

# THE VOC SPARES COMPANY LTD.

Unit 3a, Robinson Way, Telford Way Ind. Est.  
KETTERING, NN16 8PT  
Phone - 01536 312220  
Fax - 01536 312225



## Piston and Ring Fitting Instructions

Please take care when removing and re-fitting ring as they are fragile and can break.

If the gudgeon (wrist) pin is difficult to remove warm the piston in hot water.

Clearance for cylinder boring measured at the base of the piston skirt.

2.5 to 3 thou' (0.064-0.076mm).

On a new bore the ring should be fitted in the order.

Top (plain)  Second (lipped)  Oil control

If new rings are being fitted to a used cylinder the top and second ring should swapped and the lipped ring inverted.

Top (lipped)  Second(plain)  Oil control

Ring gap, measured in an unworn section of the cylinder,  
16 to 20 thou' (0.4-0.5mm) for the top and lip rings  
10 to 20 thou' (0.25-0.5mm) for the oil control ring.

Ring gaps can be adjusted with fine file keeping the ends of the ring square.

