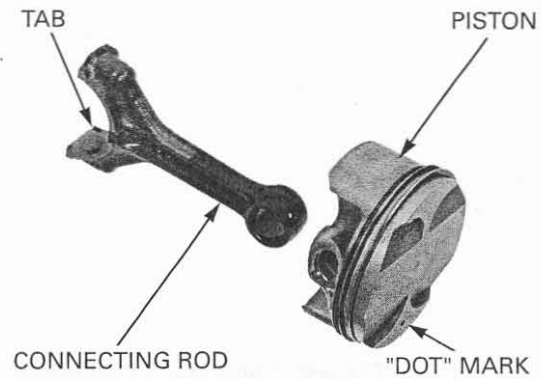


PISTON INSTALLATION

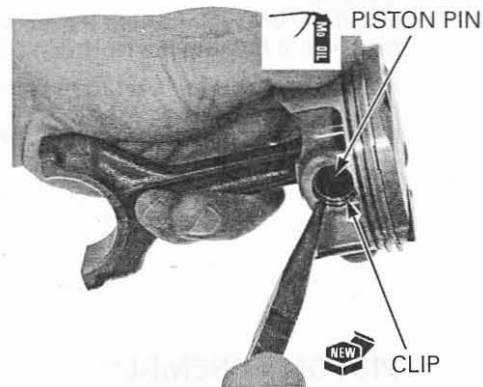
Apply molybdenum oil solution to the connecting rod small end inner surfaces and piston pin outer surfaces.

Assemble the piston and connecting rod with the journal bearing tab facing to the piston "dot" mark.



Install the piston pin and secure it using new piston pin clips.

- Make sure that the piston pin clips are seated securely.
- Do not align the piston pin clip end gap with the piston cut-out.



Coat the cylinder walls, pistons and piston rings with engine oil.

Install the piston/ connecting rod assembly with the piston "IN" mark facing the intake side.

Install the piston/connecting rod assemblies into the cylinders using a commercially available piston ring compressor tool.

TOOL (Commercially available):
Piston ring compressor RC40C

When reusing the connecting rods, they must be installed in their original locations.

NOTICE

- While installing the piston, be careful not to damage the top surface of the cylinder, especially around the cylinder bore.
- Be careful not to damage the cylinder sleeve and crankpin with the connecting rod.

Make sure the piston ring compressor tool sits flush on the top surface of the cylinder.

Use the handle of a plastic hammer or equivalent tool to tap the piston into the cylinder.

Install the crankshaft (page 13-8).

