




G2

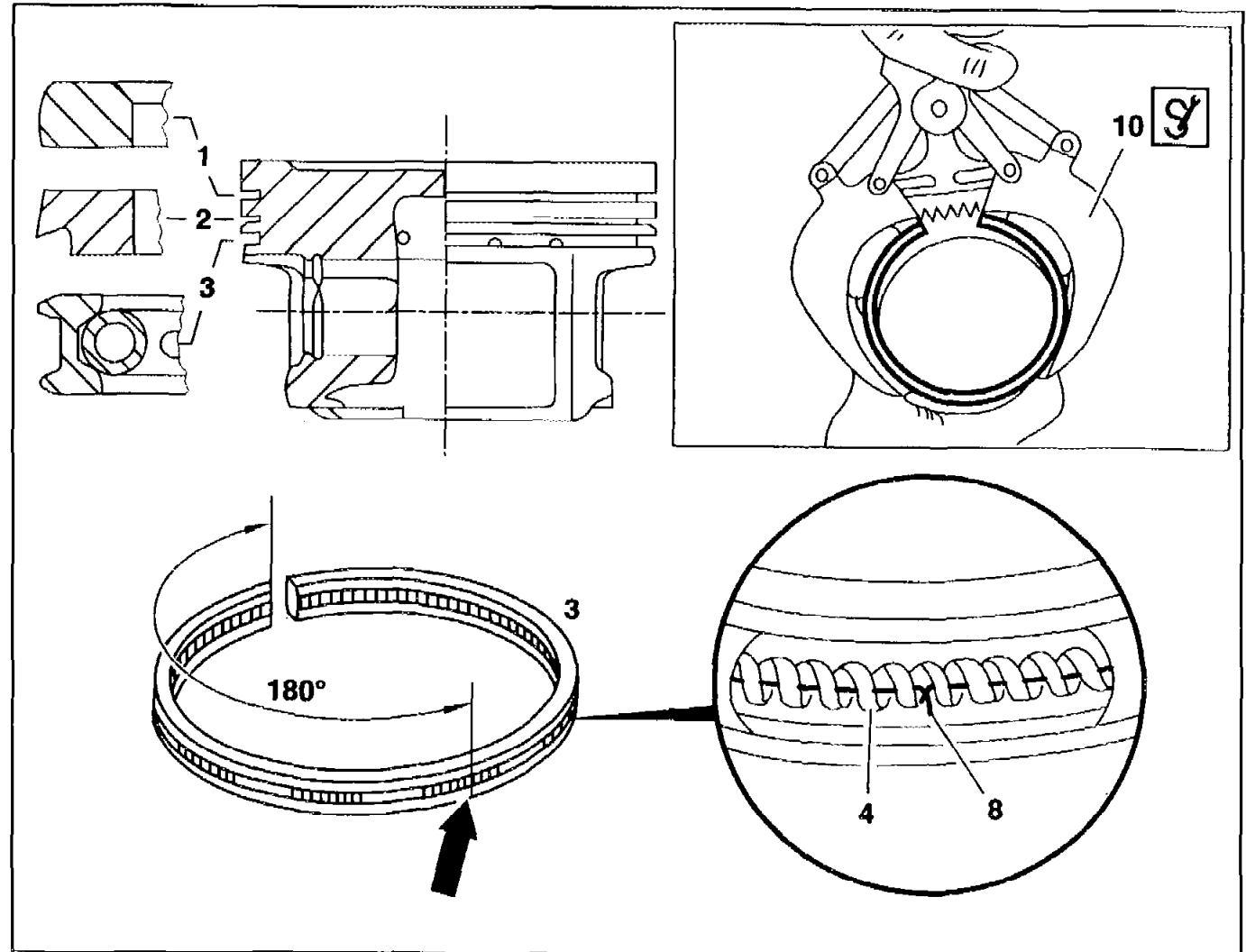
AR03.10-P-7311HA

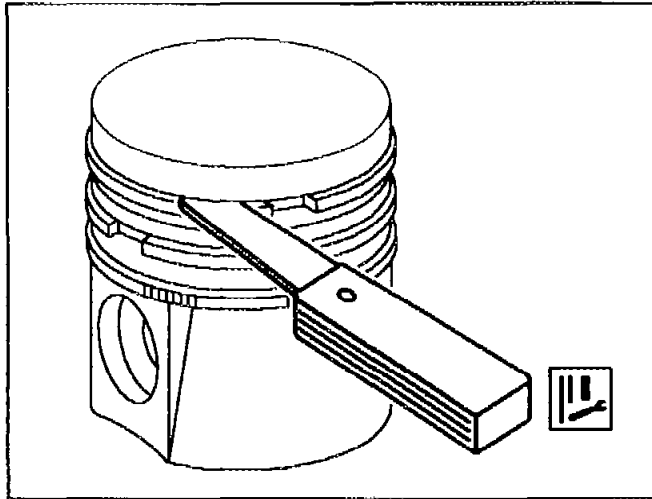
Removing and installing piston rings

13.1.98

ENGINE 604, 605, 606

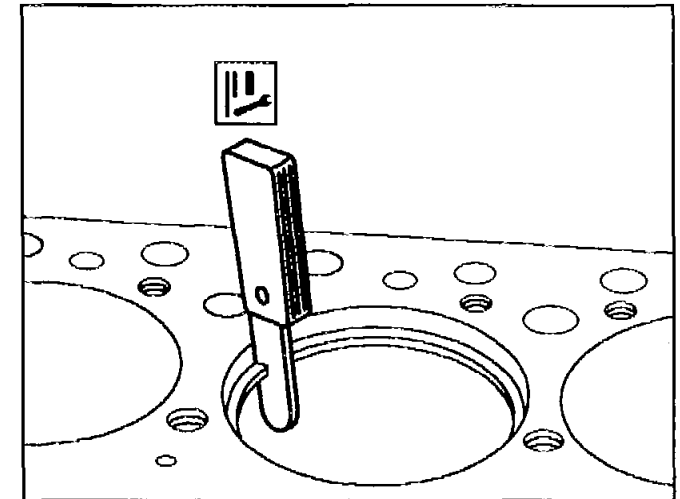
- 1 Plain compression ring
- 2 Taper-faced hook scraper ring
- 3 Double beveled oil control ring
- 4 Coil spring
- 8 Hooked spring
- 10  Pliers





Measuring end clearance

S03.10-3005-01



Measuring gap clearance

S03.10-3006-01

Fig. item, etc.	Work instructions		
	Pistons	remove	AR03.10-P-7021B 01
1, 2, 3	Piston rings	remove ⓘ Installation: pay attention to installation position! Top or manufacturer's designation points