

Determine correct position of connecting rod relative to notch or arrow (1) on piston, Fig. 10.

Oil the piston pin.

Insert piston pin from side opposite shoulder or installed lock until pin stops against lock or shoulder.

Install piston pin lock in groove at other end of piston pin.

Be sure both lock(s) are firmly set in groove(s).

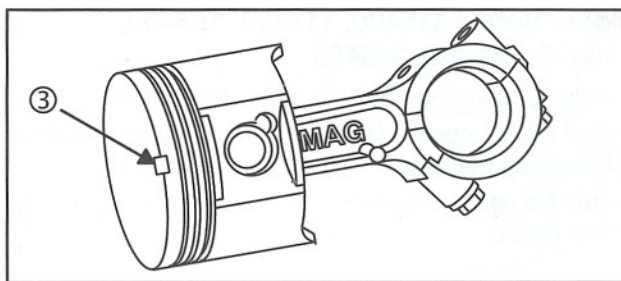


Fig. 10

**NOTE:** Some rods have the word "MAG" cast in the rod on the flywheel side.

### Install Piston Rings

**Model Series 110400, 110600, 111400, 111600, 113400, 120400, 120600, 121400, 121600, 122600, 123400, 123600, 204400, 205400**

Correct piston ring positions are shown in Fig. 11.

Install the oil control ring (3) and expander (4) first, followed by the center ring (2) and top ring (1).

Install the center ring and top ring with the ID mark pointing the top of the piston (arrows).

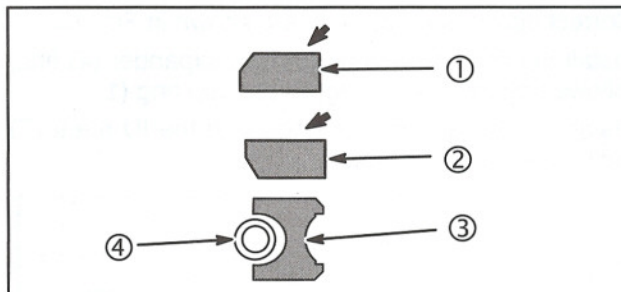


Fig. 11

### Model Series 85400

Correct piston ring positions are shown in Fig. 12.

Install the oil control rings (3) and expander (4) first, followed by the center ring (2) and top ring (1).

Install the center ring and top ring with the ID marks (X) pointing the top of the piston.

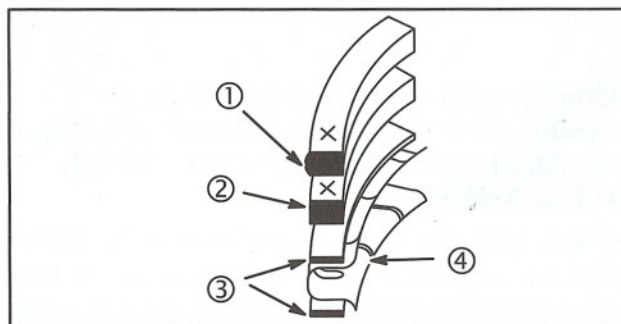


Fig. 12

**NOTE:** The top ring (1) is plated. The center ring (2) is phosphate coated (black).

### Model Series 97700, 99700, 104700

Correct piston ring positions are shown in Fig. 13.

Install the oil control rings (3) and expander (4) first, followed by the center ring (2) and top ring (1).

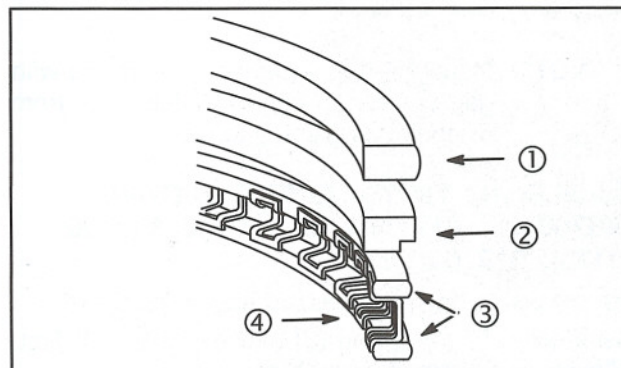


Fig. 13

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