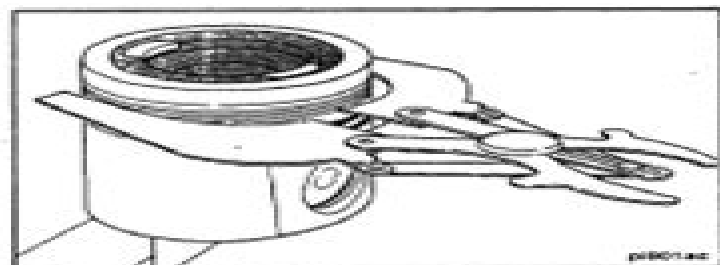
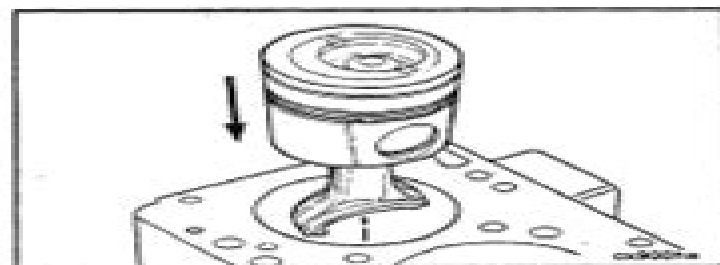


Install the second retaining ring.



**Piston Ring Expander, Part No. 3823137**

Use the piston ring expander, Part No. 3823137, to install the piston rings. Refer to Procedure 001-047.



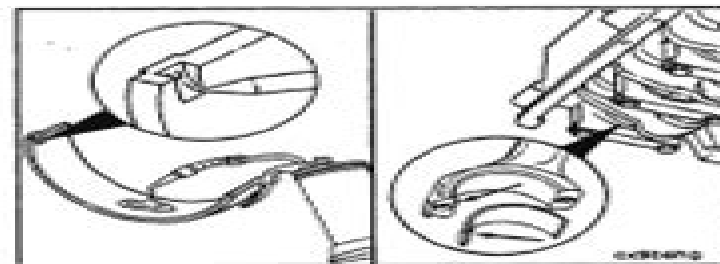
**Piston Grading**

When rebuilding an engine with the original cylinder block, crankshaft, and pistons, make sure the pistons are installed in the original cylinder.

If replacing the piston(s), make sure the replacement piston(s) are the same grade as the original piston.

If a new cylinder block or crankshaft is used, the piston grading procedure must be performed to determine the proper piston grade for each cylinder.

Install the connecting rod/piston assembly into the No. 1 cylinder without the rings installed.



**NOTE:** The connecting rod bearings must be installed in the original connecting rod and cap.

Install the upper shell in the connecting rod with the tang of the bearing in the slot of the connecting rod.

Use clean 15W-40 engine oil to coat the inside diameter of the connecting rod bearing shell.

# Isb Shop Manual

**E Durkheim**



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