EM1LU–01

REPLACEMENT

REPLACE OVERSIZED (O/S) PISTONS

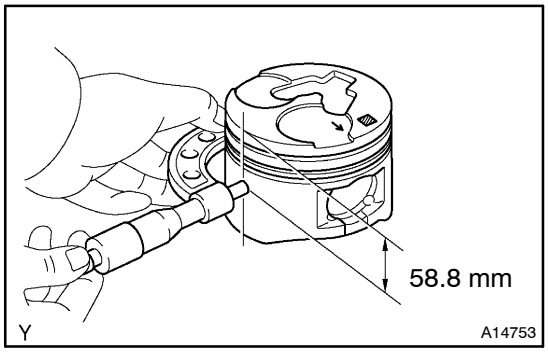
HINT:

- Bore all the 4 cylinders to the O/S piston outside diameter.
- Replace all the piston rings with ones to match the O/S pistons.

(a) Keep the O/S pistons.

O/S piston diameter:

O/S 0.50	96.440 – 96.470 mm (3.7968 – 3.7980 in.)
O/S 0.75	96.690 – 96.720 mm (3.8067 – 3.8079 in.)
O/S 1.00	96.940 – 96.970 mm (3.8165 – 3.8177 in.)



(b) Using a micrometer, measure the piston diameter at right angles to the piston pin center line, 58.8 mm (2.315 in.) from the piston head.

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

Size to be rebored = P + C – H
P = Piston diameter
C = Piston clearance
0.050 – 0.070 mm (0.0020 – 0.0028 in.)
H = Allowance for honing
0.02 mm (0.0008 in.) or less

(d) Bore and hone cylinder to calculated dimensions.

Maximum honing: 0.02 mm (0.0008 in.)

NOTICE:

Excess honing will destroy the finished roundness.