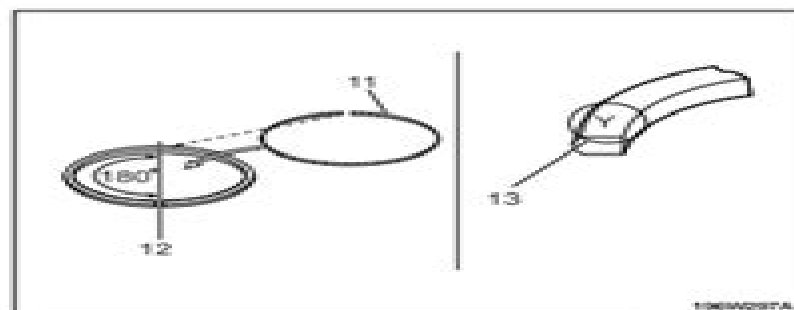
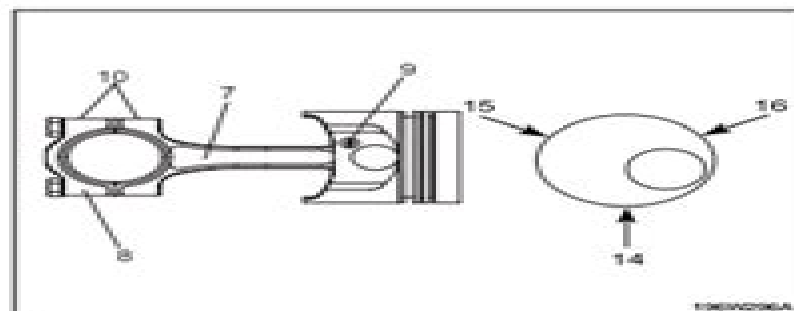
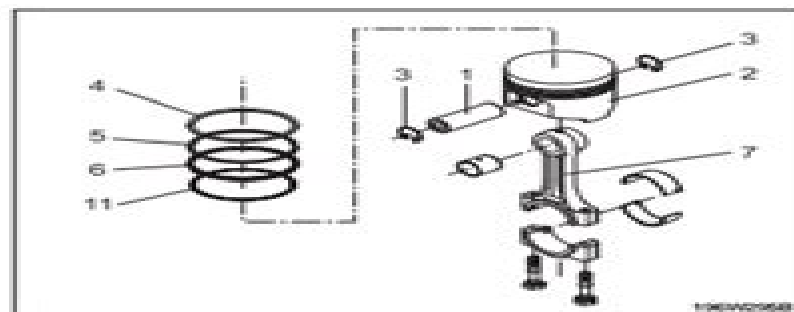


E. PISTON RING AND PISTON PIN

1. Remove the piston rings with a piston ring replacing tool.
2. Remove the piston pin.

(When reassembling)

- Clean all the parts before assembling.
- Heat the piston in approx. 80°C (176°F) of oil for 10 – 15 minutes, when inserting the piston pin into the piston.
- Install the piston and connecting rod with the mark FW on the piston to the flywheel and the mark on the connecting rod to the injection pump.
- Install the piston rings with their manufacturer's mark to the top of piston.
- Install the top ring with its gap at 90° (1.57 rad) from piston pin to the exhaust port.
- Install the second ring and oil ring with their gap at every 120° (2.09 rad) or 180° (3.14 rad).
- Install the expander in the oil ring with its gap opposite to the gap of oil ring.



- | | |
|--------------------------|--------------------------|
| (1) Piston pin | (9) Mark |
| (2) Piston | (10) Casting mark |
| (3) Piston pin snap ring | (11) Expander joint |
| (4) Top ring | (12) Oil ring gap |
| (5) Second ring | (13) Manufacturer's mark |
| (6) Oil ring | (14) Top ring |
| (7) Connecting rod | (15) Second ring |
| (8) Connecting rod cap | (16) Oil ring gap |

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Zhe Xu



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