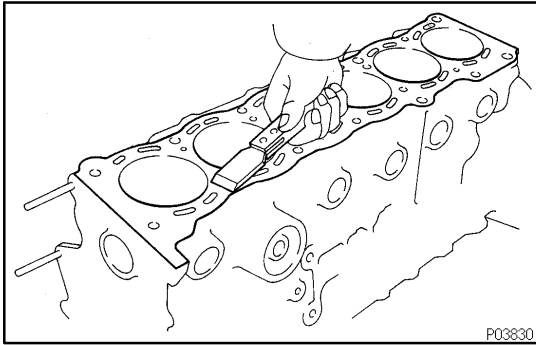
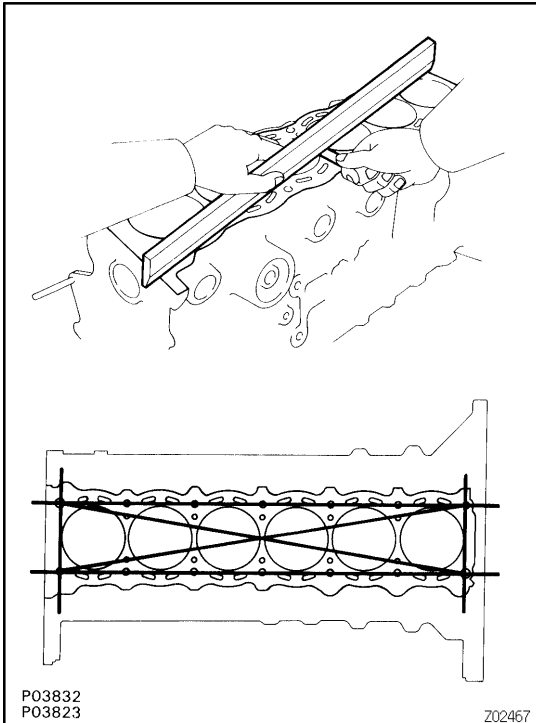




INSPECTION

1. CLEAN CYLINDER BLOCK

- (a) Remove the gasket material.
Using a gasket scraper, remove all the gasket material from the top surface of the cylinder block.
- (b) Clean the cylinder block.
Using a soft brush and solvent, thoroughly clean the cylinder block.



2. INSPECT TOP SURFACE OF CYLINDER BLOCK FOR FLATNESS

Using a precision straight edge and feeler gauge, measure the surfaces contacting the cylinder head gasket for warpage.

Maximum warpage:

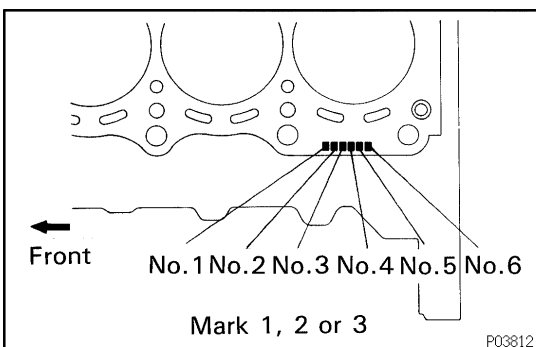
0.05 mm (0.0020 in.)

If warpage is greater than maximum, replace the cylinder block.

3. INSPECT CYLINDER FOR VERTICAL SCRATCHES

Visually check the cylinder for vertical scratches.

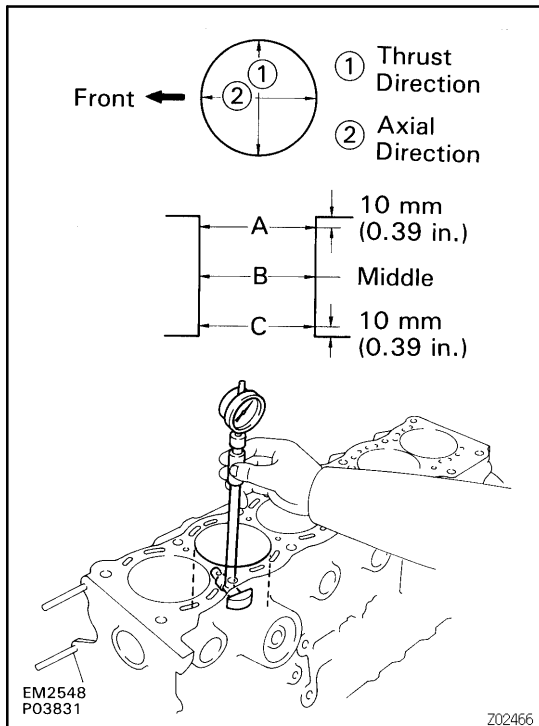
If deep scratches are present, rebore all the 6 cylinders. If necessary, replace the cylinder block.



