SERVICE BULLETIN

M-879

December 22, 1983

V\text{\textfrac{2}{3}}_{\text{m}} EVOLUTION ENGINE CYLINDER
BORE SIZES AND SERVICE WEAR LIMITS

BORE SIZES

Incorrect bore sizes and service wear limits are listed in the following Service Manuals on the pages indicated:

<table>
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<th>MODEL</th>
<th>PART NO.</th>
<th>PAGES</th>
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<tbody>
<tr>
<td>FL/FX</td>
<td>99482-84</td>
<td>V3-2, V3-24, V3-25</td>
</tr>
<tr>
<td>FLT/FXR</td>
<td>99483-84</td>
<td>3-2, 3-24, 3-25</td>
</tr>
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</table>

Incorrect bore sizes and service wear limits are also incorrect on page 10, Frame 38 of the Vf\text{\textfrac{2}{3}}_m Evolution Engine Audio-Visual Program No. 6, Part No. 99934-84.

CORRECT BORE SIZES

The correct bore sizes, after honing, are as follows:

- Standard bore: 3.4900 ± .0002 in.
- .005 in. oversize (O.S.): 3.5000 ± .0002 in.
- .010 in. O.S.: 3.5080 ± .0002 in.
- .020 in. O.S.: 3.5180 ± .0002 in.
- .030 in. O.S.: 3.5280 ± .0002 in.

CORRECT BORE SERVICE WEAR LIMITS

The correct service wear limits for cylinder bores are as follows:

- Standard: 3.501 in.
- .005 Oversize (O.S.): 3.506 in.
- .010 O.S. Bore: 3.511 in.
- .020 O.S. Bore: 3.521 in.
- .030 O.S. Bore: 3.531 in.

Correcting Service Manuals and Audio-Visual Programs

Insert the corrected text contained on the attached sheet in your Service Manuals and Audio-Visual Programs. If additional correction pages are needed, contact the Technical Communications Department, Extension 4328.