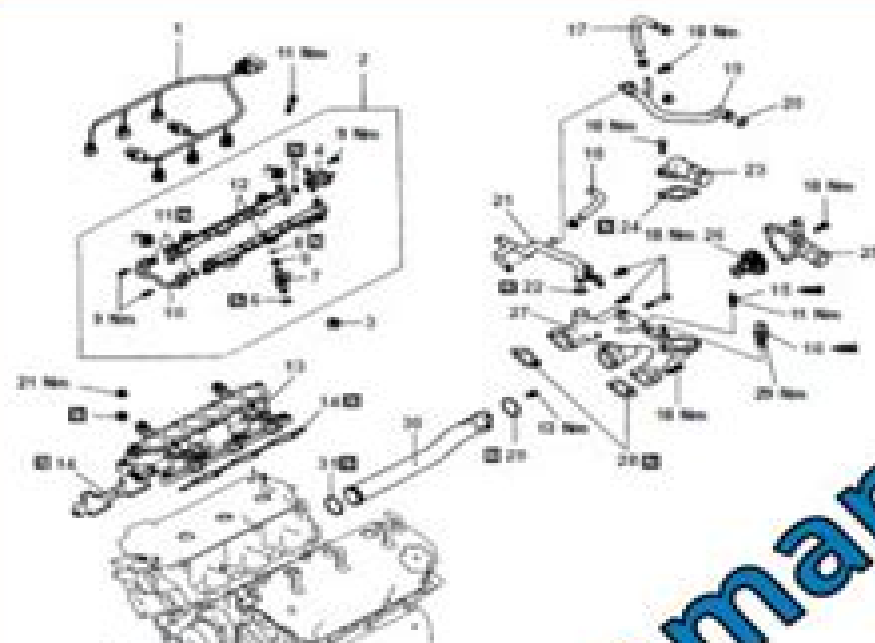


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Removal steps

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- ▶ **A** Timing belt
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BORING CYLINDER

1. Overbore pistons to be used should be determined on the basis of the largest bore cylinder.

Piston size identification

Size	Identification mark
5.50 mm O.S.	0.50
1.00 mm O.S.	1.00

NOTE



4. Use suitable thrust pin before inserting the piston into the cylinder block. Care must be taken when using a suitable thrust pin and connecting rod.
5. Make the correct bearing fit by checking with a micrometer. If a bearing alignment mark, or bearing on the same side.

2. Check if the thrust clearance in the connecting rod big end is correct.
Standard value: 0.10-0.20 mm
Limit: 0.4 mm

INSPECTION

CYLINDER BLOCK

1. Visually check for scratches, rust, and corrosion. Also use a flow detecting agent for the check. If defects are evident, correct, or replace.
2. Using a straightedge and feeler gauge, check the flatness of the block top surface. Make sure that the surface is free from gasket pieces and other foreign matter.
Standard value: 0.05 mm
Limit: 0.1 mm
3. If distortion is excessive, correct within the allowable limit or replace.
Grinding limit: 0.2 mm
*Grinding combined with cylinder head grinding.
Cylinder block height (when new):
210.4-210.6 mm
4. Check the cylinder walls for scratches and seizure. If defects are evident, correct (return to an oversize) or replace.
5. Using a cylinder gauge, measure the cylinder bore and cylindricity. If worn badly, correct by turning the cylinder to an oversize and replace pistons and piston rings. Measure at the points shown in the illustration.
Standard value:
Cylinder ID: 83.0 mm
Concentricity: 0.01 mm



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Lei Huang



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