4. INSPECT CYLINDER BORE DIAMETER

HINT:

There are 3 sizes of the standard cylinder bore diameter, marked "1", "2" and "3" accordingly. The mark is stamped on the top of the cylinder block.



Using a cylinder gauge, measure the cylinder bore diameter at positions A, B and C in the thrust and axial directions.

Standard diameter:

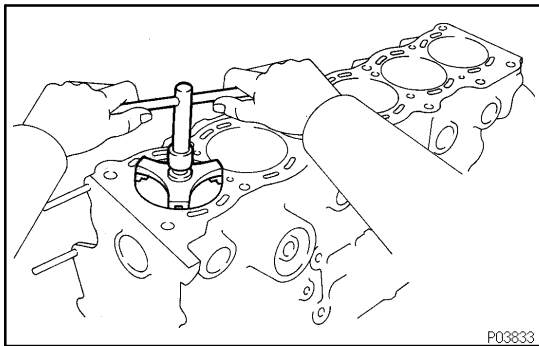
STD

Mark "1"	100.000 – 100.010 mm (3.9370 – 3.9374 in.)
Mark "2"	100.010 – 100.020 mm (3.9374 – 3.9378 in.)
Mark "3"	100.020 – 100.030 mm (3.9378 – 3.9382 in.)

Maximum diameter:

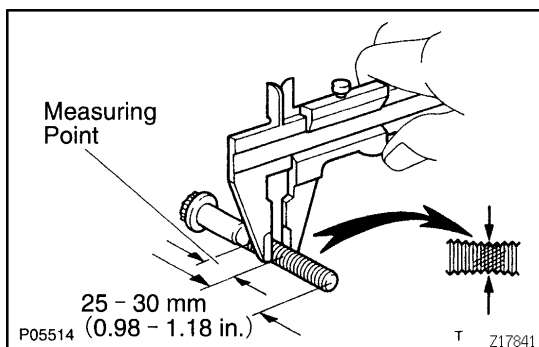
STD	100.23 mm (3.9461 in.)
O/S 0.50	100.73 mm (3.9658 in.)
O/S 1.00	101.23 mm (3.9854 in.)

If the diameter is greater than maximum, rebore all the 6 cylinders. If necessary, replace the cylinder block.



5. REMOVE CYLINDER RIDGE

If the wear is less than 0.2 mm (0.008 in.), using a ridge reamer, grind the top of the cylinder.



6. INSPECT MAIN BEARING CAP BOLTS

Using vernier calipers, measure the thread outside diameter of the bolt.

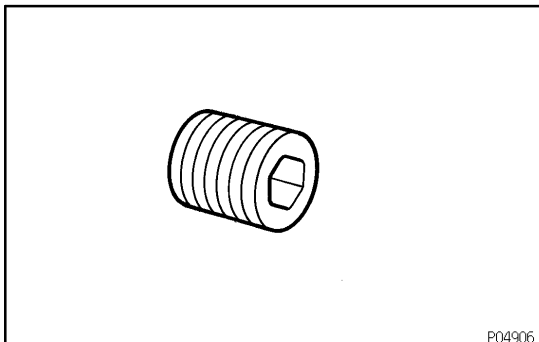
Standard outside diameter:

10.85 – 11.00 mm (0.4271 – 0.4331 in.)

Minimum outside diameter:

10.6 mm (0.417 in.)

