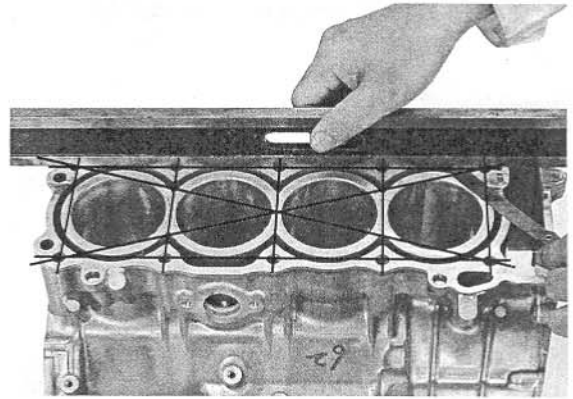


Inspect the top of the cylinder for warpage.

SERVICE LIMIT: 0.10 mm (0.004 in)



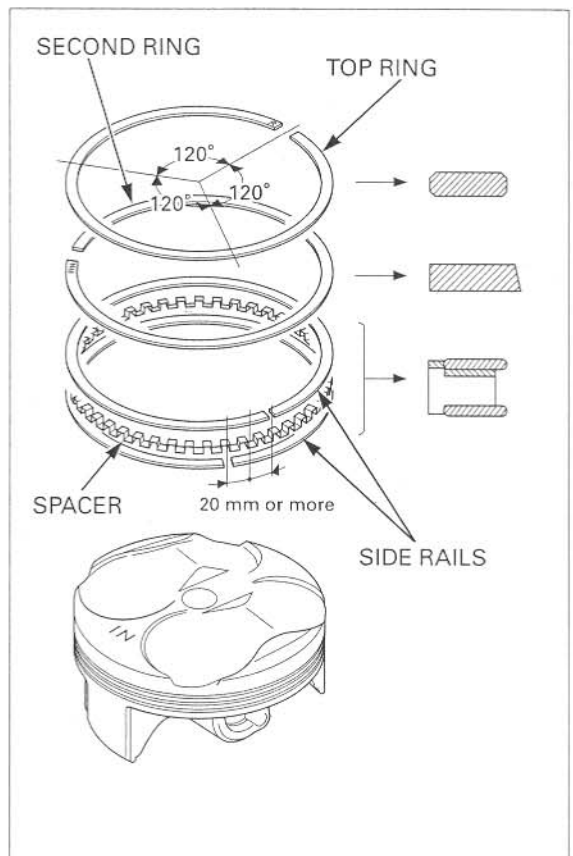
PISTON ASSEMBLY

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

- Apply oil to the piston rings.
- Avoid piston and piston ring damage during installation.
- Install the piston rings with the marking (R: top ring, RN: second ring) facing up.
- Do not mix the top and second rings; top ring is narrower than the second ring in width.
- To install the oil ring, install the spacer first, then install the side rails.

Stagger the piston ring end gaps 120° apart from each other.
Stagger the side rail end gaps as shown.

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



PISTON INSTALLATION

Apply molybdenum oil solution to the connecting rod small end inner surfaces and piston pin outer surfaces.

Assemble the piston and connecting rod with the journal bearing tab facing to the piston "IN" mark.

