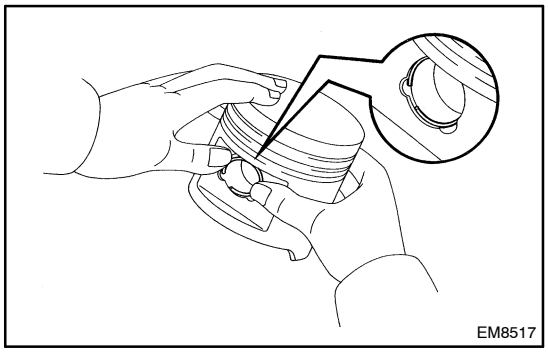
EM1LV–01

REASSEMBLY

HINT:

- Thoroughly clean all parts to be assembled.
- Before installing the parts, apply fresh engine oil to all sliding and rotating surfaces.
- Replace all gaskets, O–rings and oil seals with new parts.

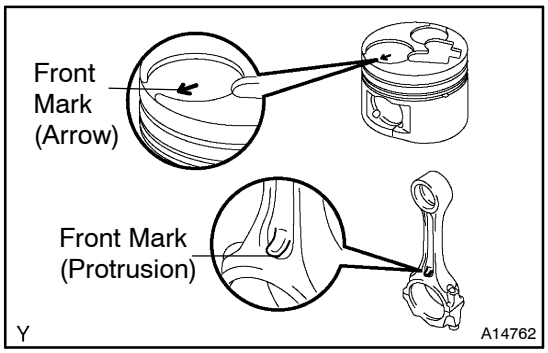


1. ASSEMBLE PISTON AND CONNECTING ROD

(a) Install a new snap ring on one side of the piston pin hole.

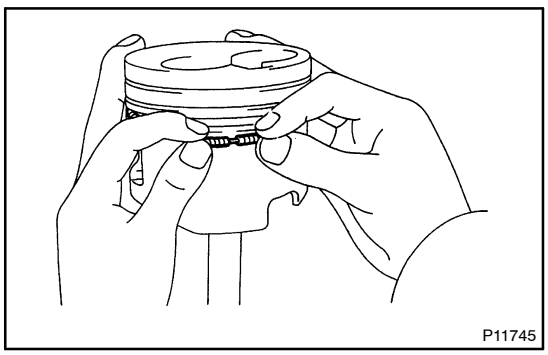
(b) Gradually heat the piston to 80°C (176°F).

(c) Coat the piston pin with engine oil.



(d) Align the front marks of the piston and connecting rod, and push in the piston pin with your thumb.

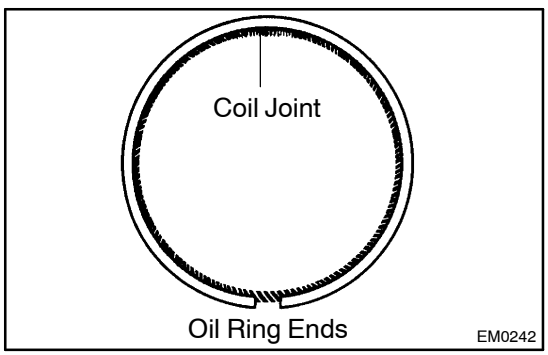
(e) Install a new snap ring on the other side of the piston pin hole.



2. INSTALL PISTON RINGS

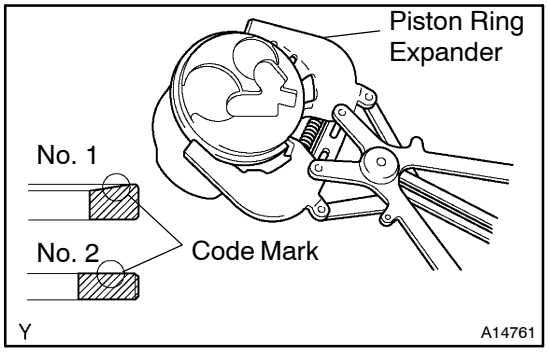
(a) Install the coil by hand.

(b) Install a piston ring expander, install the oil ring.



HINT:

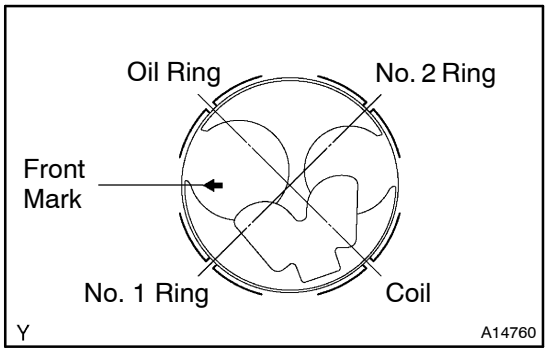
Face the end gap of the oil ring in the opposite direction of coil joint.



(c) Using a piston ring expander, install the 2 compression rings with the code mark facing upward.

Code mark:

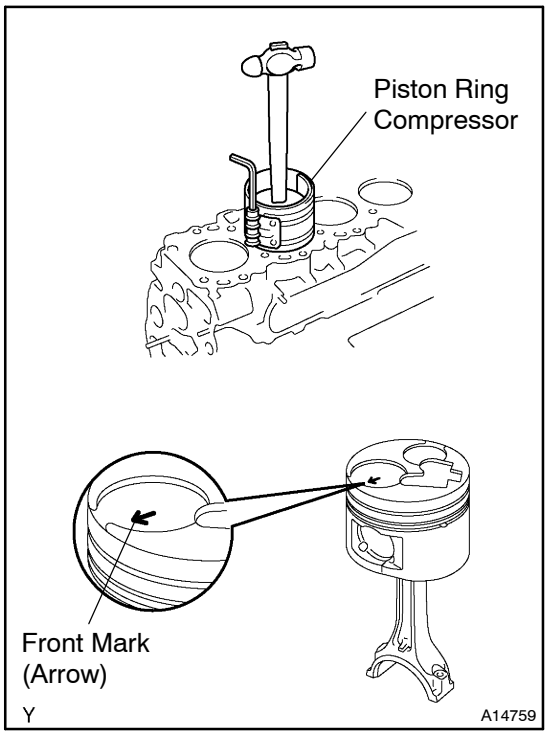
No. 1	1N
No. 2	2N



(d) Position the piston rings so that the ring ends are as shown.

NOTICE:

Do not align the ring ends.



3. INSTALL PISTON AND CONNECTING ROD ASSEMBLIES

Using a piston ring compressor, push the correctly numbered piston and connecting rod assemblies into each cylinder with the front mark of the piston facing forward.