

6. Piston ring groove

Item	Standard Value	Serviceable Limit
Bottom dia	45.9~46.0 mm (1.707~1.811 in)	
Groove width	Top	1.205~1.220mm
	Second	(0.047~0.048 in)
	Oil	2.50~2.52 mm
		Replace if over 1.3 mm (0.0512 in)
		Replace if over 2.6 mm (0.1024 in)

7. Piston rings

Measure the ring end gap by inserting the piston ring into the cylinder so that the ring is at right angle to the cylinder axis. (Fig. 3-39)

Item	Standard Value	Serviceable Limit
Ring thickness	Top	1.165~1.180 mm
	Second	(0.046~0.047 in)
	Oil	1.175~1.190 mm
		Replace if under 1.125 mm (0.0443 in)
		Replace if under 1.135 mm (0.0447 in)
Ring closing force	Top	2.475~2.490 mm
	Second	(0.097~0.098 in)
	Oil	0.52~0.78 kg
		Replace if under 0.42 kg (0.926 lbs)
		Replace if under 0.53 kg (1.169 lbs)
Ring end gap	0.15~0.40 mm	Replace if over 0.8 mm (0.0315 in)
	(0.006~0.016 in)	

8. Check the gaskets for damage. Replace if any damage exists.

(Note)

1. Oversize piston rings are available in four sizes; 0.25, 0.50, 0.75 and 1.00 mm (0.01, 0.02, 0.03 and 0.04 in).
2. When making piston ring end gap measurement, insert the ring carefully into the cylinder to prevent scratches or gouges to the cylinder wall.

D. Reassembly

1. After assuring that there are no damages or excessive wear to the cylinder, assemble the cylinder in the reverse order of disassembly.
2. Make sure that the cylinder gasket and the two dowel pins are installed.
3. During the installation of the cylinder ①, use piston bases ② to prevent piston movement, also use a ring compressor ③ to prevent ring damages. (Fig. 3-40)
4. Assemble the cylinder head and cover unit.

(Note)

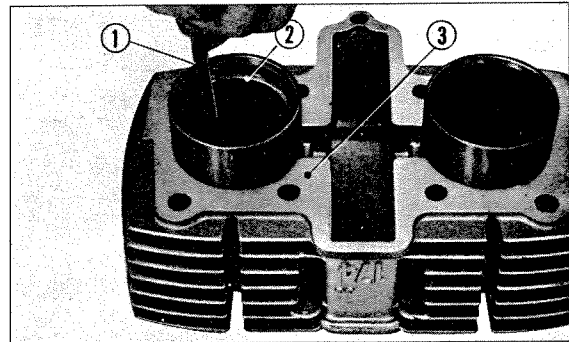
Check to make sure that the gaskets are properly in place.

3.3 LEFT CRANKCASE COVER

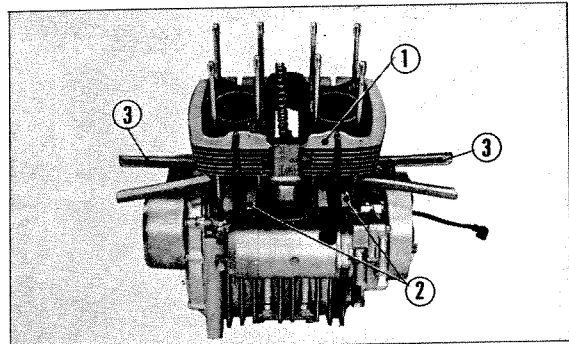
1. LEFT CRANKCASE COVER

A. Construction

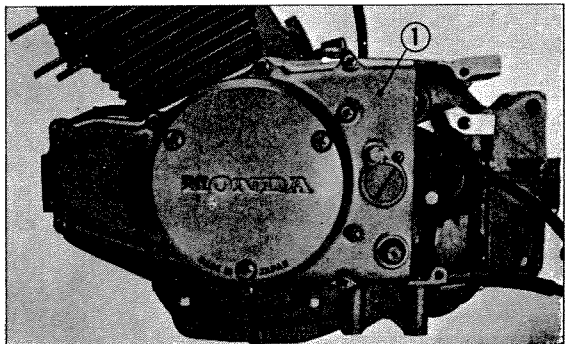
The purpose of the crankcase is to protect the vital components of the engine. The left crankcase houses the A.C generator stator. (Fig. 3-41, 3-42)



① Thickness gauge ② Piston ring ③ Cylinder
Fig. 3-39. Measuring the piston ring end gap



① Cylinder ② Piston base ③ Piston ring compressor
Fig. 3-40. Installing the cylinder



① Left crankcase cover
Fig. 3-41. Left crankcase cover