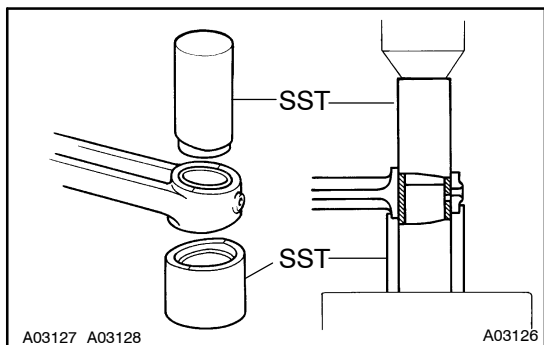




REPLACEMENT

1. REPLACE CONNECTING ROD BUSHINGS

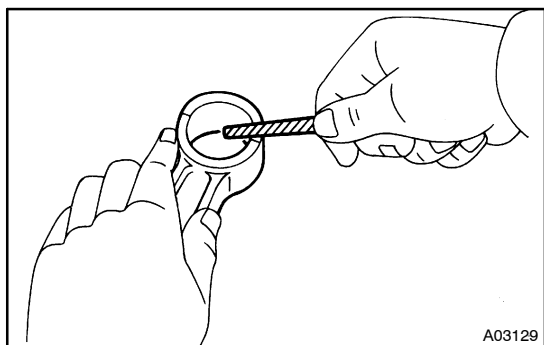
- (a) Using SST and a press, press out the bushing.

SST 2L

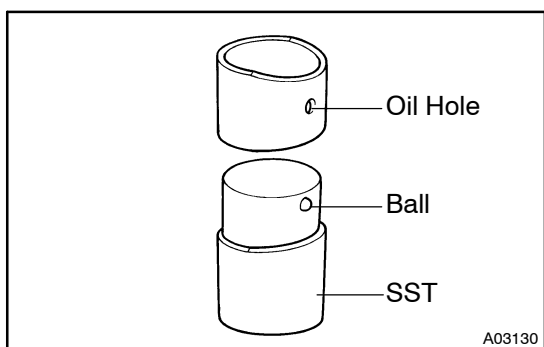
09222-64012 (09222-02022, 09222-02041)

3L, 5L

09222-54011 (09222-03016, 09222-03026)



- (b) Using a round file, lightly file off any roughness from the small end of the connecting rod.



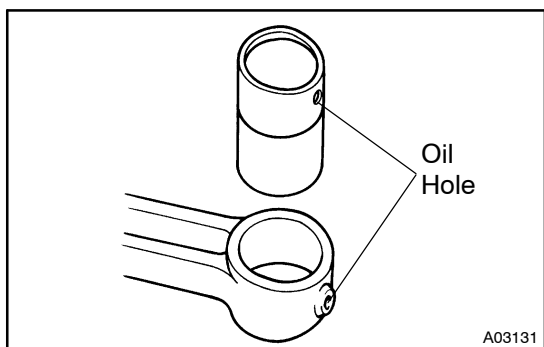
- (c) Attach the bushing to SST with the ball of SST inside the oil hole of the bushing.

SST 2L

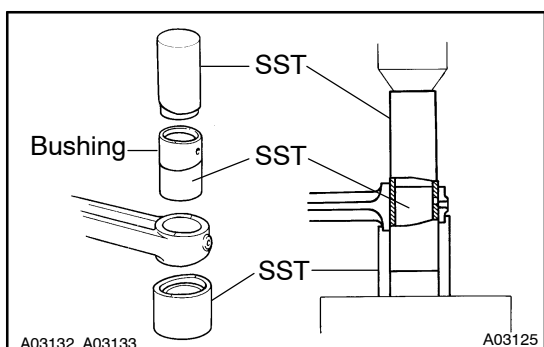
09222-64012 (09222-02031)

3L, 5L

09222-54011 (09222-03021)



- (d) Align the oil holes of a new bushing and the connecting rod.



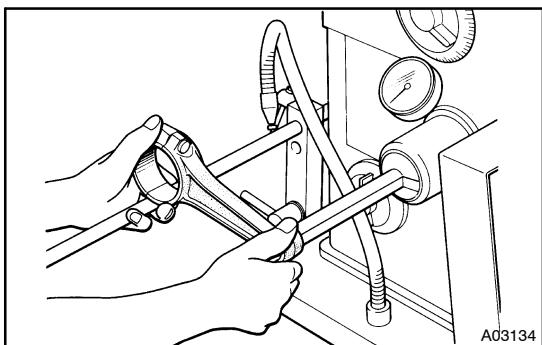
- (e) Using SST and a press, press in the bushing.

