

When the correct fit is obtained you must be able to withdraw the feeler with a pull of 8-10 pounds on the scale, with the feeler inserted between the piston and the cylinder midway between the piston pin bores where the diameter of the piston is the greatest. Check the fit of the piston when it is approximately 2" down in the cylinder bore in an inverted position.

PISTON PINS

Check the bushing in the upper end of the connecting rod for wear. If worn and you are using the original pistons with a service set of rings, an oversize piston pin may be obtained in .003 or .005" oversize.

The piston pin hole in the piston and the bushing in the connecting rod may be honed to increase

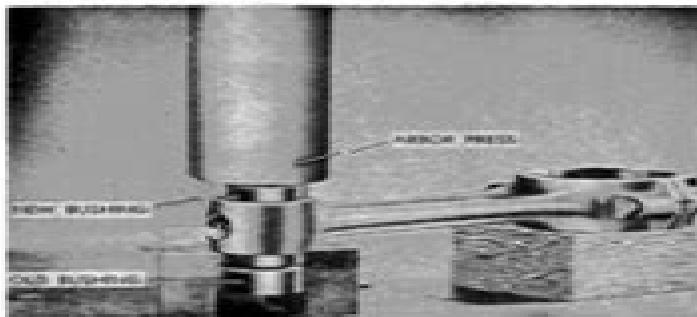


Figure 37 — Pressing in Piston Pin Bushing

their diameter to obtain the desired fit as shown in your Limits and Clearance Chart.

Note that while the chart specifies a light push fit of the pin in the piston, there is a definite clearance of the piston pin in the connecting rod.

CONNECTING ROD

Replace the bushing in the connecting rod if new pistons and sleeves are used. Using an arbor press, press out the old bushing and press in the new one — after which the bushing must be honed to obtain the correct fit of the pin in the bushing as shown in Limits and Clearance Chart.

If there is an excess of stock in the piston pin bushing, it may be reamed first, then honed. In any event, the final operation should be done with a honer to obtain the desired fit with better than 75% bearing area on the pin.

PISTON AND CONNECTING ROD ASSEMBLY

1. Assemble the pistons on the connecting rod by first heating them in some form of oven or in hot water to a minimum temperature of 160°F. When heated, the piston pin will enter the piston very easily and can be tapped through the connecting rod and into place without distorting the piston.

The snap rings must be assembled in the grooves, making sure they are fully seated in place.

2. The piston pin hole in the connecting rod must be parallel to and in plane with, the large bore in the bearing end of the connecting rod.



Figure 38 — Checking connecting rod for twist and alignment

This may be checked on a fixture with the piston pin assembled in the rod before assembling the piston, but regardless of this preliminary check, the completed piston and rod assembly must be rechecked and there must not be more than .0005" twist or out of squareness checked over a spread of approximately 4 inches. The connecting rod can be bent or twisted to meet this specification.

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a all marking must be done in rm assessor using the mathematical studies annotations and in accordance with the current document for guidance in emarking mathematical studies sl it is essential that you read this document before you start marking b if the candidate has full marks on a question use the annotation if the candidate has made c6

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