

### CYLINDER BLOCK

- (1) Visually check for scratches, rust, and corrosion. Use also a flaw detecting agent for the check. If defects are evident, correct, or replace.
- (2) 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**

- (3) 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**

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

- (5) 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.

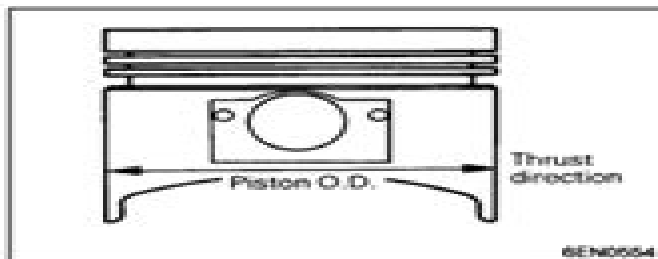
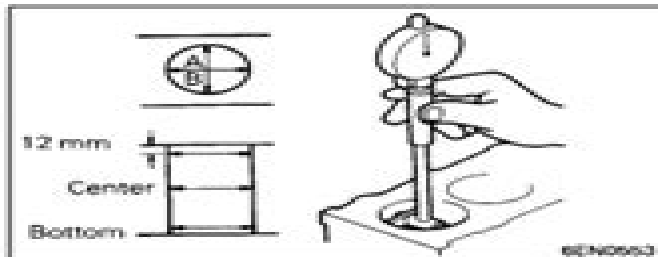
**Standard value:**

**Cylinder I.D.**

**4G63 85.00 - 85.03 mm**

**4G64 86.50 - 86.53 mm**

**Cylindricity 0.01 mm or less**



### BORING CYLINDER

- (1) 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.

- (2) Measure outside diameter of piston to be used. Measure it in thrust direction as shown.
- (3) 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)**

# 4g69 Workshop Manual 76665

**D Kirk**



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