SST 2L

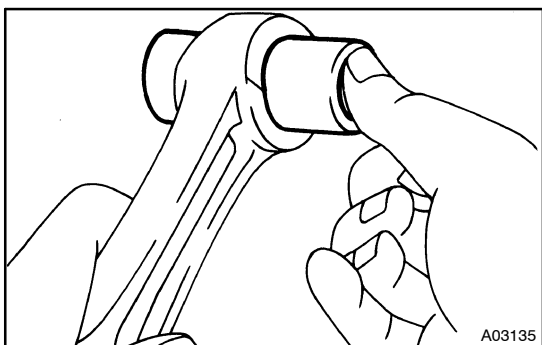
09222-64012 (09222-02022, 09222-02031, 09222-02041)

3L, 5L

09222-54011 (09222-03016, 09222-03021, 09222-03026)



- (f) Using a pin hole grinder, hone the pushing to obtain the standard specified clearance (See page EM-12) between the pushing and piston pin.



- (g) Check the piston pin fit at normal room temperature. Coat the piston pin with engine oil, and push it into the connecting rod with your thumb.

2. REPLACE OVERSIZED (O/S) PISTONS FOR CYLINDER BORING

HINT:

- Bore all the 4 cylinders to the oversized piston outside diameter.
- Replace all the piston rings with ones to match the oversized pistons.

- (a) Keep 4 new O/S pistons.

O/S piston diameter:

2L

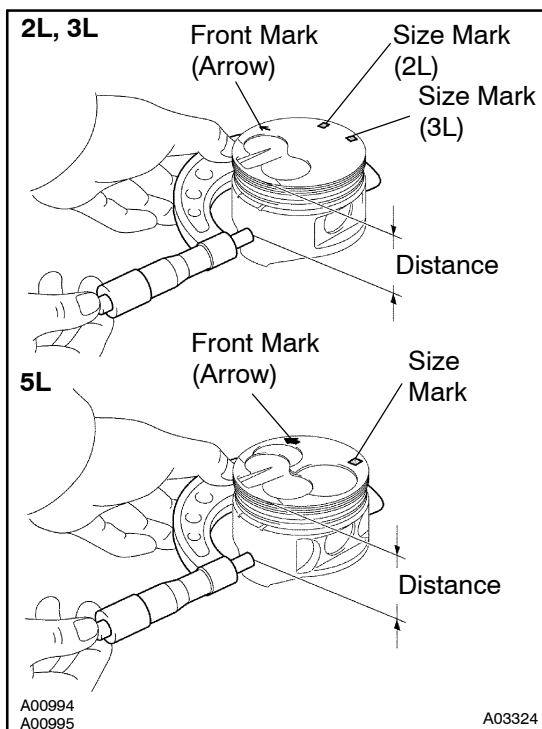
O/S 0.50	92.440 - 92.470 mm (3.6394 - 3.6405 in.)
O/S 0.75	92.690 - 92.720 mm (3.6492 - 3.6504 in.)
O/S 1.00	92.940 - 92.970 mm (3.6590 - 3.6602 in.)

3L

O/S 0.50	96.440 - 96.470 mm (3.7968 - 3.7980 in.)
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5L

O/S 0.50	99.950 - 99.980 mm (3.9350 - 3.9362 in.)
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- (b) Using a micrometer, measure the piston diameter at right angles to the piston pin center line, the indicated distance from the piston head.

Distance:

2L	58.27 – 58.33 mm (2.2941 – 2.2965 in.)
3L	56.27 – 56.33 mm (2.2153 – 2.2177 in.)
5L	61.27 – 61.33 mm (2.4122 – 2.4146 in.)

- (c) Calculate the amount each cylinder is to be rebored as follows:

$$\text{Size to be rebored} = P + C - H$$

P = Piston diameter

C = Piston clearance:

2L, 3L	0.050 – 0.070 mm (0.0020 – 0.0028 in.)
5L	0.040 – 0.060 mm (0.0016 – 0.0024 in.)

H = Allowance for honing: 0.02 mm (0.0008 in.) or less

- (d) Bore and hone the cylinders to calculated dimensions.

Maximum honing: 0.02 mm (0.0008 in.)

NOTICE:

Excess honing will destroy the finished roundness.