

Component Procedures: Piston Ring

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Component Procedures: Piston Ring

Parts and Labor (itype_189)

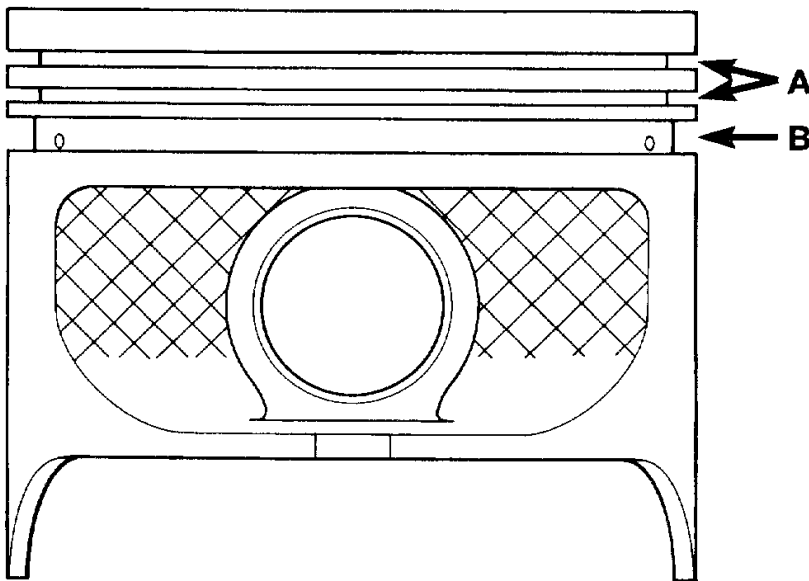
Parts

Qualifier	Part #	Name	Price	Note
Piston Rings	4798324	22 - Piston Ring Set	0.00	Includes: Standard Ring Se?

