

Table 7 Piston Specifications

Model	Skirt Dia.	Top Groove width x depth			Second Groove width x depth		
H1	inch	2.36122	.0591 +.0039 +.0031	x .1063 ±.0039	.0591 +.0024 +.0016	x .1063 ±.0039	
	mm	59.975	1.5 +0.10 +0.08	x 2.7 ±0.1	1.5 +0.06 +0.04	x 2.7 ±0.1	
H2	inch	2.79314	.0591 +.0039 +.0031	x .1272 ±.0039	.0591 +.0024 +.0016	x .1272 ±.0039	
	mm	70.946	1.5 +0.10 +0.08	x 3.23 ±0.1	1.5 +0.06 +0.04	x 3.23 ±0.1	

(2) Piston pressure against the sides of the cylinder causes piston wear. Measure piston diameter at the skirt .20 in. (5 mm) up from the bottom of the piston, at right angles to the piston pin.

#### d. Piston Clearance

If the piston is replaced, piston clearance of the new piston must be measured. See page 17 .

#### e. Connecting Rod Small End Play

Insert the piston pin and the needle bearing into the small end of the connecting rod, and measure the play with a dial gauge. If play exceeds the service limit, replace the needle bearing and piston pin.

Standard play: .00012-.00088 in.  
(0.003-0.022 mm)

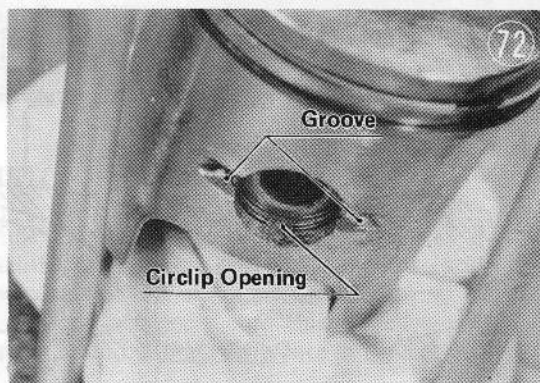
Service limit: .0039 in. (0.10 mm)

### 3) Assembly

This is the reverse of disassembly.

#### CAUTION:

1. Insert the piston so that the arrow stamped on the top points to the exhaust side.
2. Use a new piston pin circlip in place of the one removed during disassembly. Align the circlip so that its opening does not face either groove in the piston.

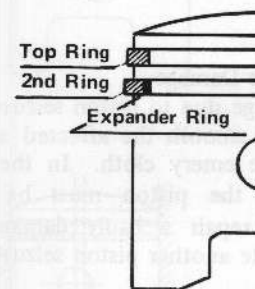


### 4. PISTON RINGS

There are two piston rings, the main function of which is to prevent compression leakage. The top ring, also called the compression ring, has chamfered outer edges, while the second ring is un-chamfered. The top ring can also be easily identified by its chromed outer edge, designed to minimize wear at high temperatures.

In the H Series, an expander ring is installed in the second ring groove between the ring and the piston. The elasticity of this octagonal expander ring helps check piston slap.

#### Ring Position



#### Expander Ring

