

REPLACEMENT

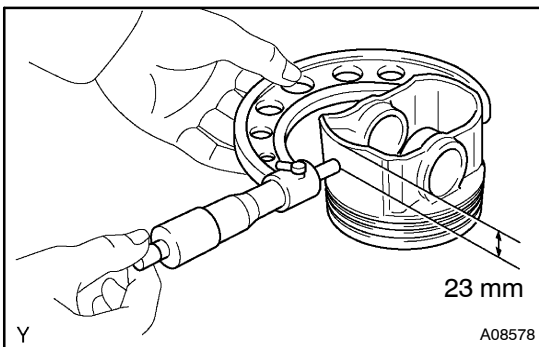
1. REPLACE OVERSIZED (O/S) PISTONS FOR CYLINDER BORING

HINT:

- Bore all the 6 cylinders for the O/S piston outside diameter.
 - Replace all the piston rings with ones to match the O/S pistons.
- (a) Keep 6 new O/S pistons.

O/S 0.50 piston diameter:

75.43 – 75.44 mm (2.9697 – 2.9701 in.)



- (b) Using a micrometer, measure the piston diameter at a right angles to the piston pin center line, 23 mm (0.91 in.) below the skirt bottom edge.
- (c) Calculate the amount of each cylinder to be rebored as follows:

Size to be rebored = P + C - H

P = Piston diameter

C = Piston oil clearance

0.070 – 0.093 mm (0.0028 – 0.0037 in.)

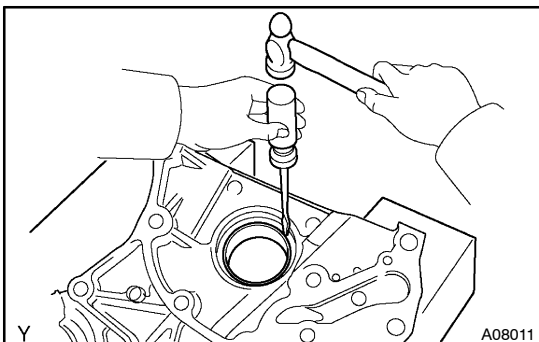
H = Allowance for honing

0.02 mm (0.0008 in.) or less

- (d) Bore and hone the cylinders to calculated dimensions.
Maximum honing: 0.02 mm (0.0008 in.)

NOTICE:

Excess honing will destroy the finished roundness.

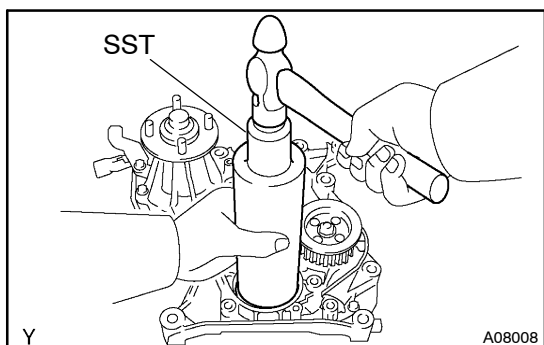


2. REPLACE CRANKSHAFT FRONT OIL SEAL

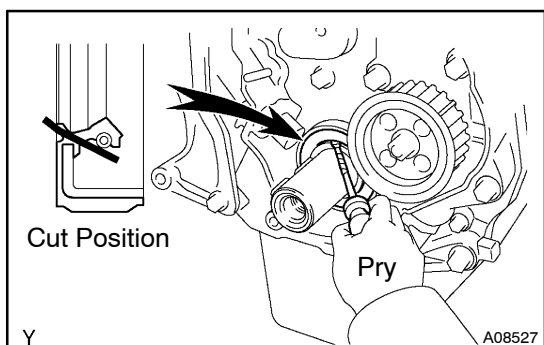
HINT:

There are 2 methods ((a) and (b)) to replace the oil seal.

- (a) If the timing belt case is removed from the cylinder block:
- (1) Using a screwdriver and hammer, tap out the oil seal.



