

PISTON ASSEMBLY

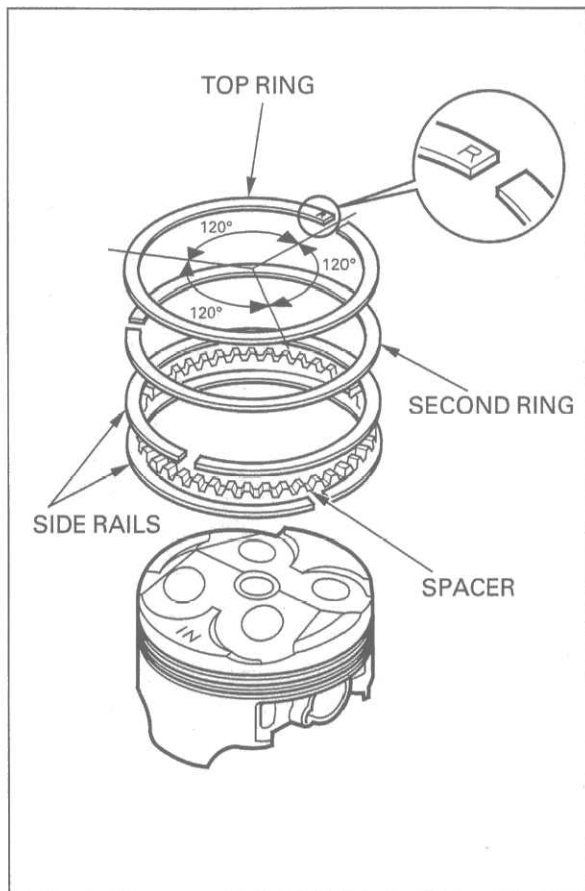
Clean the piston ring grooves thoroughly and install the piston rings.

NOTE:

- Apply oil to the piston rings.
- Avoid piston and piston ring damage during installation.
- Install the piston rings with the marking (R) facing up.
- Do not mix the top and second rings; the top ring is narrower than the second ring in width.

Space the piston ring end gaps 120 degrees apart. Do not align the gaps in the oil rings (side rails).

After installation, the rings should rotate freely in the ring grooves.



PISTON INSTALLATION

Apply molybdenum disulfide oil to the connecting rod small end. Assemble the piston and connecting rod.

NOTE:

Install the connecting rod with its oil hole side facing the "IN" mark on the piston crown.

Do not align the piston pin clip end gap with the piston cut-out.

Apply oil to the piston pin outer surface. Install the piston pin, and secure it using a new piston pin clip.

Apply oil to the cylinder sleeve and piston rings.

Install the piston/connecting rod assembly into the cylinder using a commercially available piston ring compressor tool.

CAUTION:

- **While installing the piston, being careful not to damage the top surface of the cylinder, especially around the cylinder bore.**
- **Be careful not to damage the cylinder sleeve and crank pin with the connecting rod bolt threads.**

Install the piston/connecting rod assembly with the piston "IN" mark facing to the intake side.

