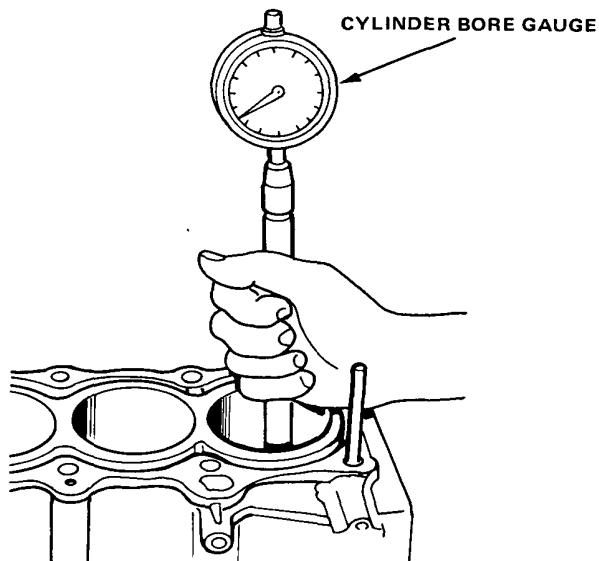
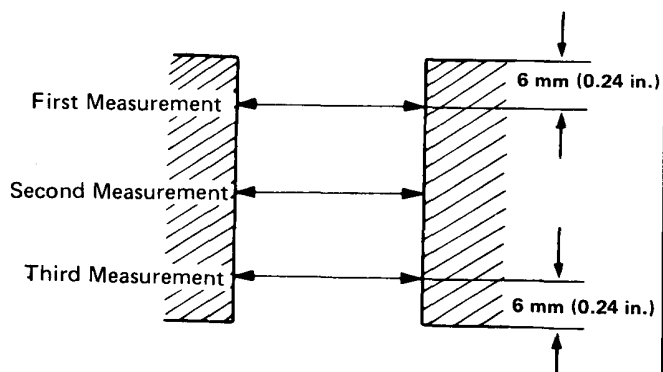
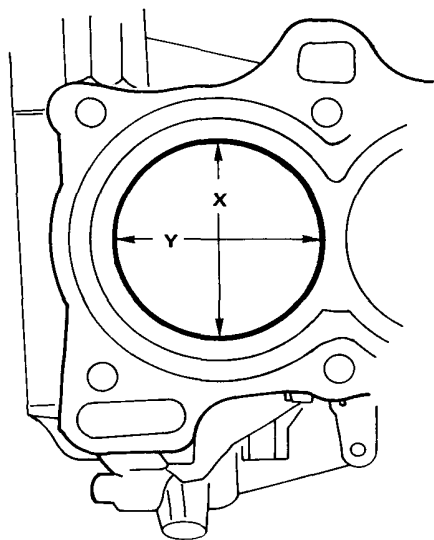




## Block Inspection

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



### Cylinder Bore Size

Standard (New): 74.00–74.02 mm  
(2.9133–2.9142 in.)

Service Limit: 74.10 mm (2.9173 in.)

### Oversize

Standard 0.25 (New): 74.215–74.248 mm  
(2.9218–2.9231 in.)

Standard 0.5 (New): 74.465–74.498 mm  
(2.9317–2.9330 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 (page 7-11) after reboring.

NOTE: Scored or scratched cylinder bores must be honed (see next page).

### Out-of-Round

Service Limit: 0.05 mm (0.002 in.)

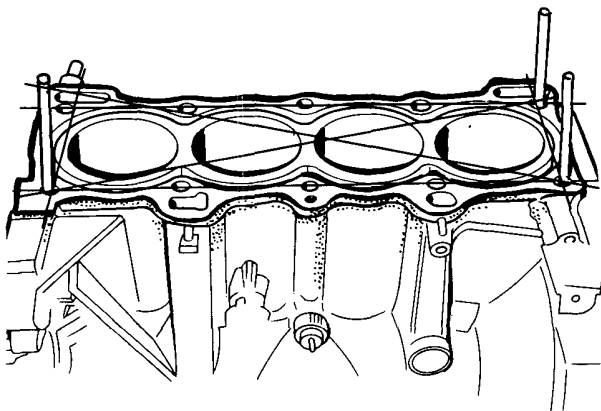
(cont'd)

# Engine Block

## Block Inspection (cont'd)

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

**SURFACES TO BE MEASURED**

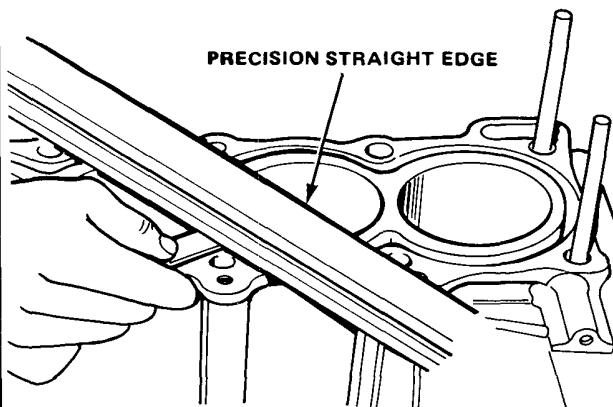


**Engine Block Warpage:**

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

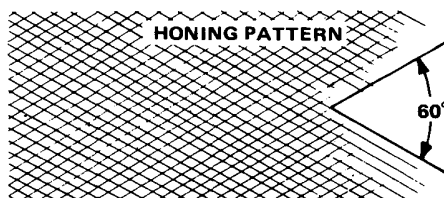
**Service Limit:** 0.10 mm (0.004 in.)

**PRECISION STRAIGHT EDGE**



## Cylinder Bore Honing

1. Measure cylinder bores as shown on page 7-9. If the block is to be re-used, hone the cylinders, and remeasure the bores.
2. Hone cylinder bores with honing oil and a fine (400 grit) stone in a 60 degree cross-hatch pattern.



3. When honing is complete, thoroughly clean the engine block of all metal particles. Wash the cylinder bores with hot soapy water, then dry and oil immediately to prevent rusting.
4. If Scoring or scratches are still present in cylinder bores after honing to service limit, rebore the engine block.

**NOTE:** Some light vertical scoring and scratching is acceptable if it is not deep enough to catch your fingernail and does not run the full length of the bore.