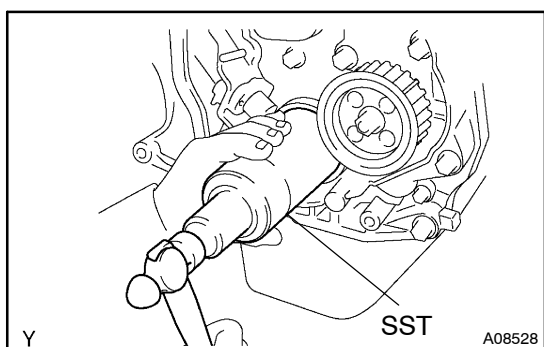
- (2) Using SST and a hammer, tap in a new oil seal until its surface is flush with the timing belt case edge.
SST 09316-60011 (09316-00011)



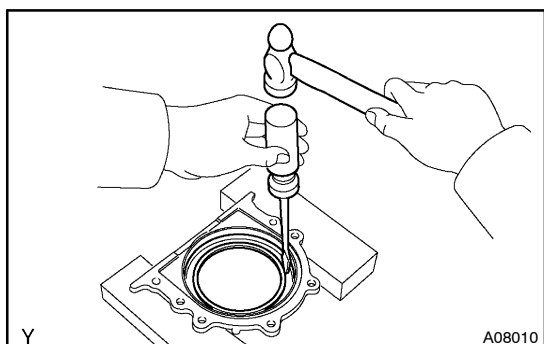
- (b) If the timing belt case is installed to the cylinder block:
(1) Using a knife, cut off the oil seal lip.
(2) Using a screwdriver, pry out the oil seal.

NOTICE:

Be careful not to damage the crankshaft. Tape the screwdriver tip.

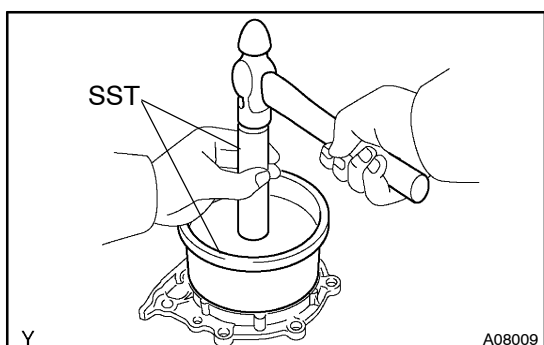


- (3) Using SST and a hammer, tap in the oil seal until its surface is flush with the timing belt case edge.
SST 09316-60011 (09316-00011)

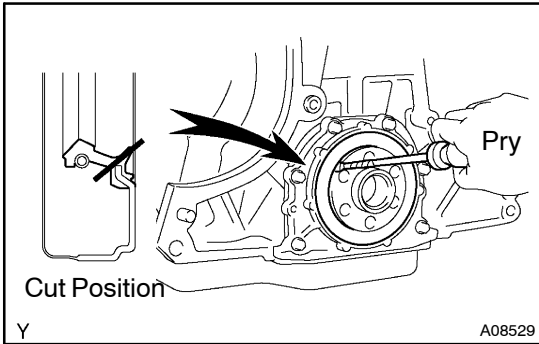
**3. REPLACE CRANKSHAFT REAR OIL SEAL****HINT:**

There are 2 methods ((a) and (b)) to replace the oil seal.

- (a) If the rear oil seal retainer is removed from the cylinder block:
(1) Using a screwdriver and hammer, tap out the oil seal.



- (2) Using SST and a hammer, tap in a new oil seal until its surface is flush with the rear oil seal retainer edge.
SST 09223-15030, 09950-70010 (09951-07100)

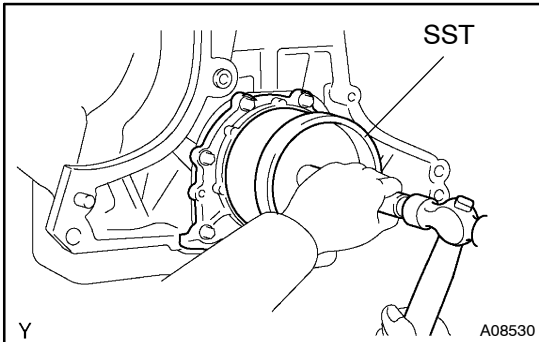


(b) If rear oil seal retainer is installed to cylinder block:

- (1) Using a knife, cut off the oil seal lip.
- (2) Using a screwdriver, pry out the oil seal.

NOTICE:

Be careful not to damage the crankshaft. Tape the screwdriver tip.



- (3) Using SST and a hammer, tap in the oil seal until its surface is flush with the rear oil seal retainer edge.

SST 09223-15030, 09950-70010 (09951-07100)