

CYLINDER BLOCK

- Visually check for scratches, rust, and corrosion. Use also a flaw detecting agent for the check. If defects are evident, correct, or replace.
- Using a straightedge and feeler gauge, check the block top surface for warpage. Make sure that the surface is free from gasket chips and other foreign matter.

Standard value: 0.05 mm

Limit: 0.1 mm

- If the distortion is excessive, correct within the allowable limit or replace.

Grinding limit: 0.2 mm

Includes/combined with cylinder head grinding
Cylinder block height (when new):

4G63 284 mm

4G64 290 mm

- Check cylinder walls for scratches and seizure. If defects are evident, correct (bored to oversize) or replace.

- Using cylinder gauge, measure the cylinder bore and cylindricity. If worn badly, correct cylinder to an oversize and replace piston and piston rings. Measure at the points shown in illustration.

Standard value:

Cylinder I.D.

4G63 85.00 - 85.03 mm

4G64 86.50 - 86.53 mm

Cylindricity 0.01 mm or less

BORING CYLINDER

- Oversize pistons to be used should be determined on the basis of the largest bore cylinder.

Piston size identification

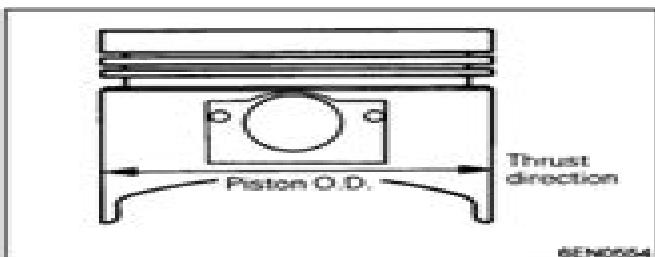
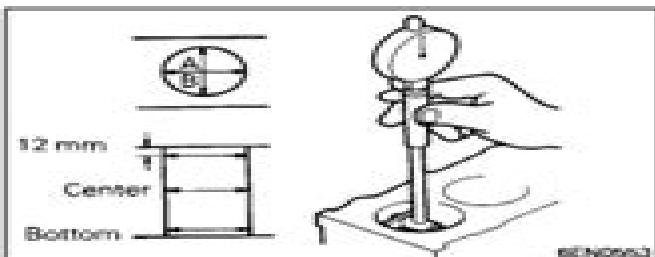
Size	Identification mark
0.50 O.S.	0.50
1.00 O.S.	1.00

NOTE

Size mark is stamped on the piston top.

- Measure outside diameter of piston to be used. Measure it in thrust direction as shown.
- Based on the measured piston O.D. calculate boring finish dimension.

Boring finish dimension = Piston O.D. + (clearance between piston O.D. and cylinder) - 0.02 mm (honing margin)



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Table of Contents 4g69 Workshop Manual 76665

1. Understanding the eBook 4g69 Workshop Manual 76665
 - The Rise of Digital Reading 4g69 Workshop Manual 76665
 - Advantages of eBooks Over Traditional Books
2. Identifying 4g69 Workshop Manual 76665
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an 4g69 Workshop Manual 76665
 - User-Friendly Interface
4. Exploring eBook Recommendations from 4g69 Workshop Manual 76665

- Personalized Recommendations
- 4g69 Workshop Manual 76665 User Reviews and Ratings
- 4g69 Workshop Manual 76665 and Bestseller Lists
- 5. Accessing 4g69 Workshop Manual 76665 Free and Paid eBooks
 - 4g69 Workshop Manual 76665 Public Domain eBooks
 - 4g69 Workshop Manual 76665 eBook Subscription Services
 - 4g69 Workshop Manual 76665 Budget-Friendly Options
- 6. Navigating 4g69 Workshop Manual 76665 eBook Formats
 - ePUB, PDF, MOBI, and More
 - 4g69 Workshop Manual 76665 Compatibility with Devices
 - 4g69 Workshop Manual 76665 Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of 4g69 Workshop Manual 76665
 - Highlighting and Note-Taking 4g69 Workshop Manual 76665
 - Interactive Elements 4g69 Workshop Manual 76665
- 8. Staying Engaged with 4g69 Workshop Manual 76665
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers 4g69 Workshop Manual 76665
- 9. Balancing eBooks and Physical Books 4g69 Workshop Manual 76665
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection 4g69 Workshop Manual 76665
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine 4g69 Workshop Manual 76665
 - Setting Reading Goals 4g69 Workshop Manual 76665
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of 4g69 Workshop Manual 76665

- Fact-Checking eBook Content of 4g69 Workshop Manual 76665
- Distinguishing Credible Sources

13. Promoting Lifelong Learning

- Utilizing eBooks for Skill Development
- Exploring Educational eBooks

14. Embracing eBook Trends

- Integration of Multimedia Elements
- Interactive and Gamified eBooks

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