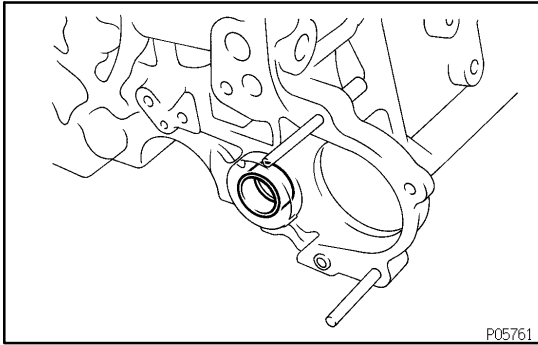
If the diameter is less than minimum, replace the bolt.



7. INSPECT CYLINDER BLOCK OIL ORIFICE

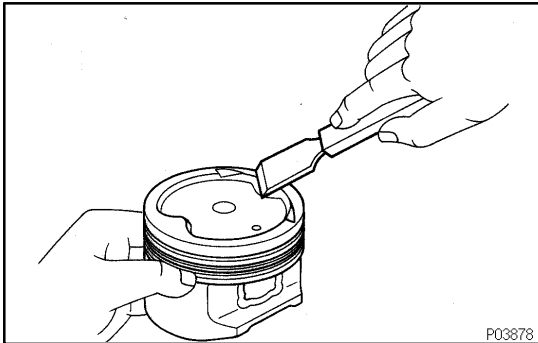
Check the orifice for clogging.

If necessary, replace the orifice.



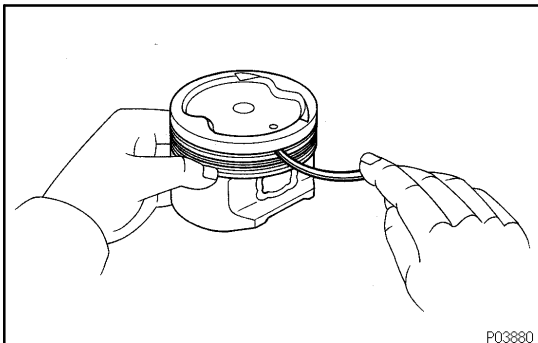
8. INSPECT BEARING OF OIL PUMP DRIVE SHAFT GEAR

Check the bearing for pitting and scratches.
If the bearing is damaged, replace the cylinder block.

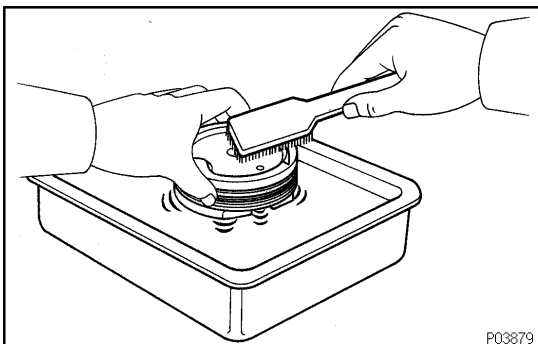


9. CLEAN PISTON

(a) Using a gasket scraper, remove the carbon from the piston top.



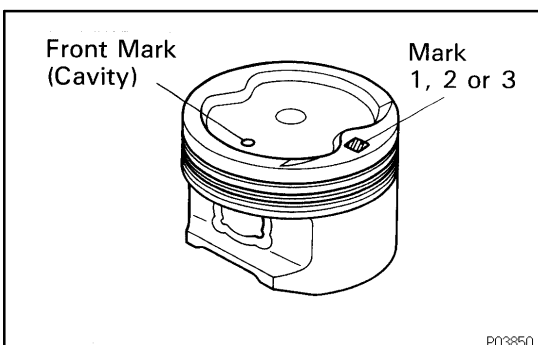
(b) Using a groove cleaning tool or broken ring, clean the piston ring grooves.



(c) Using solvent and a brush, thoroughly clean the piston.

