

Description of Operation

- A Confirm run number and proper grade piston selections.
- Clean pistons with degreasing solvent followed by air dry and wipe with lint-free cloth.
- Clean rods by soaking in degreasing solvent for two hours followed by spray with 50/50 EF411 and degreasing solvent.
- When re-using OHT3F-014-1, clean in ultrasound bath per 9.5 of test method, clean with mylar tape Q135 Metalite 3µ 1½ wide roll. Do not re-use if diameter does not meet 21.9950 –22.0000 mm
- B Lubricate piston pin and connecting rod with EF-411. Install one piston pin retainer clip into the retaining groove. Install the con rod and piston pin. (Note: dimple on con rod is for manufacturing only) Install the second retainer clip. Make sure both retainer clips are properly seated in their grooves.

Specification

1	OHT3F-053-1	Grade 12 test piston s
2	OHT3F-054-1	Grade 34 test piston s
3	OHT3F-055-1	Grade 56 test piston s
4	OHT3F-014-1	Piston pin set
5	OHT3F-012-1	Retainer clip set
6	12593374	Rod Powdered Metal

View

Piston, Pin and Connecting Rod

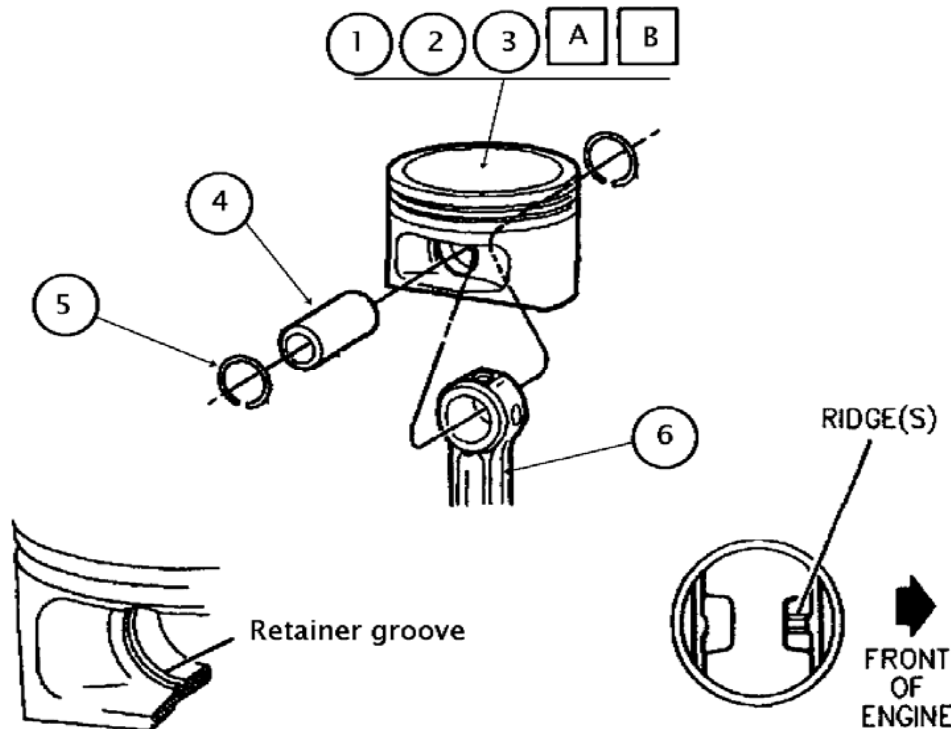
Piston pin and Connecting Rod assembly

Section

3

Sheet

7



REV	Date	Revision History
2	11/03/04	Add part numbers for "Cast" and "Powdered Metal" Rods See "6"
3	01/31/06	Removed Cast Rod information
4	06/22/06	Update piston and rod cleaning procedure and assembly note on dimple
5	07/01/11	Updated Connecting Rod part number and renumbered as sheet 8
6	06/02/16	Added cleaning requirements when re-using Piston Pins
Short Block Assembly		Sequence III F