

INSPECTION AND REPAIR

Pistons

1. Wash the piston and connecting rod assembly in a suitable solvent and dry with a hot air gun or compressed air.



Figure 18
Piston Ring Removal



Figure 19
Piston Pin Removal

1. Compression Ring
2. Oil Control Ring
3. Piston Pin Retainer
4. Piston Pin
5. Bearing Shells
6. Piston Pin Bushing
7. Connecting Rod
8. Connecting Rod Cap
9. Piston Pin Cover — Part No. 1088

Using a ring groove cleaner, remove the carbon deposits from the ring grooves. Be careful to avoid cutting any metal from either the side or the bottom of the grooves. Figure 20.

2. Inspect the piston ring lands for excessive wear.

Using a new ring and feeler gauge check the side clearance. Figure 21.

Replace pistons that exceed the following wear limits:

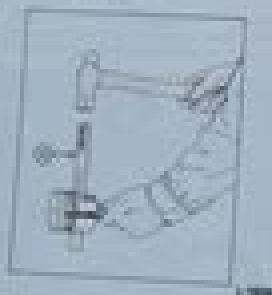
Wear Limit	
Compression Ring	0.005 in. (0.25 mm)
Oil Control Ring	0.008 in. (0.20 mm)

3. Using a micrometer, check the piston diameter at 90° from the piston pin boss. Figure 22.

Replace pistons that are worn to less than factory minimum diameter.

Model 110	2.987 in. (76.1 mm)
Model 120	2.925 in. (74.3 mm)

4. Using a small feeler gauge and micrometer, measure the piston pin bush diameter and the pin diameter. Figure 23.



Replace pistons or pins that exceed the following wear limits:

	Wear Limit		
	Piston Pin Bush Clearance	Piston Pin Diameter	Pin to Bush Clearance
Model 110	0.005 in. (0.13 mm)	0.002 in. (0.05 mm)	0.003 in. (0.08 mm)
Model 120	0.007 in. (0.18 mm)	0.004 in. (0.10 mm)	0.003 in. (0.08 mm)



Figure 24
Piston Ring Groove — Cleaning



Figure 25
Piston Skirt — Wear Check
100% Piston Skirt



Figure 26
Ring Land — Wear Check

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NOTE: In some instances, the pin diameter may be measured slightly larger than the piston bush diameter. This measurement is normal.

WASCS

1. Check wear rings in the cylinder bore to determine the end gap clearance and ring wear as follows:

Position the rings, with a key in the cylinder bore. Push the ring down to the bottom point of the ring travel using an inverted piston to square the ring to the bore. Use a feeler gauge and measure the ring and gap. Figure 27.

Replace wear rings having a ring gap exceeding 0.008 in. (0.2 mm).

Check into piston rings in the same manner to assure that wear rings have sufficient end gap clearance.

Enlarge the ring and gap. Figure 28. If less than 0.008 in. (0.20 mm) to the specified dimension. See "Specifications" — Chapter 3.

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