



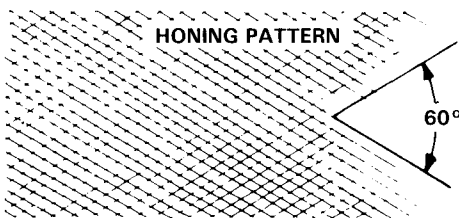
Bore Honing (A/T)

NOTE: Only scored or scratched cylinder bores must be honed.

1. Measure cylinder bores as shown on page 7-12. If the block is to be reused, hone the cylinders and remeasure the bores.
2. Hone cylinder bores with honing oil and a fine (400 grit) stone in a 60 degree cross-hatch pattern.

NOTE:

- Use only a rigid hone with 400 grit or finer stone such as Sunnen, Ammco, or equivalent.
- Do not use stones that are worn or broken.



3. When honing is complete, thoroughly clean the cylinder block of all metal particles. Wash the cylinder bores with hot soapy water, then dry and oil them immediately to prevent rusting.

NOTE: Never use solvent, it will only redistribute the grit on the cylinder walls.

4. If scoring or scratches are still present in cylinder bores after honing to service limit, rebore the cylinder block.