NOTICE:

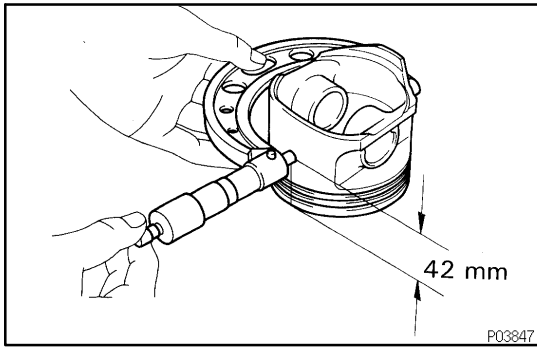
Do not use a wire brush.



10. INSPECT PISTON OIL CLEARANCE

HINT:

There are 3 sizes of the standard piston diameter, marked "1", "2" and "3". The mark is stamped on the piston top.



- (a) Using a micrometer, measure the piston diameter at right angles to the piston pin center line, 42 mm (1.65 in.) from the piston head.

Piston diameter:

STD

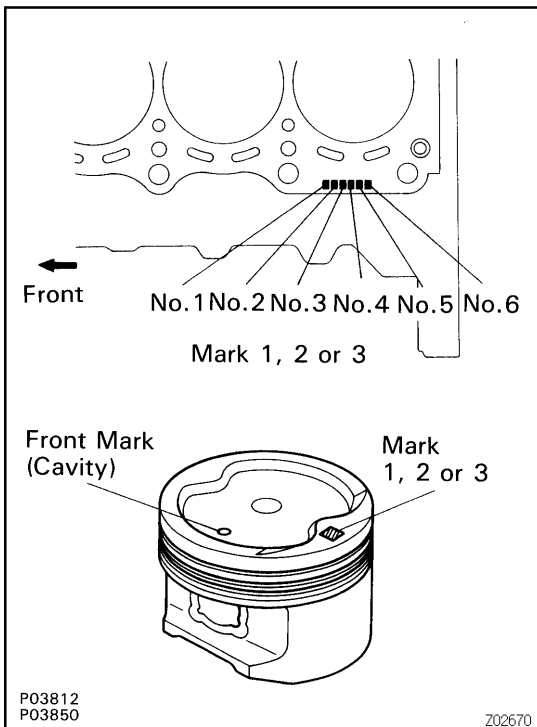
Mark "1"	99.950 – 99.960 mm (3.9350 – 3.9354 in.)
Mark "2"	99.960 – 99.970 mm (3.9354 – 3.9358 in.)
Mark "3"	99.970 – 99.980 mm (3.9358 – 3.9362 in.)

O/S 0.50

100.450 – 100.480 mm (3.9547 – 3.9559 in.)

O/S 1.00

100.950 – 100.980 mm (3.9744 – 3.9756 in.)



- (b) Measure the cylinder bore diameter in the thrust directions (See page EM-95).
- (c) Subtract the piston diameter measurement from the cylinder bore diameter measurement.

Standard oil clearance:

0.040 – 0.060 mm (0.0016 – 0.0024 in.)

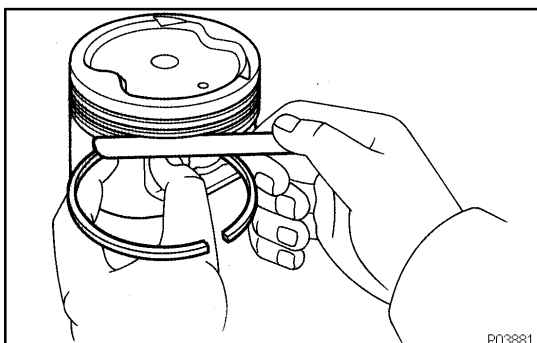
Maximum oil clearance:

0.080 mm (0.0031 in.)

If the oil clearance is greater than maximum, replace all the 6 pistons and rebore all the 6 cylinders. If necessary, replace the cylinder block.

HINT:

Use new cylinder block: Use a piston with the same number mark as the cylinder bore diameter marked on the cylinder block.



