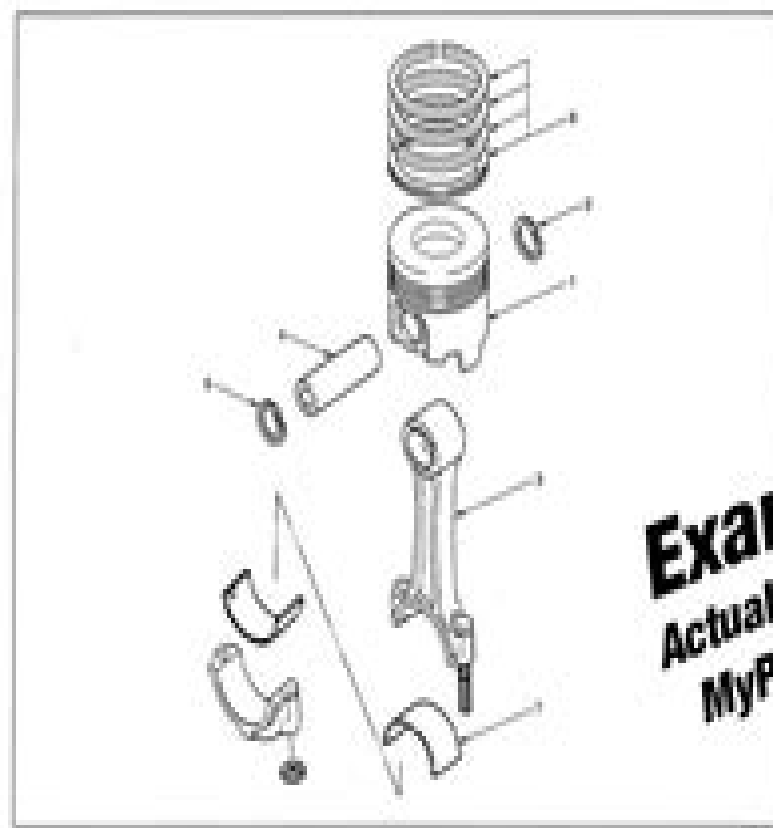


PISTON AND CONNECTING ROD ASSEMBLY



Assembly sequence

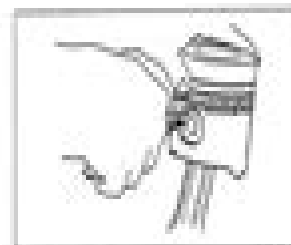
- | | |
|--------------------|----------------------------|
| a1. Piston | a6. Snap ring |
| a2. Snap ring | a8. Piston ring |
| a3. Connecting rod | a7. Connecting rod bearing |
| a4. Piston pin | |

IMPORTANT OPERATIONS

1. Piston
2. Snap ring
3. Connecting rod

Use a piston heater to heat the piston to about 100°C.

- (1) Using snap-ring pliers, install one snap ring in the piston.
- (2) Fit the connecting rod in a vice. Hold the connecting rod in copper plates to prevent damage to the connecting rod.
- (3) Assemble the piston to the connecting rod. Install the piston so that the front mark (1) on the piston's head and the forged "BLUET" mark on the connecting rod (2) are pointing toward the engine's front.

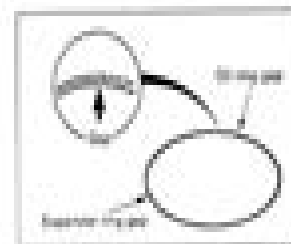


4. Piston pin
5. Snap ring

- (1) Apply a liberal coat of clean engine oil to the piston pin, connecting rod, and the piston's hole.
- (2) Align the piston and the connecting rod's piston hole, and press in the piston pin strongly.
- (3) Use snap-ring pliers to install the other snap ring in the position.

Note:
Confirm that the snap ring is securely installed in the ring grooves.

- (4) Remove the piston and connecting rod assembly from the vice and check that the connecting rod moves smoothly.



6. Piston rings
- (1) Assemble the oil ring and expander ring.

Note:
Assemble the two rings so that their gaps are located on opposite sides (180° apart) from each other.

- (2) Apply clean engine oil to the piston rings and piston-ring grooves.

D12 Engine Service Manual

James E. Duffy, Howard Bud Smith

A red circular graphic with a gradient, appearing as a stylized arrow or a partial circle, located to the right of the authors' names.

D12 Engine Service Manual:

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