Unit: mm (in)

Cylinder/Piston

Item	Standard	Service Limit
Cylinder I.D.	60.000-60.015 (2.3622-2.3628)	60.10 (2.366)
Cylinder out of round	----	0.05 (0.002)
Cylinder taper	----	0.05 (0.002)
Cylinder warpage across top	----	0.10 (0.004)
Piston mark direction	"IN" mark facing toward the intake side	
Piston O.D. (D)	59.970-59.990 (2.3610-2.3618)	59.86 (2.357)
Piston O.D. measurement point (H)	10 (0.4)	
Piston pin hole I.D.	16.002-16.008 (0.6300-0.6302)	16.028(0.6310)
Piston pin O.D.	16.000-16.006 (0.6299-0.6302)	15.980(0.6291)
Cylinder-to-piston clearance	0.010-0.045 (0.0004-0.0018)	0.1 (0.004)
Piston pin O.D.	16.000-16.006 (0.6299-0.6302)	15.980(0.6291)
Piston-to-piston pin clearance		
Connecting rod-to-piston pin clearance		
Top ring-to-ring groove clearance	0.025-0.060 (0.0010-0.0024)	0.10 (0.004)
Second ring-to-ring groove clearance	0.015-0.045 (0.0006-0.0018)	0.10 (0.004)
Top ring end gap	0.20-0.35 (0.008-0.014)	0.65 (0.026
Second ring end gap	0.20-0.35 (0.008-0.014)	0.50 (0.0s
Oil ring end gap	0.20-0.70 (0.008-0.028)	
Top ring mark		
Second ring mark		

Crankshaft

Connecting rod small end I.D.		
Connecting rod big end side clearance	0.1-0.3 (0.004-0.01)	0.40 (0.016)
radial clearance		
Crankshaft runout	———	0.02 (0.001)
Crank pin oil clearance	0.028-0.052 (0.0011-0.0020)	0.07 (0.003)
Crank pin bearing selection	See page 11-9	
Main journal oil clearance	0.028-0.052 (0.0011-0.0020)	0.07 (0.003)
Main journal bearing selection	---	