

## SERVICE INFORMATION

### GENERAL

- This section covers service of the cylinder and piston. These services can be performed with the engine installed in the frame.
- Take care not to damage the cylinder wall and piston.
- Be careful not to damage the mating surfaces when removing the cylinder. Do not tap the cylinder too hard during removal.
- When disassembling, mark and store the disassembled parts to ensure that they are reinstalled in their original locations.
- Clean all disassembled parts with cleaning solvent and dry them by blowing them off with compressed air before inspection.

### SPECIFICATIONS

				Unit: mm (in)			
ITEM				STANDARD		SERVICE LIMIT	
Cylinder	I.D.		50.005 – 50.015 (1.9687 – 1.9691)		50.05 (1.970)		
	Out-of-round		—		0.10 (0.004)		
	Taper		—		0.10 (0.004)		
	Warpage		—		0.05 (0.002)		
Piston, piston rings, piston pin	Piston O.D.		49.980 – 49.995 (1.9677 – 1.9683)		49.91 (1.965)		
	Piston O.D. measurement point		10 (0.4) from bottom of skirt		—		
	Piston pin bore I.D.		13.002 – 13.008 (0.5119 – 0.5121)		13.03 (0.513)		
	Piston pin O.D.		12.994 – 13.000 (0.5116 – 0.5118)		12.98 (0.511)		
	Piston-to-piston pin clearance		0.002 – 0.014 (0.0001 – 0.0006)		0.075 (0.0030)		
	Piston ring-to-ring groove clearance	Top	0.015 – 0.045 (0.0006 – 0.0018)		0.08 (0.003)		
		Second	0.015 – 0.045 (0.0006 – 0.0018)		0.08 (0.003)		
	Piston ring end gap	Top	0.10 – 0.25 (0.004 – 0.0010)		0.5 (0.02)		
		Second	0.10 – 0.25 (0.004 – 0.0010)		0.5 (0.02)		
		Oil (side rail)	0.20 – 0.70 (0.008 – 0.028)		1.1 (0.04)		
Cylinder-to-piston clearance		0.010 – 0.035 (0.0004 – 0.0014)		0.10 (0.004)			
Connecting rod small end I.D.		13.016 – 13.034 (0.5124 – 0.5131)		13.05 (0.514)			
Connecting rod-to-piston pin clearance		0.016 – 0.040 (0.0006 – 0.0016)		0.07 (0.003)			

### TORQUE VALUES

ITEM	Q'TY	THREAD DIA. (mm)	TORQUE N·m (kgf·m, lbf·ft)	REMARKS
Cam chain guide roller pin bolt	1	8	10 (1.0, 7)	
Cylinder stud bolt	4	7	6 (0.6, 4.4)	See page 9-7

## TROUBLESHOOTING

**Compression too low, hard starting or poor performance at low speed**

- Leaking cylinder head gasket
- Worn, stuck or broken piston ring
- Worn or damaged cylinder and piston
- Bent connecting rod

**Compression too high, overheating or knocking**

- Excessive carbon built-up on piston head or combustion chamber

**Excessive smoke**

- Worn cylinder, piston or piston rings
- Improper installation of piston rings
- Scored or scratched piston or cylinder wall
- Cylinder head/valve problem (page 8-5)

**Abnormal noise**

- Worn piston pin or piston pin hole
- Worn cylinder, piston or piston rings
- Worn connecting rod small end

# Honda Xrm 110 Parts Manual

**M Planty**



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