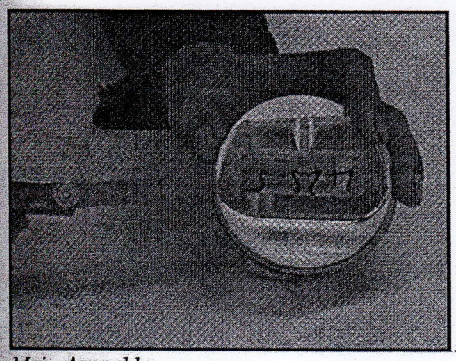


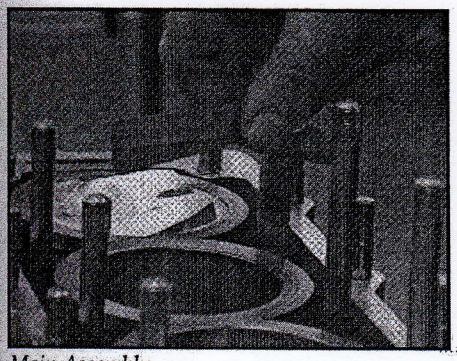
Main Assembly

Check thrust clearance.



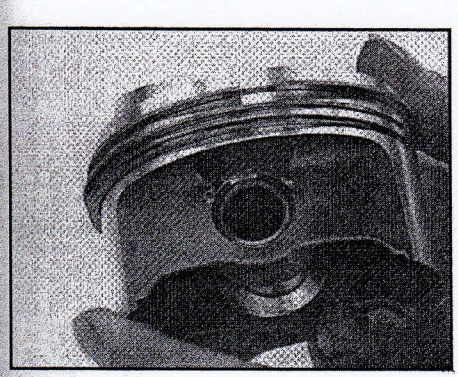
Main Assembly

Weigh pistons with gudgeon pins and select 8 that are within 1g of each other.



Main Assembly

Check the piston ring gaps by inserting the ring into the bore and measuring with feeler gauge. This should be:-
Top Ring 15 thou min / 17 thou max
2nd Ring 9 thou min / 11 thou max



Main Assembly

Next wash the rings in spirit wipe and fit starting with oil control ring first, then the 2nd and first rings.