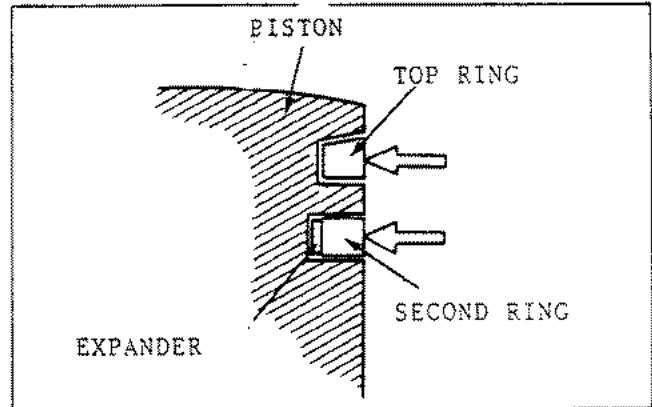


Install top, second rings and expander to piston.  
 Push piston rings into place and check that the piston circumference and piston rings are inserted at the same height. If it does not insert correctly the rings may be damaged or carbon may be deposited on piston rings



### PISTON PIN INSPECTION

Measure piston pin O.D

Service limit: 14.98mm (replace if under)

Check piston-to-piston pin clearance

Service limit: 0.04mm (replace if above)

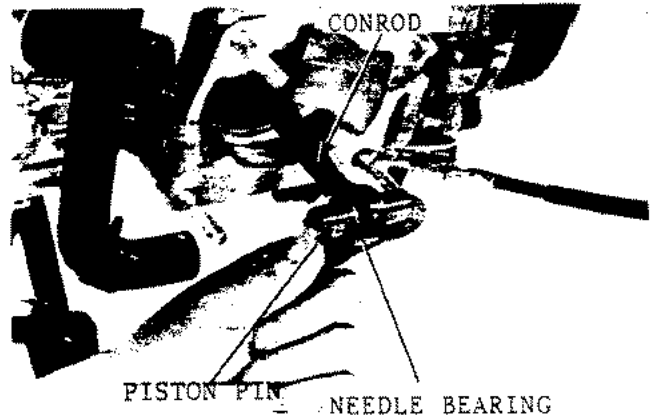
If above service limit value replace with new piston pin

If within service limit replace piston and piston pin



### CONROD SMALL END INSPECTION

Install conrod small end needle bearing end piston pin in conrod small end, and inspect condition. Replace if movement in



### CYLINDER PISTON SELECTION

If cylinder or piston exceed service limit then replace pistons that correspond to cylinder must be installed  
 Select as per the following method:

#### Piston Selection

Write down piston mark

- \* The mark is on top of piston
- \* In order that the piston selected corresponds with same cylinder mark, decide using the mark on the cylinder

When replacing piston, select piston with the same mark

