

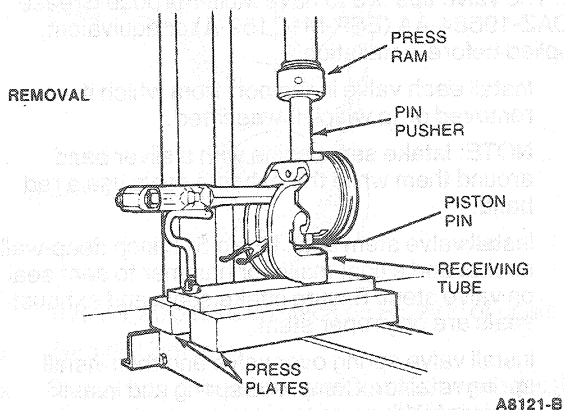
DISASSEMBLY AND ASSEMBLY (Continued)

Disassembly

1. Remove bearing inserts from connecting rod and cap.
2. Remove piston rings using a suitable piston ring expander.
3. Mark connecting rod cap to ensure assembly with the same piston and installation in the same cylinders from which they were removed.

NOTE: Mark piston to match cylinder number. Matching letters are stamped in the sides of corresponding rod and cap.

4. Using an Arbor Press and Piston Pin Remover / Replacer T68P-6135-A, press the piston pin from the piston and connecting rod.



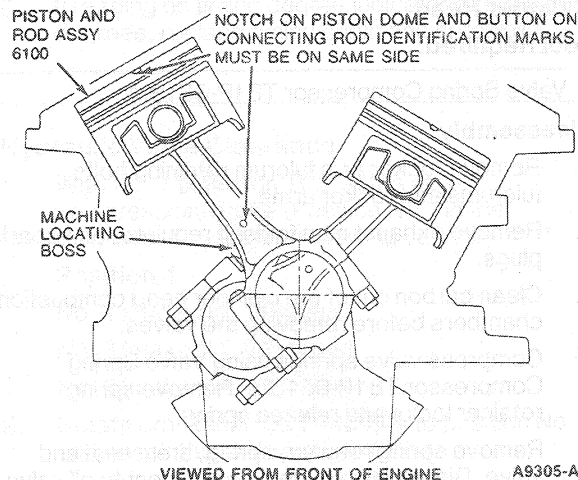
A8121-B

Assembly

Check the fit of a new piston in the cylinder bore before assembling the piston and piston pin to the connecting rod.

The piston pin bore of a connecting rod and the diameter of the piston pin must be within specification.

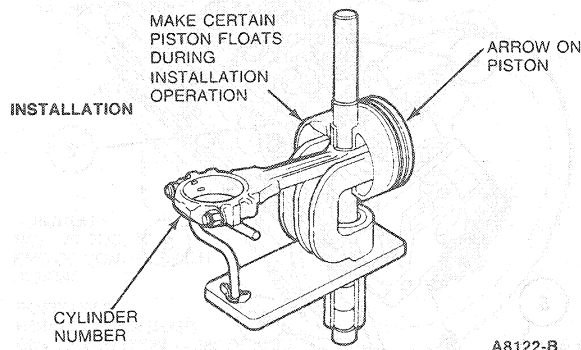
1. Apply a light coat of Engine Assembly Lubricant D9AZ-19579-D (ESR-M99C80-A) or equivalent to all parts.
2. Assemble the piston to the connecting rod, putting the notch in the piston dome and the connecting rod on the same side.



VIEWED FROM FRONT OF ENGINE A9305-A

On V-6 engines with one rod per pin, both sides of rod have larger chamfers.

3. Start the piston pin in the piston and connecting rod. (This may require a very light tap with a mallet). Using an Arbor Press and Piston Pin Remover / Replacer T68P-6135-A, press the piston pin through the piston until the pin is centered in the piston.



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4. Check the end gap of all piston rings. It must be within specification. Follow the instructions contained on the piston ring package and install the piston rings.
5. Check the ring side clearance of the compression rings with Feeler Gauge D81L-4201-A or equivalent, by inserting it between the ring and its lower land. The gauge should slide freely around the entire ring circumference without binding. Any wear that occurs will form a step at the inner portion of the lower land. If the lower lands have high steps, the piston should be replaced.
6. Ensure the bearing inserts and the bearing bore in the connecting rod and cap are clean. Foreign material under the inserts will distort the bearing and cause a failure. Install the bearing inserts in the connecting rod and cap with the tangs fitting in the slots provided.