

Rings	Serviceable limit
Top and second ring	0.0276 in. (0.7 mm)
Oil ring	0.0276 in. (0.7 mm)

5. Measuring the ring side clearance
 Measure the clearance between the piston ring and the ring lands using a thickness gauge. (Fig. 3-63)
 If clearance is beyond the specified value shown below, they should be replaced.

Rings	Serviceable limit
Top ring	0.0071 in. (0.18 mm)
Second ring	0.0065 in. (0.165 mm)
Oil ring	0.0045 in. (0.114 mm)

6. Measuring the piston pin bore (Fig. 3-63)
 Measure the piston pin bore using an inside micrometer or inner dial gauge and if the dimension is over 0.5938 in. (15.08 mm), the piston should be replaced. (Fig. 3-64)

d. Reassembly

- When assembling the new rings on the piston, roll the rings around the piston ring groove to check for proper clearance before assembling. (Fig. 5-65)
- The piston ring should be installed with manufacturer marking located at the end of the ring toward the top. (Fig. 5-66)
- Assemble the piston on the connecting rod so that the arrow mark on top of the piston is toward the exhaust side (forward) then install all new piston pin clips. (Fig. 3-67)
- Spaced piston ring gaps of all three rings to 120° apart and then install the piston into the cylinder and then assemble the cylinder.
- For other information, refer to page 36~38.

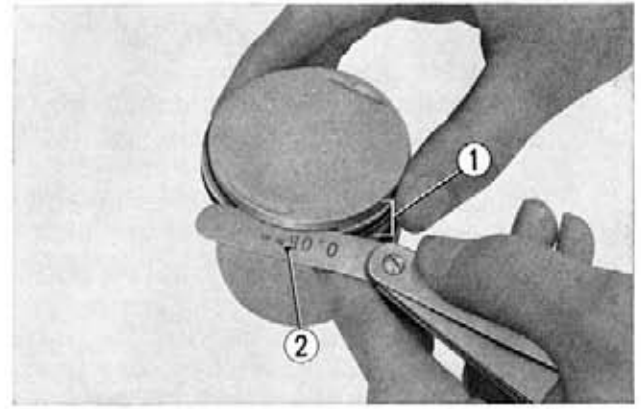


Fig. 3-63 ① Piston ring ② Thickness gauge

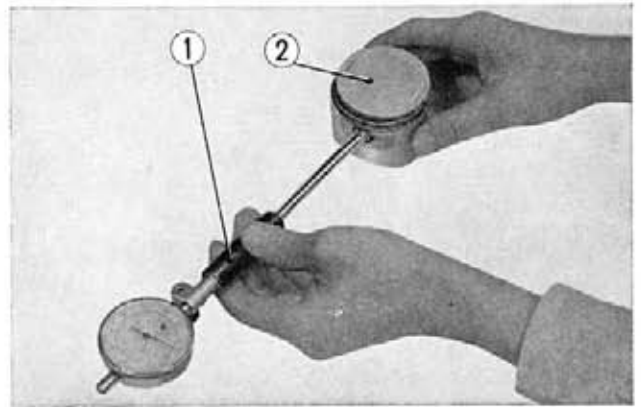


Fig. 3-64 ① Inner dial gauge
② Piston

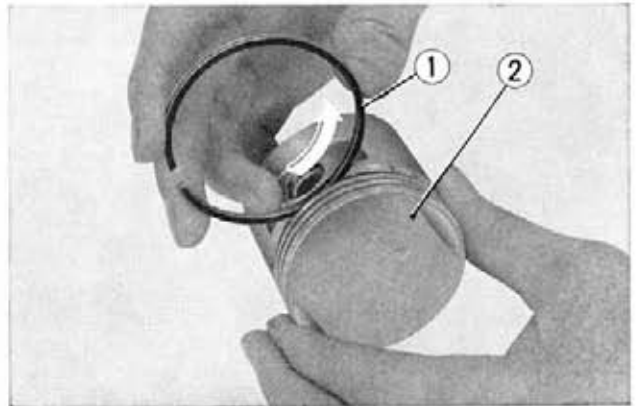


Fig. 3-65 ① Piston ring
② Piston

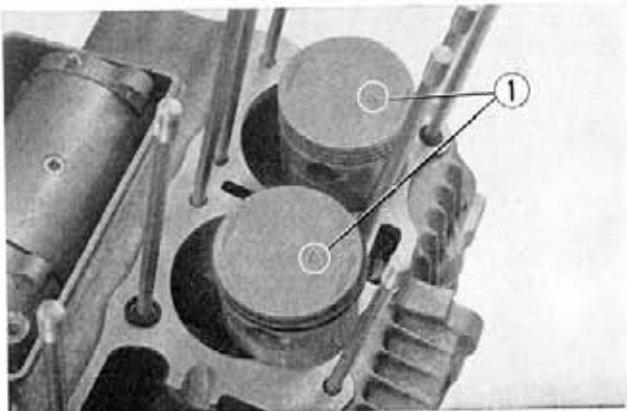


Fig. 3-67 ① Arrow marks

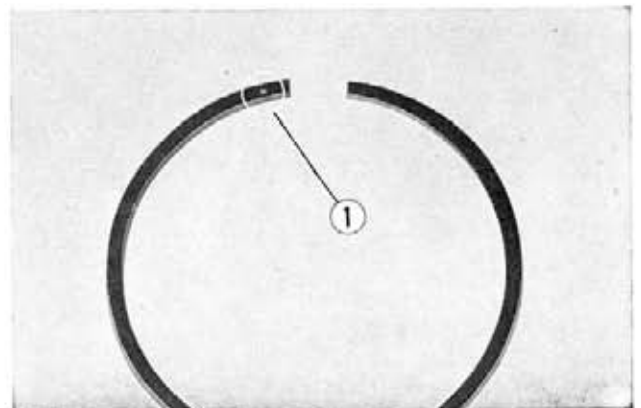


Fig. 3-66 ① Manufacturer mark