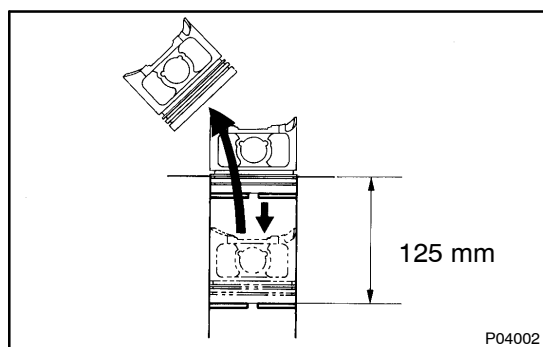
11. INSPECT PISTON RING GROOVE CLEARANCE

Using a feeler gauge, measure the clearance between new piston ring and the wall of the piston ring groove.

Ring groove clearance:

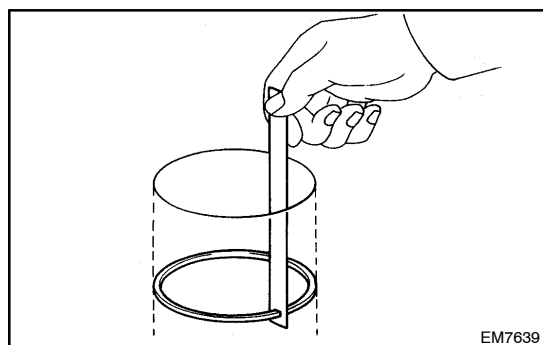
No.1	0.040 – 0.080 (0.0016 – 0.0031 in.)
No.2	0.030 – 0.070 (0.0012 – 0.0028 in.)

If the clearance is greater than maximum, replace the piston.



12. INSPECT PISTON RING END GAP

- Insert the piston ring into the cylinder bore.
- Using a piston, push the piston ring a little beyond the bottom of the ring travel, 125 mm (4.92 in.) from the top of the cylinder block.



- Using a feeler gauge, measure the end gap.

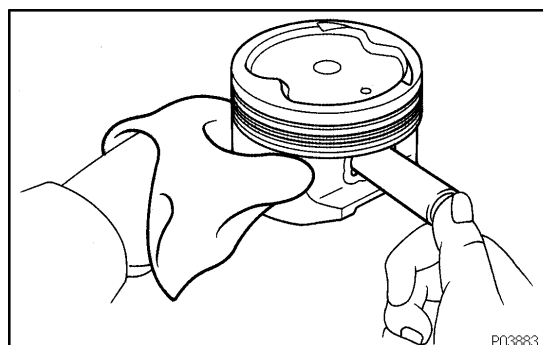
Standard end gap:

No.1	0.300 – 0.520 mm (0.0118 – 0.0205 in.)
No.2	0.450 – 0.670 mm (0.0177 – 0.0264 in.)
Oil (Side rail)	0.150 – 0.520 mm (0.0059 – 0.0205 in.)

Maximum end gap:

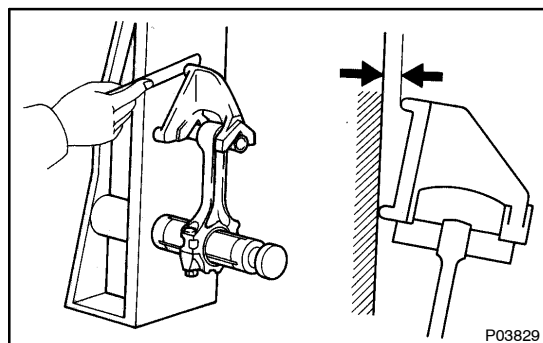
No.1	1.12 mm (0.0441 in.)
No.2	1.17 mm (0.0461 in.)
Oil (Side rail)	1.12 mm (0.0441 in.)

If the end gap is greater than maximum, replace the piston ring.
If the end gap is greater than maximum, even with a new piston ring, rebore all the 6 cylinders or replace the cylinder block.



13. INSPECT PISTON PIN FIT

At 80 – 90°C (176 – 194°F), you should be able to push the piston pin into the piston pin hole with your thumb.