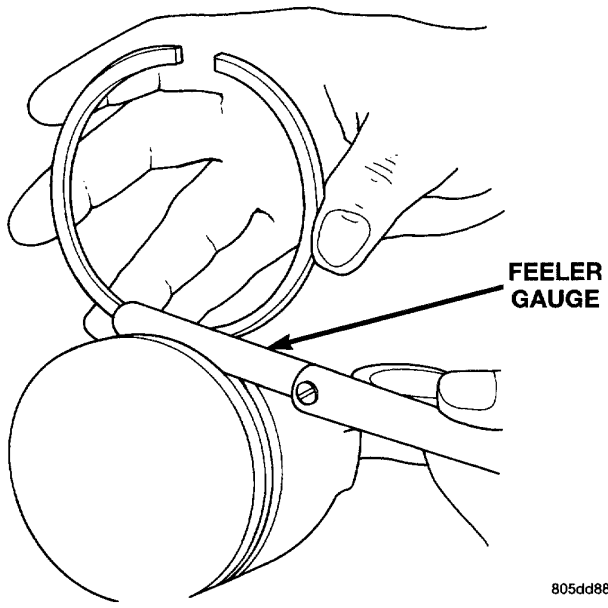
Labor

Operation	Qualifier Path	Skill	Std Hrs	Wty Hrs
Replace	All Cylinders	A	9.9	5.2
Replace	All Cylinders > NOTE > To Clean Oil Pump Scre?	A	0.2	0.0
Replace	All Cylinders > NOTE > To Grind Valves, Add	A	3.0	2.2
Replace	All Cylinders > NOTE > To R&R Connecting Rod ?	A	0.1	0.0
Replace	All Cylinders > NOTE > To R&R Oil Pump, Add	A	0.4	0.0
Replace	All Cylinders > NOTE > To R&R Piston, Pin Or ?	A	0.2	0.0
Replace	All Cylinders > NOTE > To R&R Piston, Pin Or ?	A	0.1	0.0
Replace	All Cylinders > NOTE > To R&R Piston, Pin Or ?	A	0.5	0.0
Replace	All Cylinders > NOTE > To R&R Spark Plugs, Add	A	0.5	0.0
Replace	All Cylinders > NOTE > To R&R Timing Chain, A?	A	1.1	0.0
Replace	One Cylinder	A	6.6	4.5
Replace	One Cylinder > NOTE > To Clean Oil Pump Scree?	A	0.2	0.0
Replace	One Cylinder > NOTE > To Grind Valves, Add	A	3.0	2.2
Replace	One Cylinder > NOTE > To R&R Connecting Rod B?	A	0.1	0.0
Replace	One Cylinder > NOTE > To R&R Oil Pump, Add	A	0.4	0.0
Replace	One Cylinder > NOTE > To R&R Piston, Pin Or C?	A	0.2	0.0
Replace	One Cylinder > NOTE > To R&R Piston, Pin Or C?	A	0.1	0.0
Replace	One Cylinder > NOTE > To R&R Piston, Pin Or C?	A	0.5	0.0
Replace	One Cylinder > NOTE > To R&R Spark Plugs, Add	A	0.5	0.0
Replace	One Cylinder > NOTE > To R&R Timing Chain, Add	A	1.1	0.0

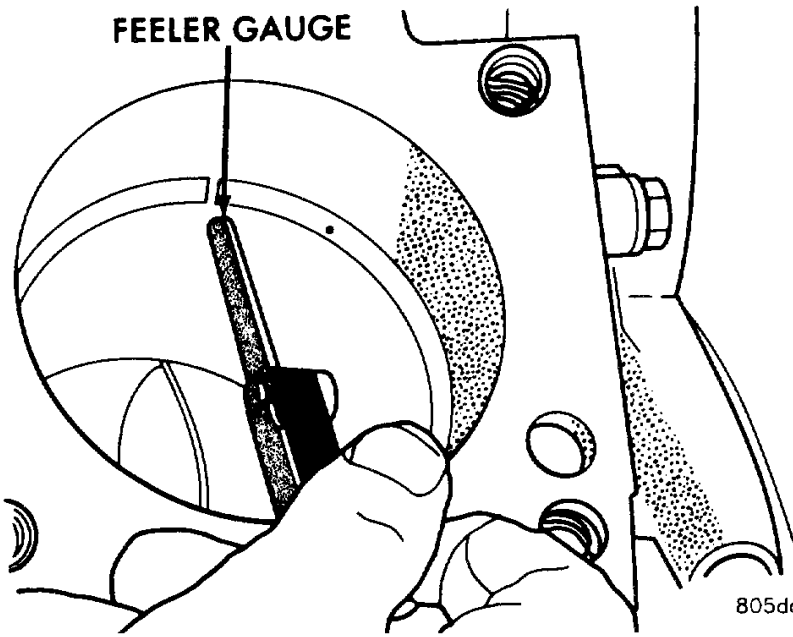
Fitting Piston Rings (Article 2071423)



