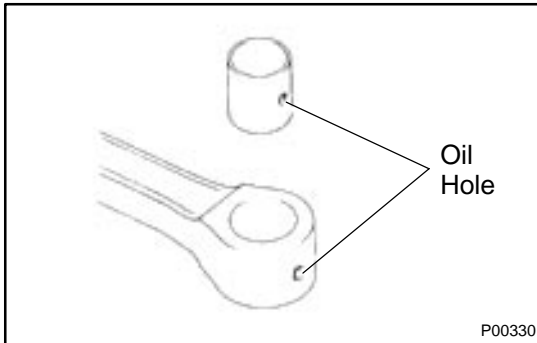


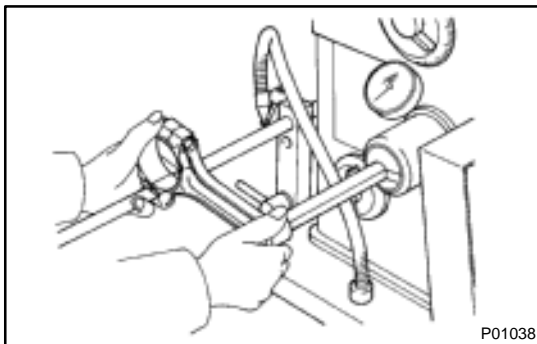
REPLACEMENT

1. REPLACE CONNECTING ROD BUSHINGS

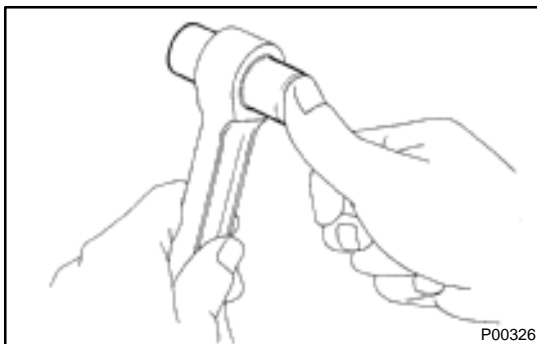
- (a) Using SST and a press, press out the bushing.
SST 09222-30010



- (b) Align the oil holes of a new bushing and the connecting rod.
(c) Using SST and a press, press in the bushing.
SST 09222-30010



- (d) Using a pin hole grinder, hone the bushing to obtain the standard specified clearance (See page EM-90) between the bushing and piston pin.



- (e) 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

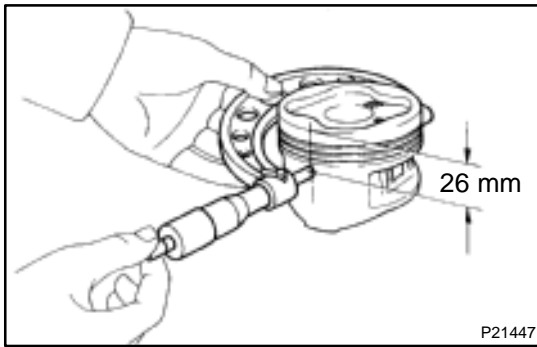
HINT:

- Bore all the 6 cylinders for the O/S piston outside diameter.
- Replace all the piston rings with ones to match the O/S pistons.

- (a) Keep 6 new O/S pistons.

O/S 0.50 piston diameter:

93.856 – 93.886 mm (3.6951 – 3.6963 in.)



- (b) Using a micrometer, measure the piston diameter at right angles to the piston pin center line, 26 mm (1.02 in.) from the piston head.

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

Size to be rebored = P + C – H

P = Piston diameter

C = Piston oil clearance:

0.134 – 0.154 mm (0.0053 – 0.0060 in.)

H = Allowance for honing:

0.02 mm (0.0008 in.) or less

- (d) Bore and hone cylinder to calculated dimensions

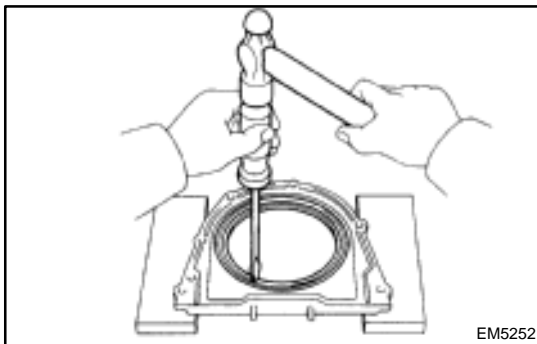
Maximum honing: 0.02 mm (0.0008 in.)

NOTICE:

Excess honing will destroy the finished roundness.

3. REPLACE CRANKSHAFT FRONT OIL SEAL

(See page [LU-12](#))

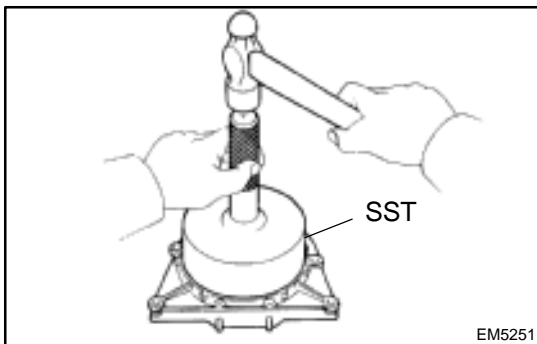


4. REPLACE CRANKSHAFT REAR OIL SEAL

HINT:

There are 2 methods ((a) and (b)) to replace the oil seal.

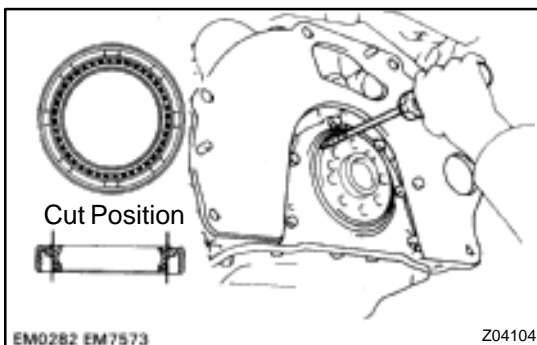
- (a) If rear oil seal retainer is removed from the cylinder block:
- (1) Using a screwdriver and hammer, tap out the oil seal.



- (2) Using SST and a hammer, tap in a new oil seal until its surface is flush with the rear oil seal retainer edge.

SST 09223-15030, 09950-70010 (09951-07150)

- (3) Apply MP grease to the oil seal lip.

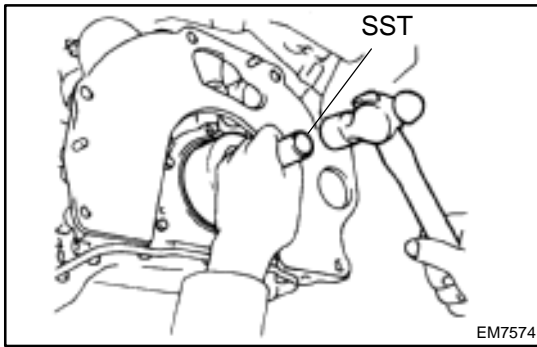


- (b) If rear oil seal retainer is installed to the cylinder block:

- (1) Using a knife, cut off the oil seal lip.
- (2) Using a screwdriver, pry out the oil seal.

NOTICE:

Be careful not to damage the crankshaft. Tape the screwdriver tip.



- (3) Apply MP grease to a new oil seal lip.
 - (4) Using SST and a hammer, tap in the oil seal until its surface is flush with the rear oil seal retainer edge.
- SST 09923-15030, 09950-70010 (09951-07150)