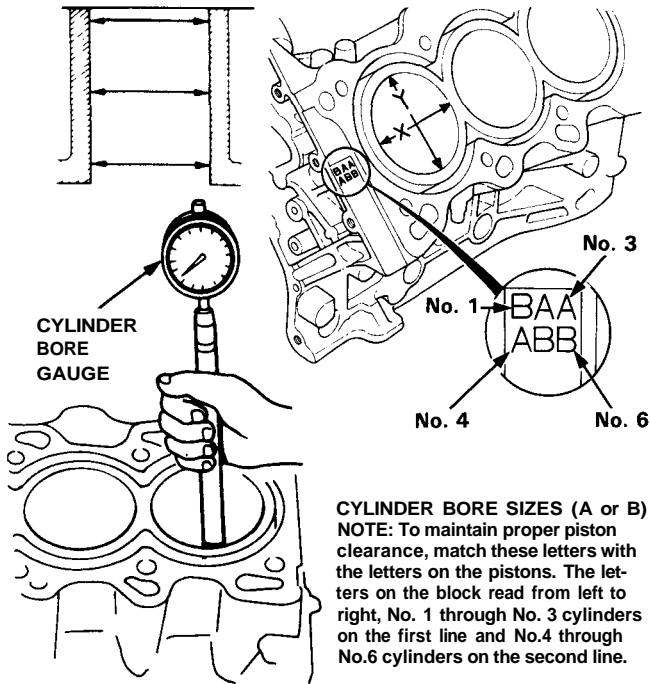


# Cylinder Block

## Inspection

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



**CYLINDER BORE SIZES (A or B)**  
NOTE: To maintain proper piston clearance, match these letters with the letters on the pistons. The letters on the block read from left to right, No. 1 through No. 3 cylinders on the first line and No. 4 through No. 6 cylinders on the second line.

### Cylinder Bore Size

Standard (New):

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

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

Service Limit: 90.07 mm (3.546 in)

### Oversize

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

0.50: 90.50-90.51 mm (3.563-3.564 in)

### Bore Taper

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

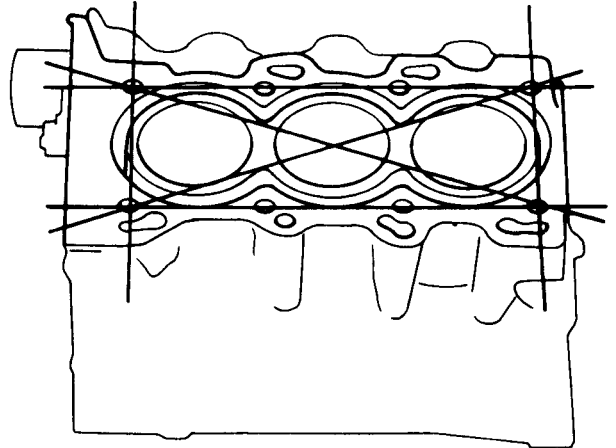
- If measurements in any cylinder are beyond Oversize Bore Service Limit, replace the block.
- If block is to be rebored, refer to Piston Clearance Inspection (see page 7-13) after reboring.

NOTE: Scored or scratched cylinder bores must be honed.

Reboring Limit: 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

