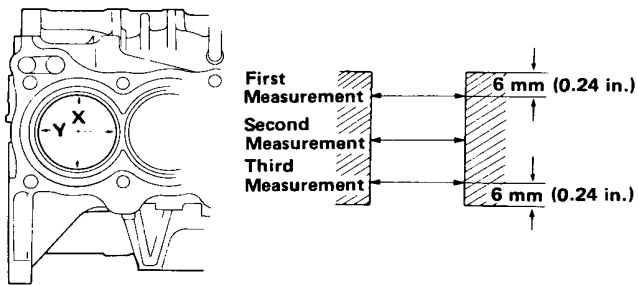


# Cylinder Block

## Inspection

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



### Cylinder Bore Size

Standard (New): 75.00–75.02 mm  
(2.9528–2.9535 in.)

Service Limit: 75.07 mm (2.9555 in.)

### Oversize

Standard 0.25 (New): 75.215–75.248 mm  
(2.9612–2.9625 in.)

Standard 0.5 (New): 75.465–75.498 mm  
(2.9711–2.9724 in.)

### Bore Taper

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

- If measurements in any cylinder is beyond Oversize Bore Service Limit, replace the block.
- If block is to be rebored, refer to Piston Clearance Inspection (page 7-9) after reboring.

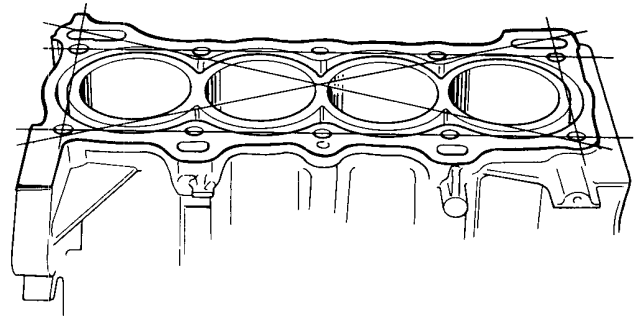
NOTE: Scored or scratched cylinder bores must be honed.

### Out-of-Round

Service Limit: 0.05 mm (0.002 in.)

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

### SURFACES TO BE MEASURED

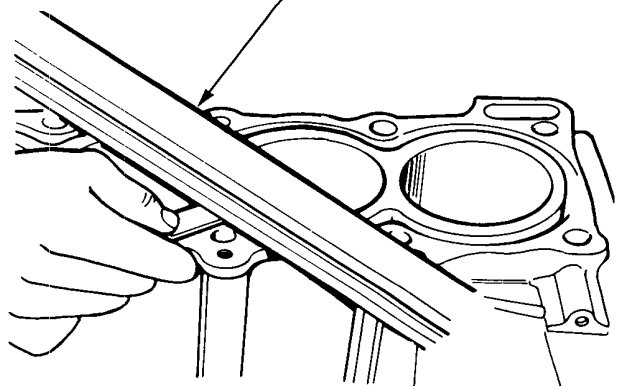


### Engine Block Warpage:

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

Service Limit: 0.10 mm (0.004 in.)

### PRECISION STRAIGHT EDGE

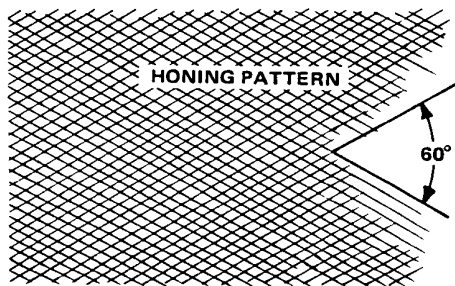




## Piston Pin

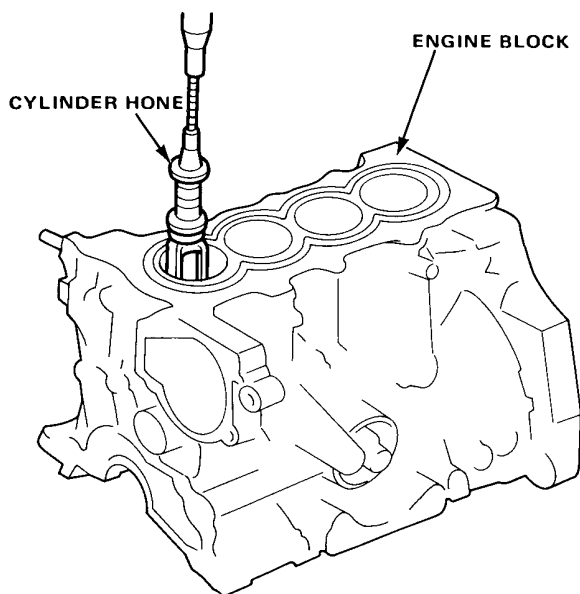
### Cylinder Bore Honing

1. Measure cylinder bores as shown on page 7-10. If the block can be re-used, hone the cylinders, and remeasure the bores.
2. Hone cylinder bores with honing oil and medium (220 grit) stone in a 60 degree cross-hatch pattern.



3. When honing is complete, thoroughly clean the engine block of all metal particles. Wash the cylinder bores with hot soapy water, then dry and oil immediately to prevent rusting.
4. If scoring or scratches are still present in cylinder bores after honing to service limit, rebore the engine block.

**NOTE:** Some light vertical scoring and scratching is acceptable if it is not deep enough to catch your fingernail and does not run the full length of the bore.



### Removal

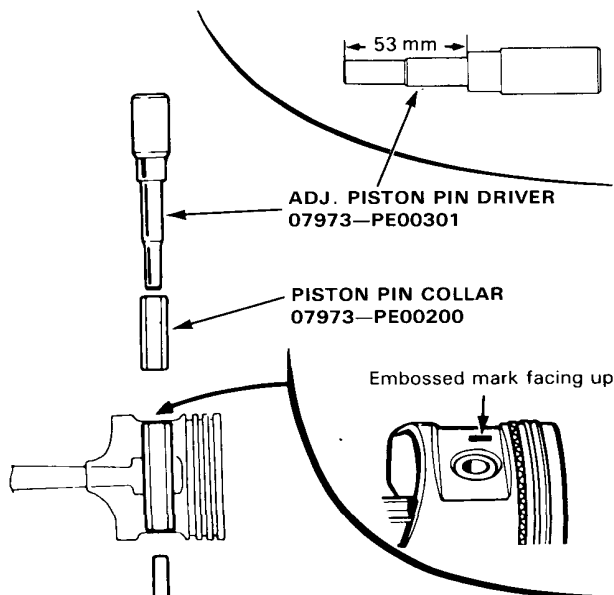
1. Install the attachment on the piston base.

**PISTON BASE HEAD**  
07973-SB00100

**PISTON PIN BASE INSERT**  
07973-PE00400

**PISTON PIN DIS/ASSEMBLY TOOL SET BASE**  
07973-6570002

2. Adjust the length of piston pin driver to 53 mm (2.09 in) as shown.



**NOTE:** Use hydraulic press. When pressing pin in or out, make sure that the recessed portion of the piston aligns with the lips on the collar.

3. Place the piston on the piston base and press the pin out with a hydraulic press.