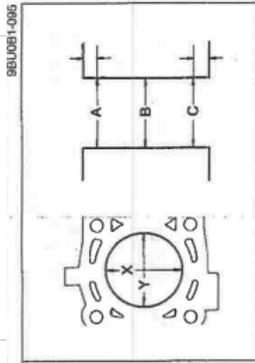


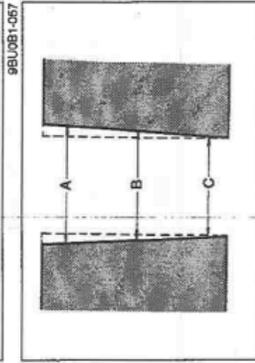
Cylinder #	1	2	3	4
<b>X-AXIS</b>				
Top				
Middle				
Bottom				
<b>Y-AXIS</b>				
Top				
Middle				
Bottom				



4. Measure the cylinder bore in X and Y directions at three levels (A, B, and C) in each cylinder as shown.

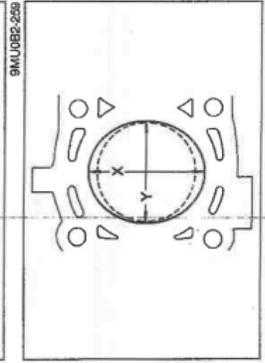
**Cylinder bore**

Size	Bore	Diameter	mm (in)
Standard	86.000	86.019	(3.3858—3.3866)
0.25 (0.010) oversize	86.250	86.269	(3.3957—3.3964)
0.50 (0.020) oversize	86.500	86.519	(3.4055—3.4063)



- (1) If the cylinder bore exceeds the maximum, rebore the cylinder to oversize.
- (2) If the difference between the measurements A and C exceeds the maximum taper, rebore the cylinder to oversize.

**Taper: 0.019mm (0.0004 in) max.**



- (3) If the difference between the measurements X and Y exceeds the maximum out-of-round, rebore the cylinder to oversize.

**Out-of-round: 0.010mm (0.0004 in) max.**

**Caution**  
The boring size should be based on the size of an oversize piston and be the same for all cylinders.