

**Model Series 115400, 117400, 185400,
186400, 235400, 245400**

Correct piston ring positions are shown in Fig. 14.
Install the oil control rings (3) and expander (4) first,
followed by the center ring (2) and top ring (1).
Install the center ring with the ID mark (X) facing the top
of the piston.

NOTE: The top ring (1) is barrel faced and plated.

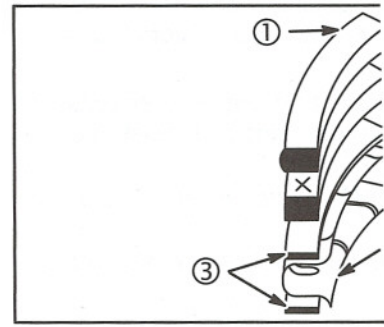


Fig. 14

Model Series 161400

Correct piston ring positions are shown in Fig. 15.
Install the oil control rings (3) and expander (4) first,
followed by the center ring (2) and top ring (1).
Install the top and center rings with the ID mark (T)
facing the top of the piston.

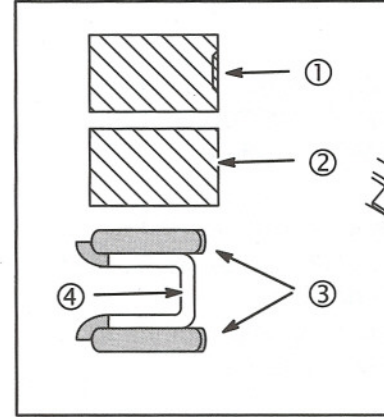


Fig. 15

**Model Series 21A800, 21B800, 284H00,
285H00, 286H00, 28AH00, 28BH00, 28CH00,
31E700, 31F700, 31G700, 31J700, 31K700,
31L700, 31M700**

Correct piston ring positions are shown in Fig. 16.
Install the oil control ring (3) and expander (4) first,
followed by the center ring (2) and top ring (1).
Install the top ring with the ID mark facing the top of the
piston.

NOTE: Install oil ring expander coil spring with
gap positioned approximately 180° from
oil control ring end gap.

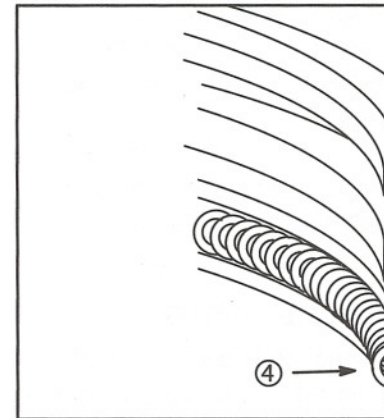


Fig. 16

**Model Series 28N700, 28P700, 28Q700,
28S700, 28U700, 28W700, 287700, 310700,
311700, 312700, 313700**

Correct piston ring positions are shown in Fig. 16.
Install the oil control ring (3) and expander (4) first,
followed by the center ring (2) and top ring (1).

NOTE: Install oil ring expander coil spring with
gap positioned approximately 180° from
oil control ring end gap.

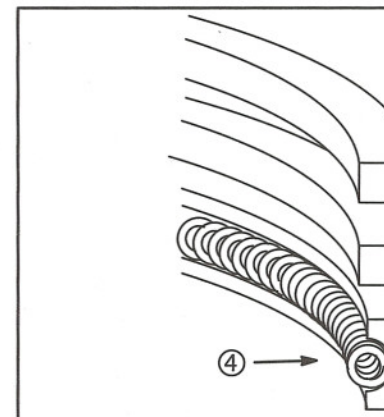


Fig. 17