



PERFORMANCE ASSEMBLY SOLUTIONS

OBSOLETE

Work Instruction

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Operation Number: 35 Description: Piston Sub-Assembly	Prepared By: Quality Approved by: Manufacturing
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Title: Piston Sub-Assembly	

PISTON SUB-ASSEMBLY



1. Inspect all components for damage. Dents, bends, scratches, etc. Check for proper machining of relief features, ring grooves, skirts, twist-clip channels, etc. Check to ensure that the piston has both relief pockets, and are properly machined.
2. With black permanent marker, place an arrow on the piston head facing the intake side of the head (as an orientation indicator).
3. Ensure that the wrist pin is present.



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4. Install the Piston Rings using the directions provided by the manufacturer. Directions are included in each K&B Performance Piston Kit. Ensure that the “dot” on the second ring is facing the deck of the piston.

5. Check to ensure that the piston rings are gapped 60 degrees apart and rotate freely without interference.

6. Place completed sub-assemblies back in the original box, initial and date the box, and place the full box on the appropriate component rack.

MAPICS #	INDIAN PART #	QTY/DESCRIPTION
540011	01-167	PISTON ASSEMBLY KIT
<i>PIA KIT</i>	<i>PIA KIT</i>	(1)Piston
<i>PIA KIT</i>	<i>PIA KIT</i>	(1)Wrist Pin
<i>PIA KIT</i>	<i>PIA KIT</i>	(1)Top Compression Ring
<i>PIA KIT</i>	<i>PIA KIT</i>	(1)Bottom Compression Ring
<i>PIA KIT</i>	<i>PIA KIT</i>	(2)Oil Ring(s)
<i>PIA KIT</i>	<i>PIA KIT</i>	(1)Oil Ring Spacer