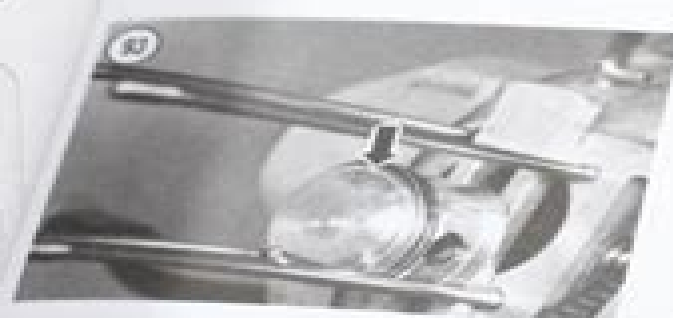
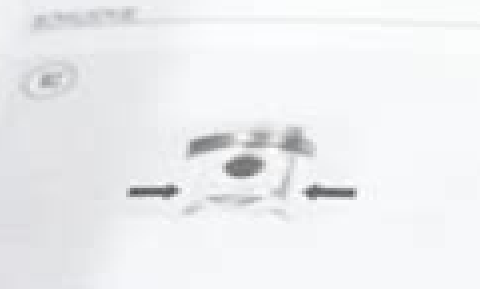




...clearance  
...the piston and  
...the inside diameter  
...1.3 mm (1/16 in.)  
...the gauge (Figure 91)  
...the inside diameter  
...Figure 92 at the  
...of the



5. To establish a final overbore dimension with a new piston, add the piston skirt measurement to the specified clearance. This will determine the dimension for the cylinder overbore size. Remember, do not exceed the cylinder maximum service limit inside diameter indicated in Table 1.
6. Refer to Table 3 for oversize piston dimensions and cylinder bore dimensions for the 1981-on ATC110 and the ATC125M. Honda provides service information for these models only.



**CAUTION**  
If it is necessary to tap the piston pin into the connecting rod, do so gently with a block of wood or a soft-faced hammer. Make sure you support the piston to prevent the lateral shock from being transmitted to the connecting rod bearing.

**NOTE**  
In the next step, install the clips with the gap away from the cutout in the piston (Figure 94).

5. Install new piston pin clips in both ends of the pin boss. Make sure they are seated in the grooves in the piston.
6. Check the installation by rocking the piston back and forth around the pin axis and from side to side along the axis. It should rotate freely back and forth but not from side to side.
7. Install the piston rings as described in this chapter.
8. Install the cylinder and cylinder head as described in this chapter.

# E22 Engine Manual

**John William Major Sothern**



## **E22 Engine Manual:**

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