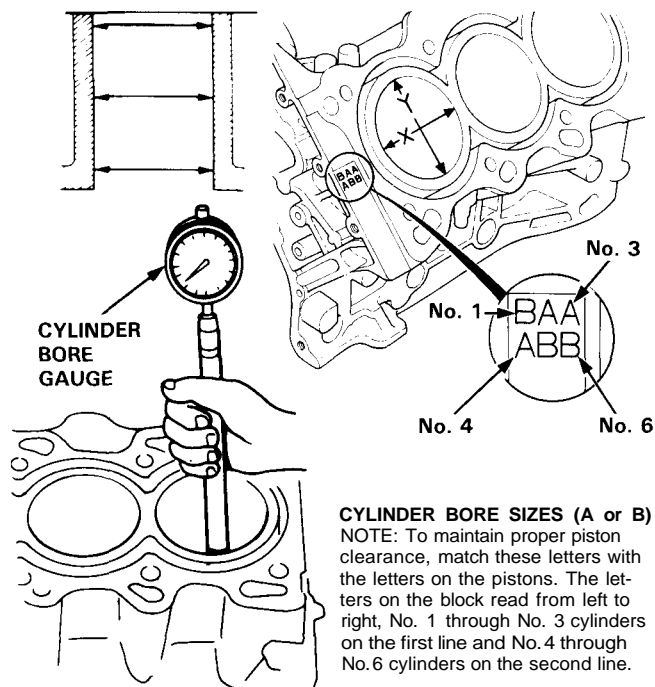


Cylinder Block

Inspection

1. Measure wear and taper in directions X and Y at three levels in each cylinder as shown.



Cylinder Bore Size

M/T:

Standard (New):

A or I 93.010 - 93.020 mm (3.6618 - 3.6622 in)

B or il 93.000 - 93.010 mm (3.6614 - 3.6618 in)

Service Limit: 93.07 mm (3.664 in)

A/T:

Standard (New):

A or I 90.010 - 90.020 mm (3.5437 - 3.5441 in)

B or il 90.000 - 90.010 mm (3.5433 - 3.5437 in)

Service Limit: 90.07 mm (3.546 in)

Oversize (A/T):

0.25: 90.25 - 90.26 mm (3.553 - 3.554 in)

0.50: 90.50 - 90.51 mm (3.563 - 3.563 in)

Bore Taper

Limit: (Difference between first and third measurement) 0.05 mm (0.002 in)

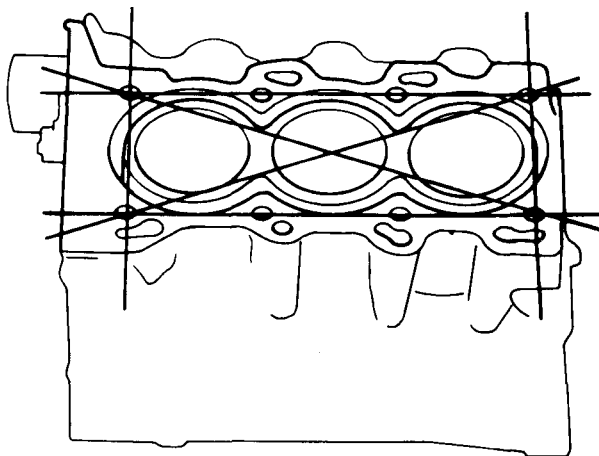
- If measurements in any cylinder are beyond Oversize Bore Service Limit, replace the block.
- If block is to be rebored, refer to Piston Clearance Inspection (see page 7-13) after reboring.

NOTE: Scored or scratched cylinder bores must be honed.

Reboring Limit (A/T): 0.50 mm (0.020 in)

2. Check the top of the block for warpage. Measure along the edges and across the center as shown.

SURFACES TO BE MEASURED



Engine Block Warpage:

Standard (New): 0.07 mm (0.003 in) max.

Service Limit: 0.10 mm (0.004 in)

PRECISION STRAIGHT EDGE