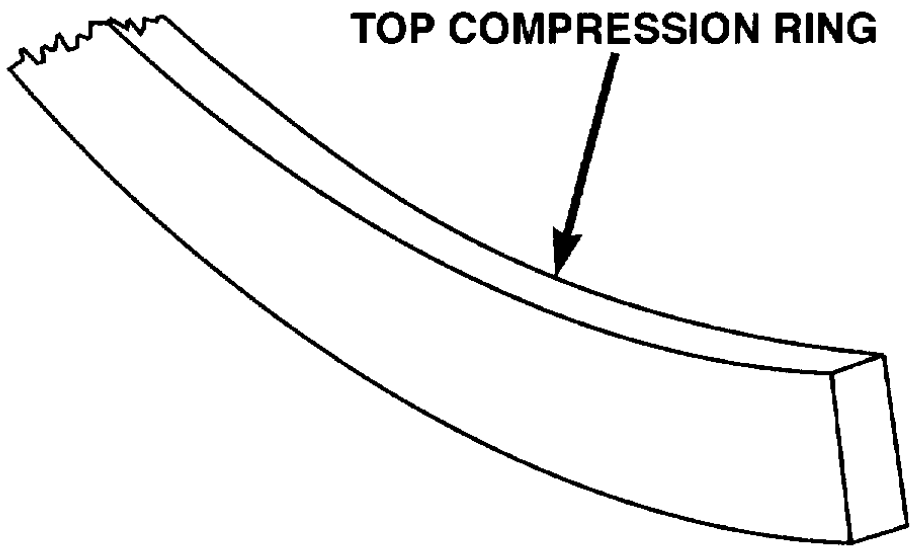
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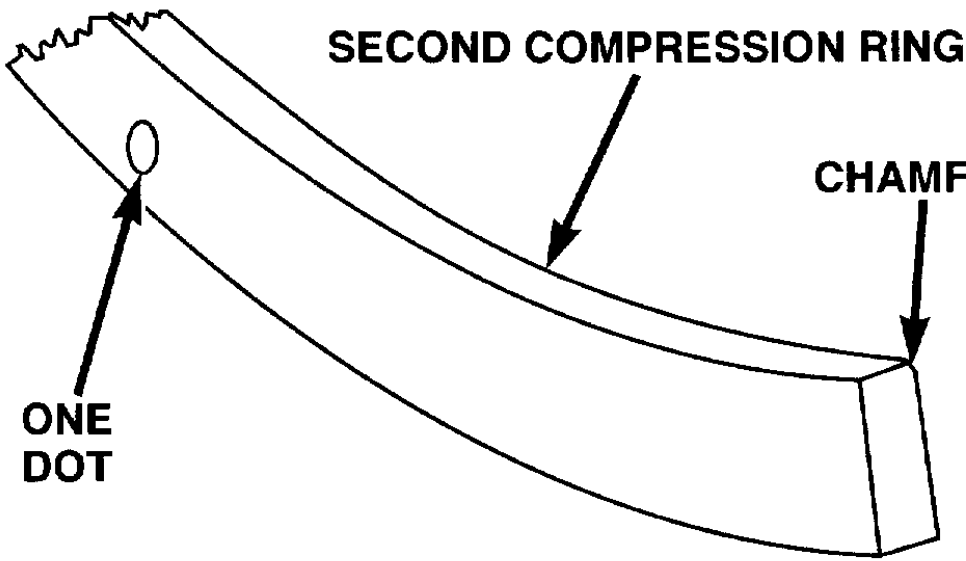


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TOP COMPRESSION RING

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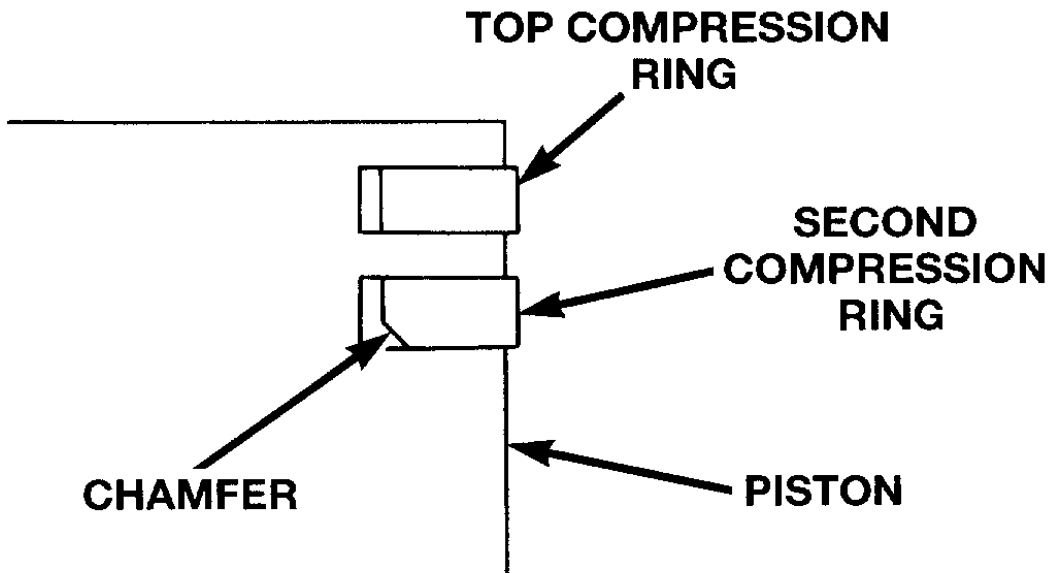


