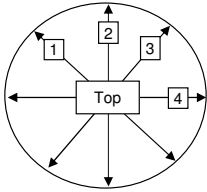
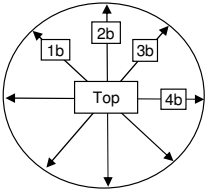
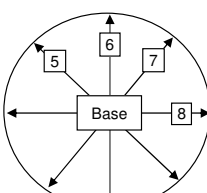
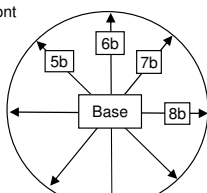
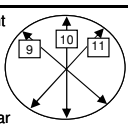




### Dimensional check of top engine SUZUKI 250RGV - APRILIA 250RS

| Model                 |                         | Controlled part:        |                    |         |                            |                                                                |                            |                                                                                                                                                                                                                                                                                                                                                                                                                                                       |
|-----------------------|-------------------------|-------------------------|--------------------|---------|----------------------------|----------------------------------------------------------------|----------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| RGV 91-96<br>RS 96-03 |                         | Controller:             |                    | Date:   |                            |                                                                |                            |                                                                                                                                                                                                                                                                                                                                                                                                                                                       |
| Driving mileage:      |                         |                         |                    |         |                            |                                                                |                            |                                                                                                                                                                                                                                                                                                                                                                                                                                                       |
| Ambient temperature:  |                         |                         |                    |         |                            |                                                                |                            |                                                                                                                                                                                                                                                                                                                                                                                                                                                       |
| Measuring item        | Standard dimension min. | Standard dimension max. | Limit              | Measure | Deviation / min. dimension | Deviation / max. dimension                                     | Average deviation of parts | Comments                                                                                                                                                                                                                                                                                                                                                                                                                                              |
| 1                     | 56,000                  | 56,023                  | Nicks or scratches |         |                            |                                                                |                            | <p>Front</p>  <p>Rear</p>  <p>Measure at 10mm from each end and near ports</p> <p>Front</p>  <p>Rear</p>  |
| 2                     | 56,000                  | 56,023                  |                    |         |                            |                                                                |                            |                                                                                                                                                                                                                                                                                                                                                                                                                                                       |
| 3                     | 56,000                  | 56,023                  |                    |         |                            |                                                                |                            |                                                                                                                                                                                                                                                                                                                                                                                                                                                       |
| 4                     | 56,000                  | 56,023                  |                    |         |                            |                                                                |                            |                                                                                                                                                                                                                                                                                                                                                                                                                                                       |
| 1b                    | 56,000                  | 56,023                  |                    |         |                            |                                                                |                            |                                                                                                                                                                                                                                                                                                                                                                                                                                                       |
| 2b                    | 56,000                  | 56,023                  |                    |         |                            |                                                                |                            |                                                                                                                                                                                                                                                                                                                                                                                                                                                       |
| 3b                    | 56,000                  | 56,023                  |                    |         |                            |                                                                |                            |                                                                                                                                                                                                                                                                                                                                                                                                                                                       |
| 4b                    | 56,000                  | 56,023                  |                    |         |                            |                                                                |                            |                                                                                                                                                                                                                                                                                                                                                                                                                                                       |
| 5                     | 56,000                  | 56,023                  |                    |         |                            |                                                                |                            |                                                                                                                                                                                                                                                                                                                                                                                                                                                       |
| 6                     | 56,000                  | 56,023                  |                    |         |                            |                                                                |                            |                                                                                                                                                                                                                                                                                                                                                                                                                                                       |
| 7                     | 56,000                  | 56,023                  |                    |         |                            |                                                                |                            |                                                                                                                                                                                                                                                                                                                                                                                                                                                       |
| 8                     | 56,000                  | 56,023                  |                    |         |                            |                                                                |                            |                                                                                                                                                                                                                                                                                                                                                                                                                                                       |
| 5b                    | 56,000                  | 56,023                  |                    |         |                            |                                                                |                            |                                                                                                                                                                                                                                                                                                                                                                                                                                                       |
| 6b                    | 56,000                  | 56,023                  |                    |         |                            |                                                                |                            |                                                                                                                                                                                                                                                                                                                                                                                                                                                       |