14. INSPECT CONNECTING ROD ALIGNMENT

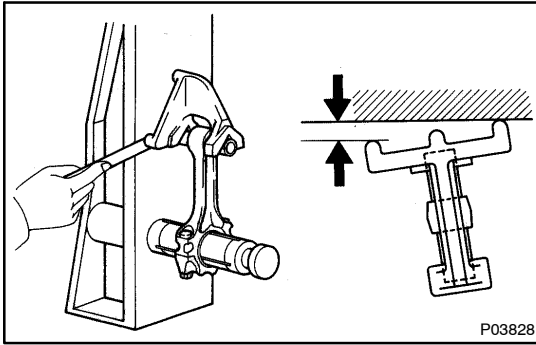
Using a rod aligner and feeler gauge, check the connecting rod alignment.

- Check for bend.

Maximum bend:

0.05 mm (0.0020 in.) per 100 mm (3.94 in.)

If bend is greater than maximum, replace the connecting rod assembly.

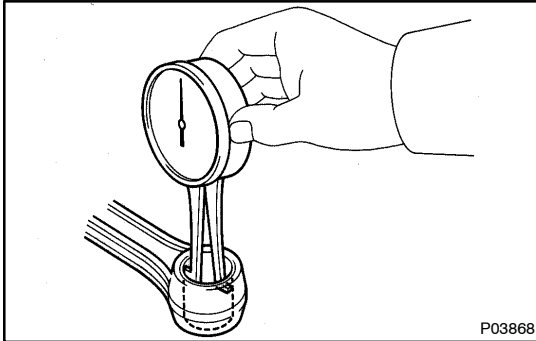


- Check for twist

Maximum twist:

0.15 mm (0.0059 in.) per 100 mm (3.94 in.)

If twist is greater than maximum, replace the connecting rod assembly.

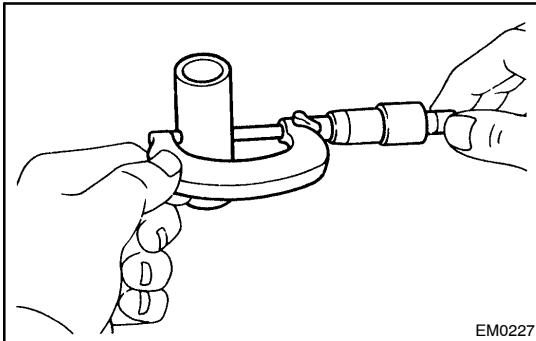


15. INSPECT PISTON PIN OIL CLEARANCE

- (a) Using a caliper gauge, measure the inside diameter of the connecting rod bushing.

Bushing inside diameter:

26.008 – 26.020 mm (1.0239 – 1.0244 in.)



- (b) Using a micrometer, measure the piston pin diameter.

Piston pin diameter:

26.000 – 26.012 mm (1.0236 – 1.0241 in.)

- (c) Subtract the piston pin diameter measurement from the bushing inside diameter measurement.

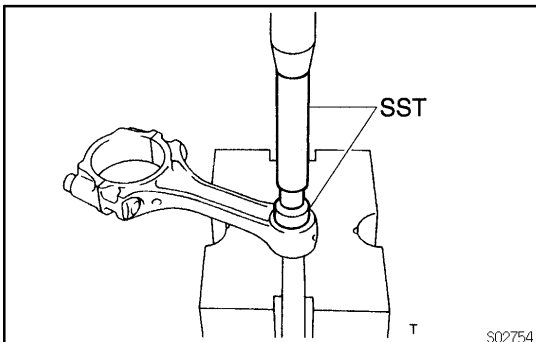
Standard oil clearance:

0.004 – 0.012 mm (0.0002 – 0.0005 in.)

Maximum oil clearance:

0.05 mm (0.0020 in.)

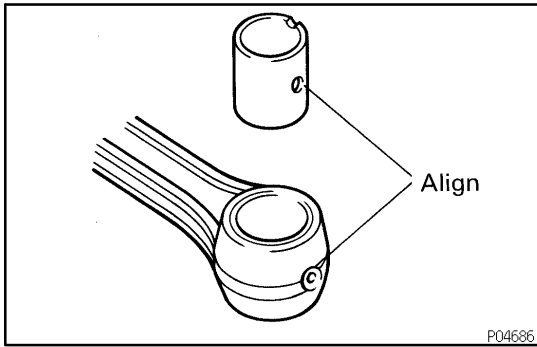
If the oil clearance is greater than maximum, replace the bushing. If necessary, replace the piston and piston pin as a set.



