

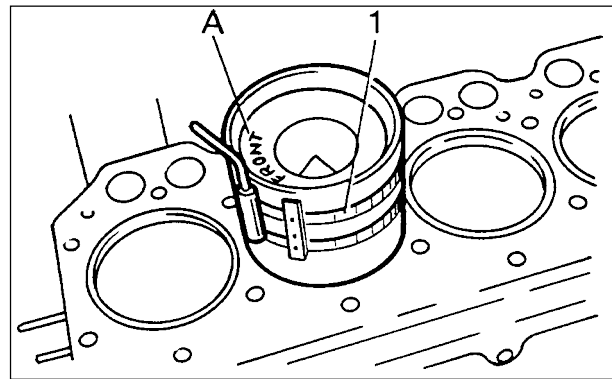
Disassembly - Assembly

• Reassembling pistons and connecting rods

Note: the pistons must be reassembled in the liners they were extracted from.

- 1 - Smear the pistons and rings with clean engine oil. Fit the pistons into the liners using the ring compressor No. 8111 (1).

Note: Check for each piston that the mark "FRONT" (A) on the upper face of the piston is turned towards the front of the cylinder block.



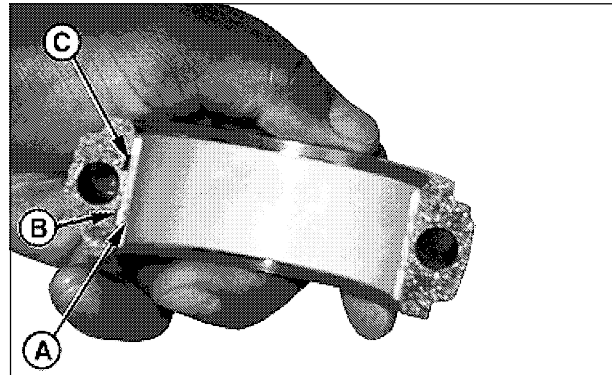
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- 2 - Push the piston into the liner until the upper ring is fully inside it.

• Assembling the cap onto the connecting rod

- 1 - Smear the half-bearings with clean engine oil, then assemble the cap onto the connecting rod with the pins (A) on the same side. The notch (C) is not used.

IMPORTANT: Ensure that the cap is correctly aligned on the connecting rod with the junction surfaces perfectly coupled.



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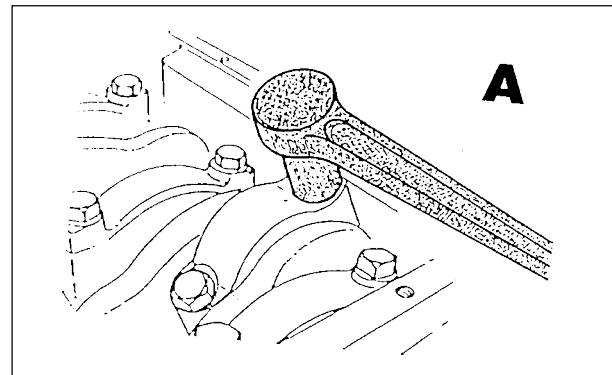
- 2 - Dip the connecting rod bolts in clean engine oil and fit them.

IMPORTANT: Never use the connecting rod bolts more than once for the final assembly of the engine. When connecting rod bolts have been tightened at final torque, do not reuse them.

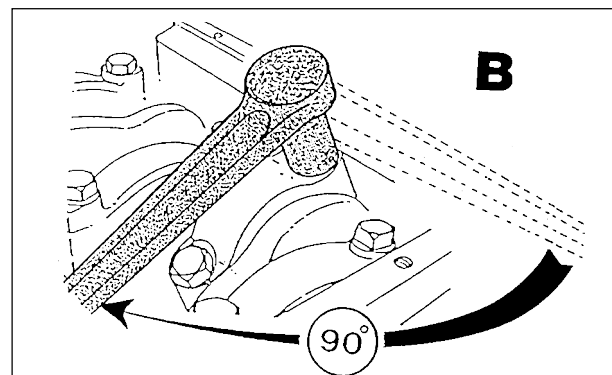
- 3 - Tighten the bolts alternatively at 5.8 daN.m, then turn each bolt at a 90-100 degree angle.

• Tightening method

- 1 - Position the wrench in parallel the engine axis (A).
- 2 - Tighten the bolt until the wrench is perpendicular to the engine axis (B).



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