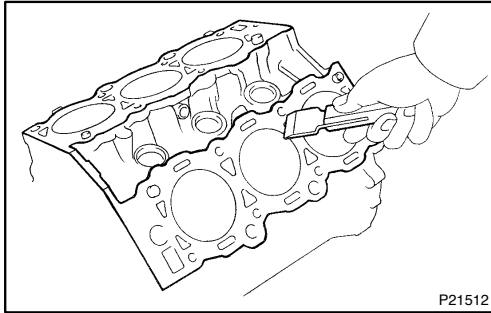
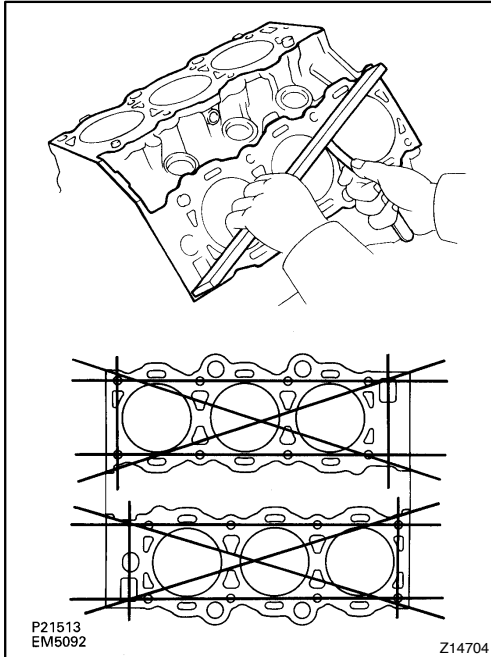




INSPECTION

1. CLEAN CYLINDER BLOCK

- (a) Remove the gasket material.
Using a gasket scraper, remove all the gasket material from the top surface of the cylinder block.
- (b) Clean the cylinder block.
Using a soft brush and solvent, thoroughly clean the cylinder block.

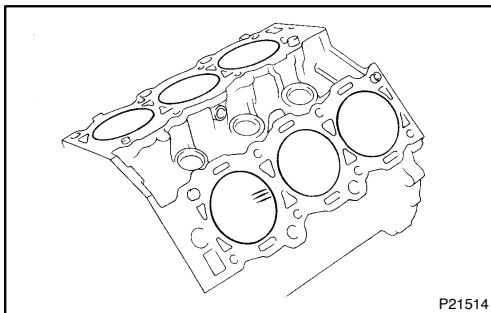


2. INSPECT CYLINDER BLOCK

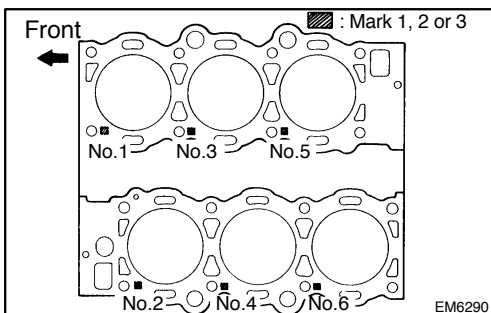
- (a) Inspect for flatness.
Using a precision straight edge and feeler gauge, measure the surfaces contacting the cylinder head gasket for warpage.

Maximum warpage: 0.05 mm (0.0020 in.)

If warpage is greater than maximum, replace the cylinder block.



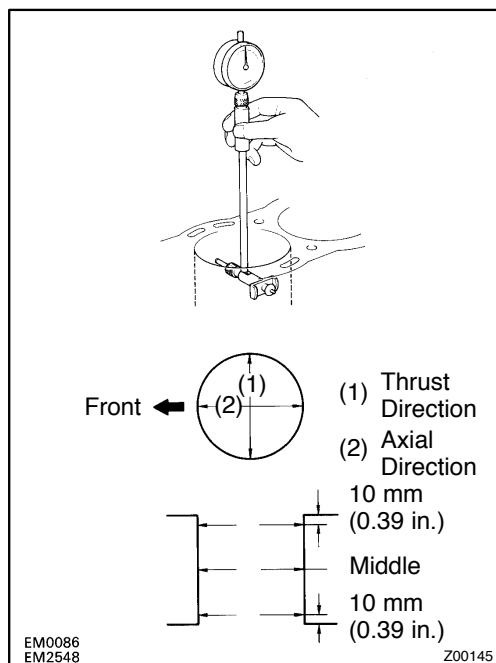
- (b) Visually check the cylinder for vertical scratches.
If deep scratches are present, rebore all the 6 cylinders. If necessary, replace the cylinder block.



- (c) Inspect the cylinder bore diameter.

HINT:

There are 3 sizes of the standard cylinder bore diameter, marked "1", "2" and "3" accordingly. The mark is stamped on the top of the cylinder block.



- (d) Using a cylinder gauge, measure the cylinder bore diameter at positions A, B and C in the thrust and axial directions.

Standard diameter:

Mark "1"	93.500 - 93.510 mm (3.6811 - 3.6815 in.)
Mark "2"	93.510 - 93.520 mm (3.6815 - 3.6819 in.)
Mark "3"	93.520 - 93.530 mm (3.6819 - 3.6823 in.)

