

## CYLINDER INSPECTION

Inspect the cylinder bore for wear or damage.  
Measure the cylinder I.D. in X and Y axis at three levels.  
Take the maximum reading to determine the cylinder wear.

**SERVICE LIMIT: 75.15 mm (2.959 in)**

Calculate the piston-to-cylinder clearance.  
Take a maximum reading to determine the clearance.  
Refer to the procedures for measurement of the piston O.D. (page 13-17).

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

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.

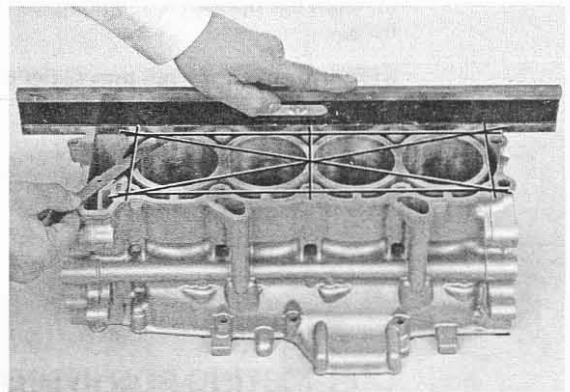
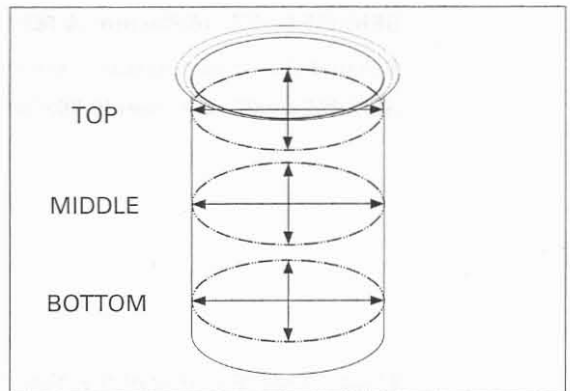
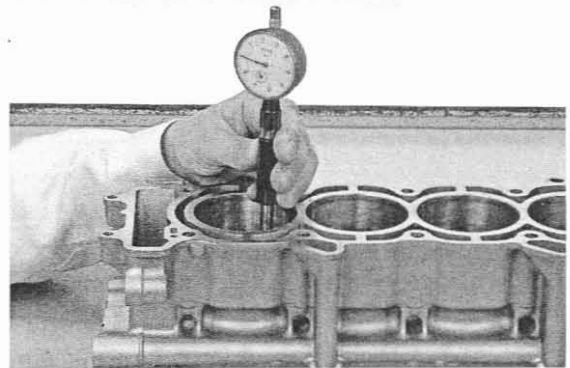
### The following oversize piston is available:

**0.25 mm (0.010 in)**

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

Inspect the top of the cylinder for warpage.

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



## PISTON OIL JET REPLACEMENT

*Always replace the O-ring when the oil jets are removed.*

Remove the bolts and piston oil jets from the upper crankcase.

Inspect the oil jets for clogs, and replace it if necessary.

