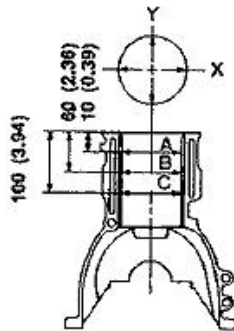


SR20DE(T)

SEM008D



SEM686D

## Surface flatness

Standard	Less than 0.03 (0.0012)
Limit	0.10 (0.0039)

## Cylinder bore

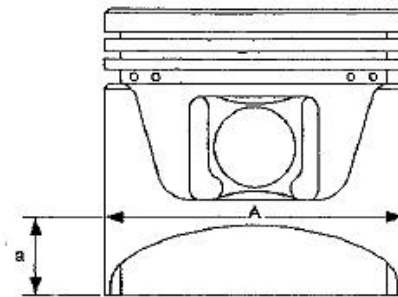
## Inner diameter

Standard	
Grade No. 1	86.000 - 86.010 (3.3858 - 3.3862)
Grade No. 2	86.010 - 86.020 (3.3862 - 3.3866)
Grade No. 3	86.020 - 86.030 (3.3866 - 3.3870)

Wear limit	0.20 (0.0079)
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Out-of-round (X - Y)	Less than 0.015 (0.0006)
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Taper (A - B and A - C)	Less than 0.010 (0.0004)
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SEM750C

## Piston skirt diameter "A"

## Standard

Grade No. 1	85.980 - 85.990 (3.3850 - 3.3854)
Grade No. 2	85.990 - 86.000 (3.3854 - 3.3858)
Grade No. 3	86.000 - 86.010 (3.3858 - 3.3862)
0.20 (0.0079) over-size (Service)	86.180 - 86.210 (3.3929 - 3.3941)

"a" dimension	10.5 (0.413)
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Piston clearance to cylinder block	0.010 - 0.030 (0.0004 - 0.0012)
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Piston pin hole diameter	21.987 - 21.999 (0.8656 - 0.8661)
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## Piston pin

Unit: mm (in)

Piston pin outer diameter	21.989 - 22.001 (0.8657 - 0.8662)
Interference fit of piston pin to piston	0 - 0.004 (0 - 0.0002)
Piston pin to connecting rod bushing clearance	
Standard	0.005 - 0.017 (0.0002 - 0.0007)
Limit	0.023 (0.0009)

\* Values measured at ambient temperature of 20°C (68°F)

## SERVICE DATA AND SPECIFICATIONS (SDS)

## Inspection and Adjustment (Cont'd)

## Piston ring

Unit: mm (in)

Side clearance	
Top	
Standard	0.045 - 0.080 (0.0018 - 0.0031)
Limit	0.1 (0.004)
2nd	
Standard	0.030 - 0.065 (0.0012 - 0.0026)
Limit	0.1 (0.004)
End gap	
Top	
Standard	0.20 - 0.30 (0.0079 - 0.0118)
Limit	0.39 (0.0154)
2nd	
Standard	0.35 - 0.50 (0.0138 - 0.0197)
Limit	0.59 (0.0232)
Oil	
Standard	0.20 - 0.60 (0.0079 - 0.0236)
Limit	0.69 (0.0272)

## CONNECTING ROD

Unit: mm (in)

Center distance	136.30 (5.3661)
Bend [per 100 (3.94)]	
Limit	0.15 (0.0059)
Torsion [per 100 (3.94)]	
Limit	0.3 (0.0012)
Connecting rod small end inner diameter	24.980 - 25.000 (0.9835 - 0.9843)
Piston pin bushing inner diameter*	22.000 - 22.012 (0.8661 - 0.8666)
Connecting rod big end inner diameter	51.000 - 51.013 (2.0079 - 2.0084)
Side clearance	
Standard	0.20 - 0.35 (0.0079 - 0.0138)
Limit	0.5 (0.020)

\*After installing in connecting rod