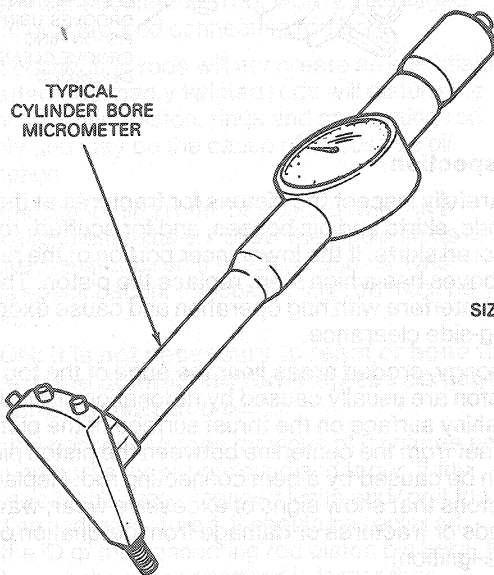


OVERHAUL (Continued)

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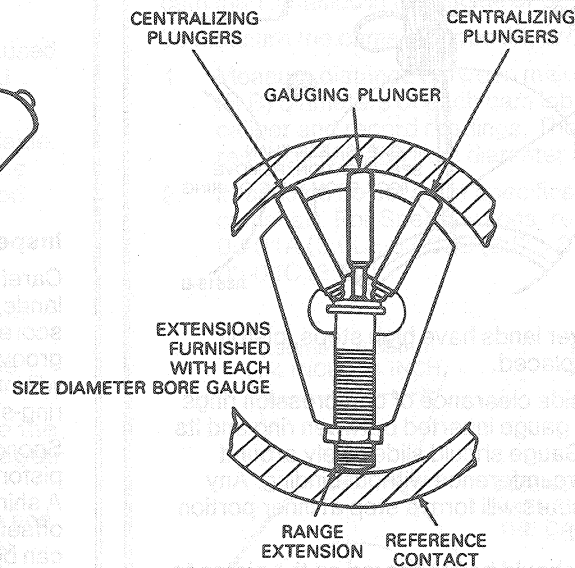
Measure the piston diameter to ensure the specified clearance is obtained. It may be necessary periodically to use another piston (within the same grade size) that is either slightly larger or smaller to achieve the specified clearance.

If none can be fitted, refinish the cylinder to provide the proper clearance for the piston.



When a piston has been fitted, mark it for assembly in the cylinder to which it was fitted.

If the taper, out-of-round and piston-to-cylinder bore clearance conditions of the cylinder bore are within specified limits, new piston rings will give satisfactory service.



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If new rings are to be installed in a used cylinder that has not been refinished, remove the cylinder wall glaze using only spring-loaded Engine Cylinder Hone Set T73L-6011-A, and only if there is no visible sign of cross-hatch markings on the cylinder walls. (Refer to Cylinder block, Cylinder Walls, Refinishing.) Always clean the cylinder bore thoroughly with detergent and water solution.

NOTE: After any refinishing operation, allow cylinder bore to cool, and ensure piston and bore are clean and dry before piston fit is checked.

1. Calculate size piston to be used by taking a cylinder bore check. Follow procedures outlined previously.
2. Select proper size piston to provide desired clearance. Measure piston diameter in-line with centerline of piston pin and at 90 degrees to piston pin axis.

3. Ensure piston and cylinder block are at room temperature, 21°C (70°F).

Measure the piston diameter to ensure the specified clearance is obtained. It may be necessary periodically to use another piston (within the same grade size) that is either slightly larger or smaller to achieve the specified clearance.

Fitting Piston Rings

NOTE: Always use a piston ring expanding tool to install rings on a piston.

1. Select proper ring set for the size cylinder bore.
2. Position ring in cylinder bore in which it is going to be used.
3. Push ring down into bore area where normal ring wear is not encountered.

CAUTION: Use care to avoid damage to ring or cylinder bore.

4. Position ring in bore so ring is square with cylinder wall.