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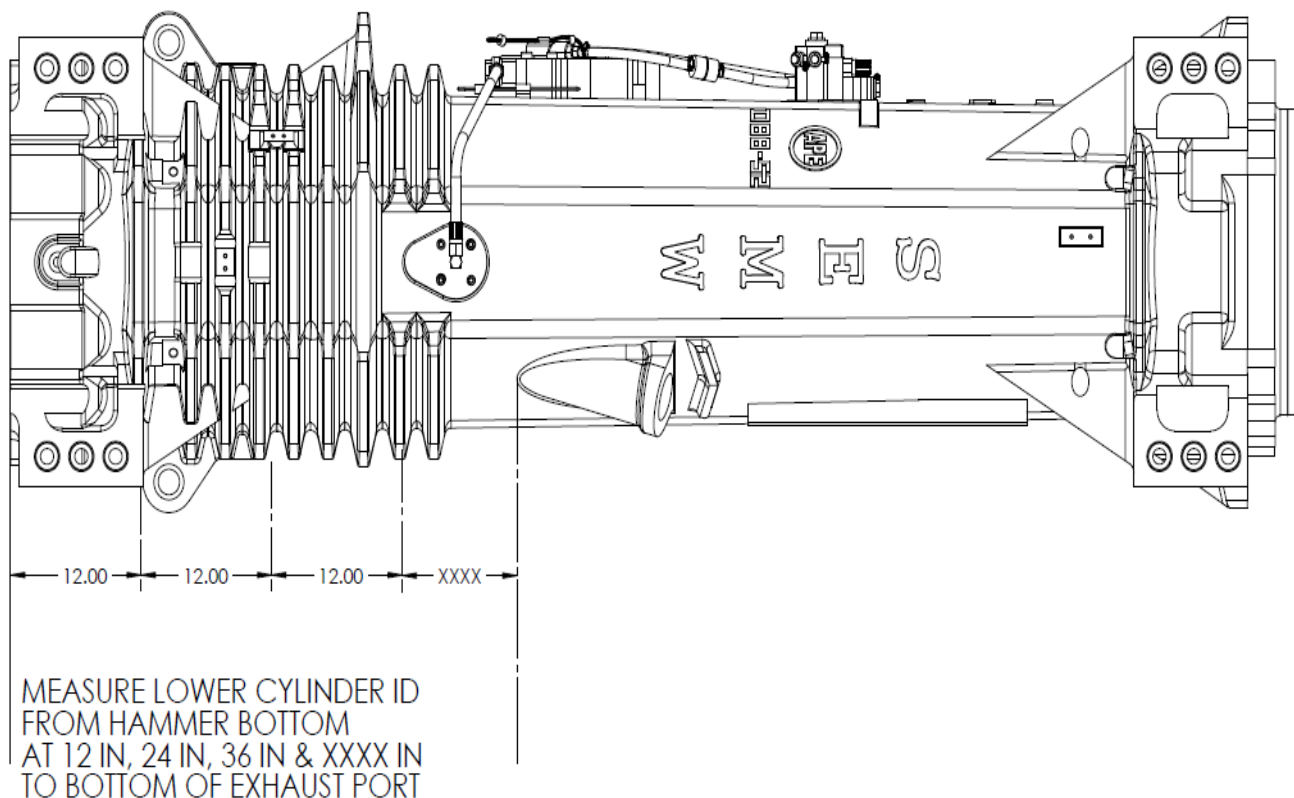
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#24 Lower Cylinder Bore Measuring, And Quick Reference Sheet

This bulletin is to give the appropriate information on how to correctly measure a diesel hammer lower cylinder bore tolerance.

The drawing below indicates where to measure a lower cylinder bore to verify it is within tolerance.



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Using a Go/No-Go gauge, you can quickly check the cylinder tolerance. When using this gauge it is extremely important that you are sweeping in the center to get an accurate measurement.

If the gauge can **NOT** sweep through the bore, then it is within tolerance.

If the gauge can sweep through the bore, then it is out of tolerance.

It is important to properly store and protect these gauges. If they get bent or have damage to the ends you will get incorrect readings.

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Below is a quick reference sheet for lower cylinder tolerance.

Diesel Hammer Lower Cylinder Bore Quick Reference Sheet

Diesel Hammer Sizes	New Bore Tolerance	Max/Replace Cylinder Tolerance
D8-42	250 MM	252 MM Or Larger
D12-42	300 MM	302 MM Or Larger
D16-32/D16-52	320 MM	322 MM Or Larger
D19-42/D19-52		
D25-21		
D25-32/D25-42/D25-52	420 MM	422 MM Or Larger
D30-32/D30-42/D30-52		
D36-26		
D36-32/D36-42/D36-52	500 MM	502 MM Or Larger
D46-32		
D50-42/D50-52		
D62-42/D62-52	550 MM	552 MM Or Larger
D70-42/D70-52		
D80-42	630 MM	632 MM Or Larger
D100-42		
D125-42	720 MM	722 MM Or Larger
D138-42	740 MM	742 MM Or Larger
D128-52		
D160-42	824 MM	826 MM Or Larger
D180-42		

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