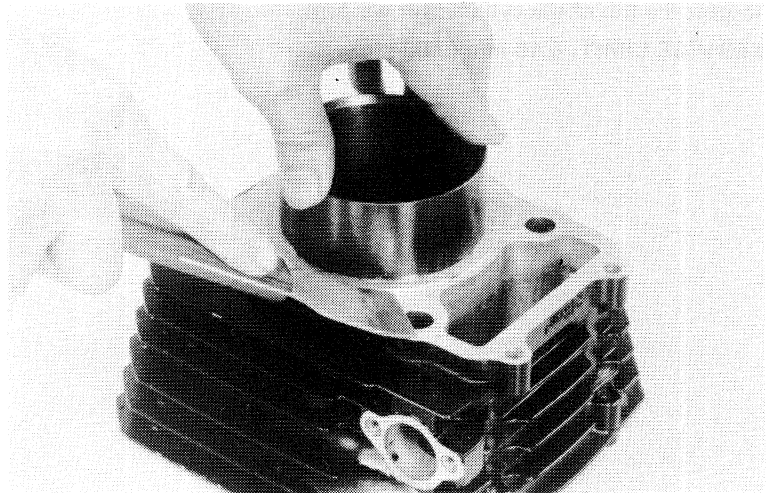


Clean off any gasket material from the cylinder surface.

**NOTE**

Be careful not to remove any metal from the gasket surface.



**CYLINDER INSPECTION**

Inspect the cylinder wall for scratches and wear. Measure and record the cylinder I.D. at three levels in both an X and Y axis for a total of six measurement. Take the maximum reading to determine the cylinder wear.

**SERVICE LIMIT: 74.10 mm (2.917 in)**

Calculate the piston-to-cylinder clearance by taking the maximum reading and subtracting the piston O.D.  
Refer to page 7-5 for measurement of the piston O.D.

**SERVICE LIMIT: 0.10 mm (0.004 in)**

Calculate the cylinder taper by taking the readings at the three levels and subtracting the minimum from the maximum reading.

**SERVICE LIMIT: 0.10 mm (0.004 in)**

Calculate the cylinder out-of-round by checking for a difference between the X and Y readings at each of the three levels.  
If there is any difference, take the maximum reading to determine the out-of-round.

**SERVICE LIMIT: 0.10 mm (0.004 in)**

The cylinder must be rebored, and oversize pistons fitted, if any of the service limits are exceed.

The following oversize pistons are available:  
0.25 mm (0.010 in), 0.50 mm (0.020 in), 0.75 mm (0.030 in) and 1.00 mm (0.039 in)

The cylinder must be rebored so that the clearance to an oversize piston is 0.015–0.045 mm (0.0006–0.0018 in).