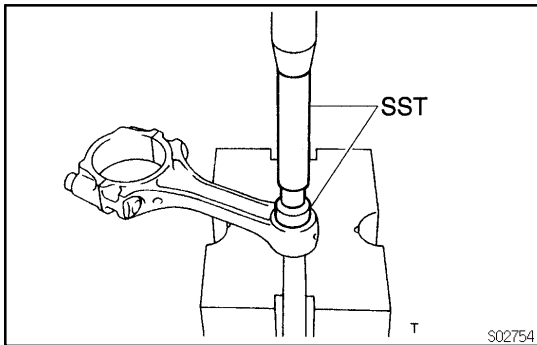
16. IF NECESSARY, REPLACE CONNECTING ROD BUSHING

- (a) Using SST and a press, press out the bushing.

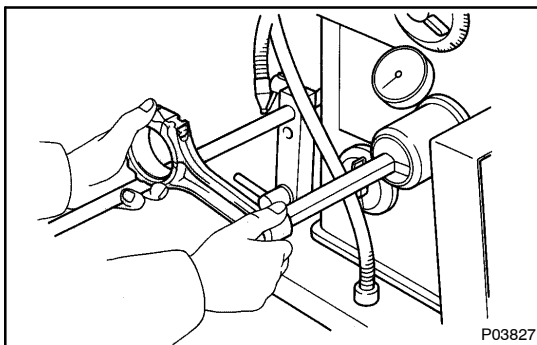
SST 09950-60010 (09951-00260, 09951-00280, 09952-06010), 09950-70010 (09951-07100)



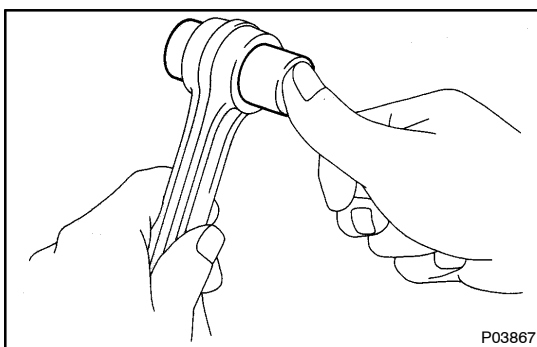
- (b) Align the oil holes of a new bushing and the connecting rod.



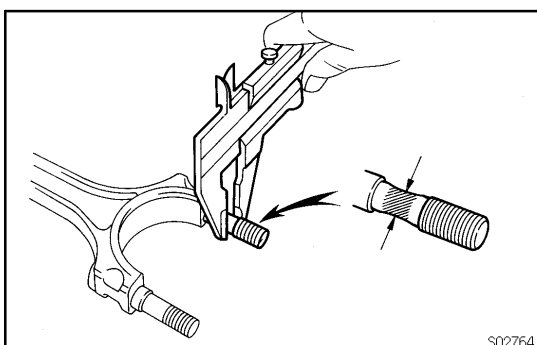
- (c) Using SST and a press, press in the bushing.
SST 09950-60010 (09951-00260, 09951-00280, 09952-06010), 09950-70010 (09951-07100)



- (d) Using a pin hole grinder, hone the bushing to obtain the standard specified clearance between the bushing and piston pin.



- (e) Check the piston pin fit at normal room temperature. Coat the piston pin with engine oil, and push it into the connecting rod with your thumb.



17. INSPECT CONNECTING ROD BOLTS

Using vernier calipers, measure the tension portion of the connecting rod bolt.

Standard diameter:

8.40 – 8.60 mm (0.3307 – 0.3386 in.)

Minimum diameter:

8.00 mm (0.3150 in.)

If the diameter is less than minimum, replace the bolt.

