

7) Piston and connecting rod assembly

- (1) Coat the metal surface, piston and piston ring with engine oil.
- (2) Turn the ring to allow the oil to ensure the ring groove sufficiently, and set the ring end gaps at 90° respectively avoiding piston pin direction and the direction at a right angle to the piston pin.
- (3) Insert the ring facing the connecting rod figure match mark toward the injection pump side, using ring pliers.

NOTE:

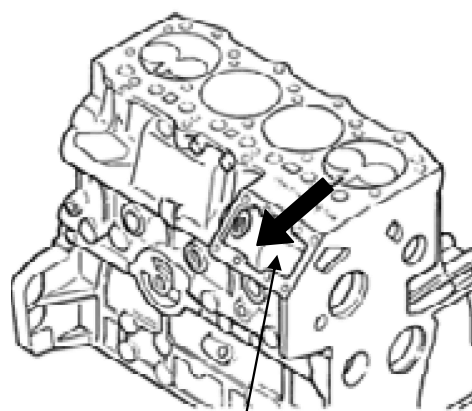
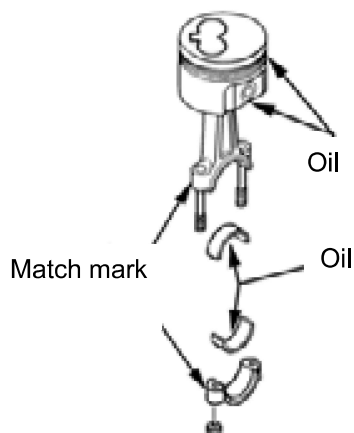
Place the smallest connecting rod figure match mark to the front side so that the figures increase gradually.

- (4) Tighten the connecting rod cap with the specified torque and check for the axial play.

Tightening torque
49 – 54 N·m {5.0 – 5.5 kgf·m}

NOTE:

1. After tightening, confirm that the crankshaft moves lightly.
2. The connecting rod should move 0.1 – 0.3 mm in the axial direction.



Injection pump side