



3DEABAB1P156A

Correcting Cylinder (Oversize)

- When the cylinder is worn beyond the allowable limit, bore and hone it to the specified dimension.

[D782-E2/E3]

Cylinder liner I.D.	Factory specification	67.250 to 67.266 mm 2.6477 to 2.6483 in.
	Allowable limit	67.400 mm 2.6535 in.
Finishing	Hone to 2.2 to 3.0 μ m Rz (0.00087 to 0.0012 in. μ Rz)	

[D902-E3/E4]

Cylinder liner I.D.	Factory specification	72.250 to 72.266 mm 2.8445 to 2.8452 in.
	Allowable limit	72.400 mm 2.8504 in.
Finishing	Hone to 2.2 to 3.0 μ m Rz (0.00087 to 0.0012 in. μ Rz)	

[D1005-E2/E3/E4]

Oversized cylinder liner I.D.	Factory specification	76.500 to 76.515 mm 3.0119 to 3.0125 in.
	Allowable limit	76.65 mm 3.018 in.
Finishing	Hone to 1.2 to 2.0 mm μ R max. (0.00047 to 0.00079 in. μ R max.)	

[D1105-E4, D1305-E3]

Oversized cylinder liner I.D.	Factory specification	76.500 to 76.515 mm 3.0119 to 3.012 in.
	Allowable limit	76.65 mm 3.018 in.
Finishing	Hone to 1.2 to 2.0 mm μ R max. (0.00047 to 0.00079 in. μ R max.)	

- Replace the piston and piston rings with oversize ones.
Oversize: 0.25 mm (0.0098 in.) (D782-E2/E3, D902-E3/E4)
Oversize: 0.5 mm (0.02 in.) (D1005-E2/E3/E4, D1105-E4, D1305-E3)

■ NOTE

- When the oversize cylinder is worn beyond the allowable limit, replace the cylinder block with a new one.

(1) Cylinder I.D. (Before Correction) (2) Cylinder I.D. (Oversize)

SYL2102835M00133009

(6) Oil Pump (D782-E2/E3, D902-E3/E4)



3TAAAB1P037A

Rotor Lobe Clearance

- Measure the clearance between lobes of the inner rotor and the outer rotor with a thickness gauge.
- If the clearance exceeds the factory specifications, replace the oil pump rotor assembly.

Rotor lobe clearance	Factory specification	0.030 to 0.16 mm 0.0012 to 0.0063 in.
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Zd 323 Repair Manual

Thirumalaisamy P.
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