SECOND COMPRESSION RING

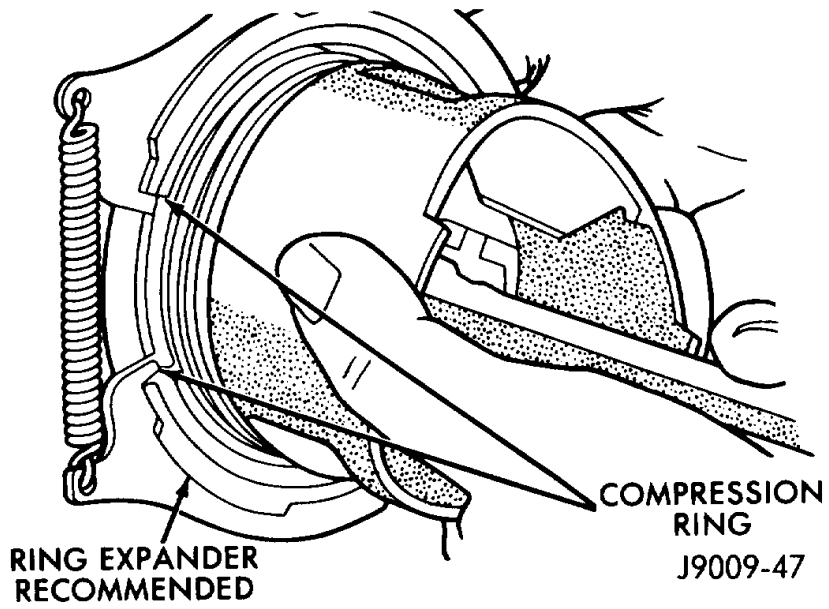
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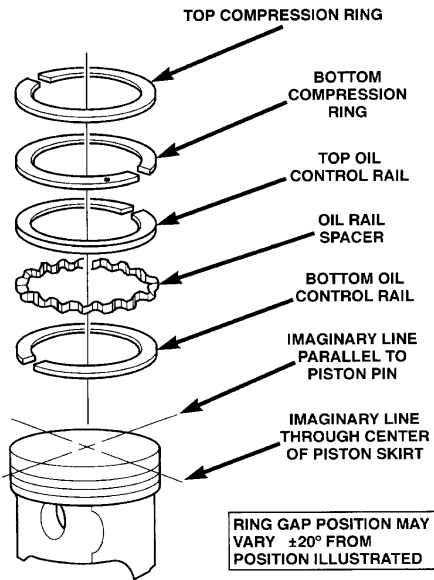
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Piston Ring Gap and Groove Clearances (Article 2071932)

Ring Gap Clearance

Top Compression Ring 0.229 to 0.610 mm (0.0090 to 0.0240 in.)

2nd Compression Ring 0.483 to 0.965 mm (0.0190 to 0.0380 in.)

Oil Control Steel Rails 0.254 to 1.500 mm (0.010 to 0.060 in.)

Ring Side Clearance

Compression Rings 0.042 to 0.084 mm (0.0017 to 0.0033 in.)

Oil Control Ring 0.06 to 0.21 mm (0.0024 to 0.0083 in.)

Piston Ring

Groove Height

Compression Rings 1.540 to 1.555 mm (0.0602 to 0.0612 in.)

Oil Control Ring 4.035 to 4.060 mm (0.1589 to 0.1598 in.)

Piston

Ring Groove Diameter

Compression Ring 87.78 to 87.90 mm (3.456 to 3.461 in.)

Oil Control Ring 87.50 to 87.75 mm (3.445 to 3.455 in.)