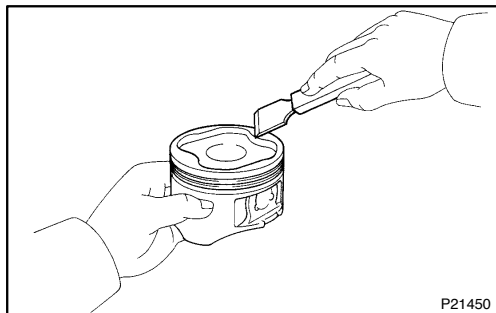
Maximum diameter:

STD	93.730 mm (3.6902 in.)
O/S 0.50	94.230 mm (3.7098 in.)

If the diameter is greater than maximum, rebore all the 6 cylinders. If necessary, replace the cylinder block.

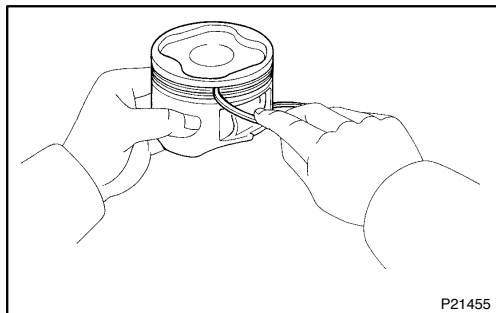
- (e) Remove the cylinder ridge.

If the wear is less than 0.2 mm (0.008 in.), using a ridge reamer, grind the top of the cylinder.

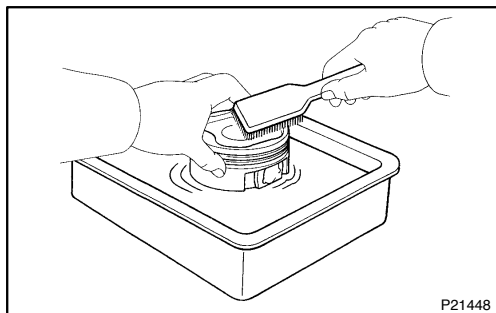


3. CLEAN PISTON

- (a) Using a gasket scraper, remove the carbon from the piston top.



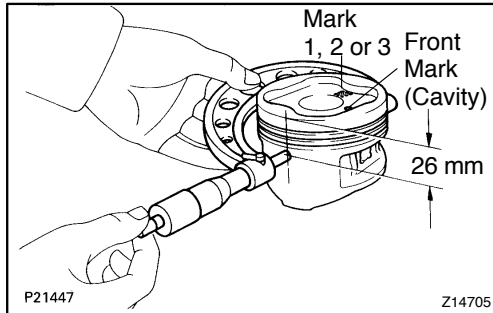
- (b) Using a groove cleaning tool or broken ring, clean the piston ring grooves.



- (c) Using solvent and a brush, thoroughly clean the piston.

NOTICE:

Do not use a wire brush.



4. INSPECT PISTON AND CONNECTING ROD

(a) Inspect the piston oil clearance.

HINT:

There are 3 sizes of the standard piston diameter, marked "1", "2" and "3" accordingly. The mark is stamped on the piston top.

- (1) Using a micrometer, measure the piston diameter at right angles to the piston pin center line, 26 mm (1.02 in.) from the piston head.

Piston diameter:

STD	Mark "1"	93.356 - 93.666 mm (3.6754 - 3.6758 in.)
	Mark "2"	93.367 - 93.376 mm (3.6759 - 3.6762 in.)
	Mark "3"	93.377 - 93.386 mm (3.6763 - 3.6766 in.)
O/S 0.50		93.856 - 93.886 mm (3.6951 - 3.6963 in.)

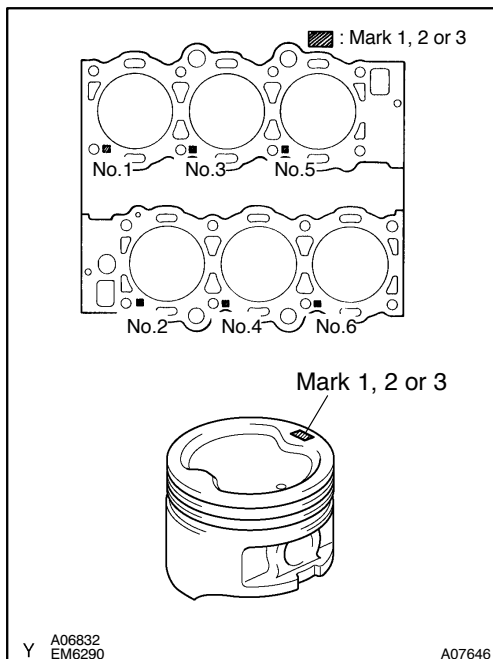
- (2) Measure the cylinder bore diameter in the thrust directions (See step 5).
- (3) Subtract the piston diameter measurement from the cylinder bore diameter measurement.

Standard oil clearance:

0.134 - 0.154 mm (0.0053 - 0.0060 in.)

Maximum oil clearance: 0.174 mm (0.0069 in.)

If the oil clearance is greater than maximum, replace all the 6 pistons. If necessary, rebore all the 6 cylinders or replace the cylinder block.



HINT:

Use a new cylinder block: Use a piston with the same number mark as the standard bore diameter marked on the cylinder block.