18. CYLINDER BORING

HINT:

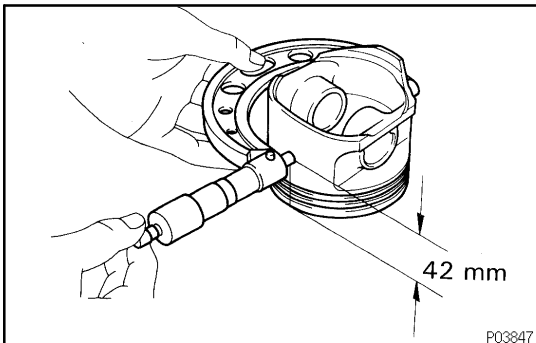
- Bore all the 6 cylinders for the oversized piston outside diameter.
- Replace all the piston rings with ones to match the oversized pistons.

(a) Select the oversized pistons.

Oversized piston diameter:

O/S 0.50	100.450 – 100.480 mm (3.9547 – 3.9559 in.)
O/S 1.00	100.950 – 100.980 mm (3.9744 – 3.9756 in.)

(b) Calculate amount to bore cylinders.



(c) Using a micrometer, measure the piston diameter at right angles to the piston pin center line, 42 mm (1.65 in.) from the piston head.

(d) Calculate the amount of each cylinder is to be rebored as follows:

$$\text{Size to be rebored} = P + C - H$$

P = Piston diameter

C = Piston clearance

0.040 – 0.060 mm (0.0016 – 0.0024 in.)

H = Allowance for honing

0.02 mm (0.0008 in.) or less

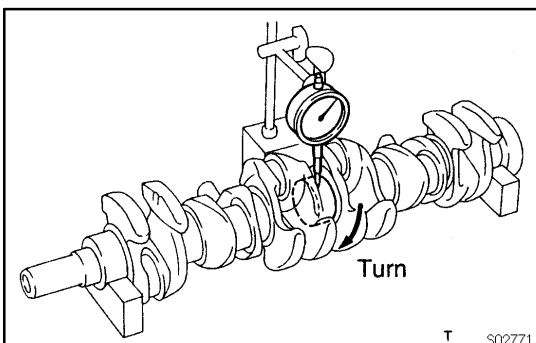
(e) Bore and hone cylinder to calculated dimensions

Maximum honing:

0.02 mm (0.0008 in.)

NOTICE:

Excess honing will destroy the finished roundness.



19. INSPECT CRANKSHAFT FOR RUNOUT

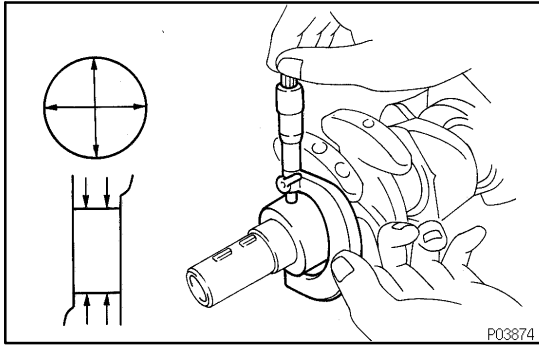
(a) Place the crankshaft on V-blocks.

(b) Using a dial indicator, measure the circle runout at the center journal.

Maximum circle runout:

0.06 mm (0.0024 in.)

If the circle runout is greater than maximum, replace the crankshaft.



20. INSPECT MAIN JOURNALS AND CRANK PINS

- (a) Using a micrometer, measure the diameter of each main journal and crank pin.

Main journal diameter:

STD	68.982 – 69.000 mm (2.7158 – 2.7165 in.)
U/S 0.25	68.745 – 68.755 mm (2.7065 – 2.7069 in.)

Crank pin diameter:

STD	56.982 – 57.000 mm (2.2434 – 2.2441 in.)
U/S 0.25	56.745 – 56.755 mm (2.2341 – 2.2344 in.)

If the diameter is not as specified, check the oil clearance (See page [EM-77](#)). If necessary, grind or replace the crankshaft.

- (b) Check each main journal and crank pin for taper and out-of-round as shown.

Maximum taper and out-of-round:

0.02 mm (0.0008 in.)

If the taper and out-of-round is greater than maximum, replace the crankshaft.

21. IF NECESSARY, GRIND AND HONE MAIN JOURNALS AND/OR CRANK PINS

Grind and hone the main journals and/or crank pins to the finished undersized diameter. Install new main journal and/or crankshaft pin undersized bearings.