| 7b                    | 56,000                  | 56,023                  |                    |         |                            |                                                                |                            |                                                                                                                                                                                                                                                                                                                                                                                                                                                       |
| 8b                    | 56,000                  | 56,023                  |                    |         |                            |                                                                |                            |                                                                                                                                                                                                                                                                                                                                                                                                                                                       |
| 8c                    | 56,000                  | 56,023                  | Nicks or scratches |         |                            |                                                                |                            | Average value                                                                                                                                                                                                                                                                                                                                                                                                                                         |
| 8d                    |                         |                         |                    |         |                            |                                                                |                            | Standard deviation                                                                                                                                                                                                                                                                                                                                                                                                                                    |
| 9                     | 55,936                  | 55,961                  | 55,880             |         |                            |                                                                |                            | <p>Measure at 19mm from the skirt end</p> <p>Front</p>  <p>Rear</p> <p>AV</p> <p>AR</p>                                                                                                                                                                                                                                                                          |
| 10                    | 55,936                  | 55,961                  | 56,880             |         |                            |                                                                |                            |                                                                                                                                                                                                                                                                                                                                                                                                                                                       |
| 11                    | 55,936                  | 55,961                  | 57,880             |         |                            |                                                                |                            |                                                                                                                                                                                                                                                                                                                                                                                                                                                       |
| 12                    | 0,055                   | 0,071                   | 0,120              |         |                            |                                                                |                            | Piston to cylinder clearance                                                                                                                                                                                                                                                                                                                                                                                                                          |
| 13                    | 16,010                  | 16,020                  | 16,036             |         |                            |                                                                |                            | Piston pin bore vertical left                                                                                                                                                                                                                                                                                                                                                                                                                         |
| 14                    | 16,010                  | 16,020                  | 16,036             |         |                            |                                                                |                            | Piston pin bore horizontal left                                                                                                                                                                                                                                                                                                                                                                                                                       |
| 15                    | 16,010                  | 16,020                  | 16,036             |         |                            |                                                                |                            | Piston pin bore vertical right                                                                                                                                                                                                                                                                                                                                                                                                                        |
| 16                    | 16,010                  | 16,020                  | 16,036             |         |                            |                                                                |                            | Piston pin bore horizontal right                                                                                                                                                                                                                                                                                                                                                                                                                      |
| 17                    | 15,995                  | 16,000                  | 15,980             |         |                            |                                                                |                            | Piston pin OD                                                                                                                                                                                                                                                                                                                                                                                                                                         |
| 18                    | 5                       | 5                       | 4                  |         |                            |                                                                |                            | 1st Piston ring free end gap                                                                                                                                                                                                                                                                                                                                                                                                                          |
| 19                    | 0,15                    | 0,30                    | 0,7                |         |                            |                                                                |                            | 1st Piston ring end gap                                                                                                                                                                                                                                                                                                                                                                                                                               |
| 20                    | 0,02                    | 0,06                    | -                  |         |                            |                                                                |                            | 1st Piston ring to groove clearance                                                                                                                                                                                                                                                                                                                                                                                                                   |
| 21                    | 6                       | 6                       | 4,8                |         |                            |                                                                |                            | 2nd Piston ring free end gap                                                                                                                                                                                                                                                                                                                                                                                                                          |
| 22                    | 0,15                    | 0,30                    | 0,7                |         |                            |                                                                |                            | 2nd Piston ring end gap                                                                                                                                                                                                                                                                                                                                                                                                                               |
| 23                    | 0,02                    | 0,06                    | -                  |         |                            |                                                                |                            | 2nd Piston ring to groove clearance                                                                                                                                                                                                                                                                                                                                                                                                                   |
| Average wear:         |                         |                         |                    |         |                            | Only dimensional, excluding scratches, seizing, shocks, etc... |                            |                                                                                                                                                                                                                                                                                                                                                                                                                                                       |

**Comments:**