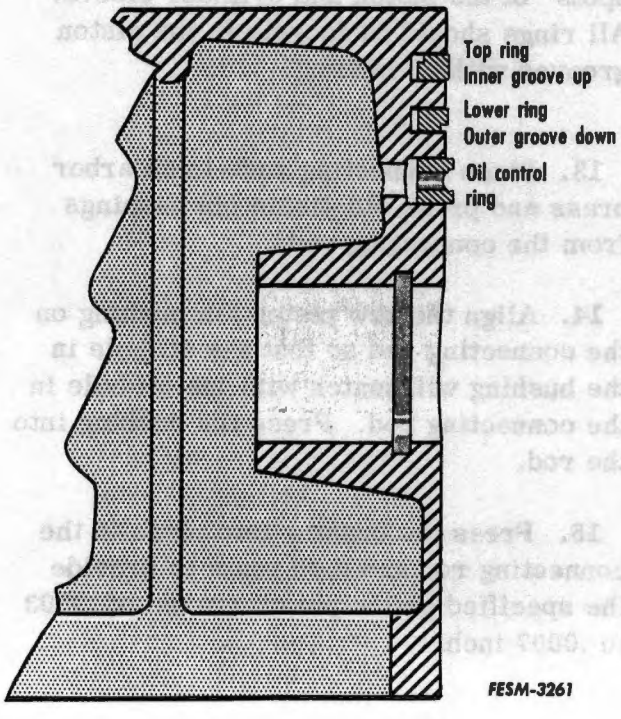
Reassembly

1. Before assembling the piston and connecting rod, check the fit of the piston pin in the piston for proper end clearance as follows:

(a) Prepare the piston and the pin for assembly as outlined in Step 2.

(b) Push the pin into the piston and install a retainer ring at each side of the piston.

(c) Push one end of the piston pin until it stops against the retainer ring on the opposite side of the piston.



(d) Using a feeler gauge, in the gap between the piston pin and the retainer ring, check for end clearance. Specified end clearance is .010 to .030 inch.

(e) Remove the retainer rings and proceed with the assembly as follows:

NOTE: When assembling the pistons to the rods, the front of the piston will be indicated by an arrow.

2. With the piston pin at room temperature (70°) and generously coated with clean engine lubricating oil, and the piston heated in hot water to approximately 150°F the piston pin can be entered into one boss of the piston by pushing with the hand. While the piston is hot, quickly and correctly position the connecting rod inside the piston, align the bushing in the rod bore with the piston pin holes in the piston and push the piston pin completely into position. Thoroughly dry the piston with compressed air.

3. Install a retainer ring in the groove at each side of the piston to secure the piston pin.

4. Using a piston ring expander, install the rings, oil control ring first, into the grooves of the pistons.

Position the ring gaps 90 degrees from the thrust side of the piston (in line with the piston pin bore) and 180 degrees from one gap to another.

Be sure the compression rings are installed with their grooves positioned as shown.