toward piston crown. Insert hooked spring with oil scraper ring offset 180° to gap (arrow). Install piston rings (1, 2, 3) with the piston ring gaps offset 120°.	000 589 51 37 00 BE03.10-P-1003-02B



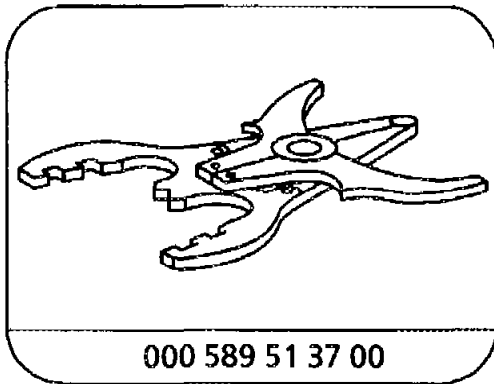
End clearance of piston ring



		Gap clearance of piston ring 	BE03.10-P-1004-02B WH58.30-Z-1008-12A
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Test data of pistons

Number	Designation		Engine 604.915/917	Engine 605.91/96	Engine 606.91/96
BE03.10-P-1003-02B	End clearance of piston ring	groove 1 mm	≤ 0.20	≤ 0.20	≤ 0.20
		groove 2 mm	≤ 0.15	≤ 0.15	≤ 0.15
		groove 3 mm	≤ 0.10	≤ 0.10	≤ 0.10
BE03.10-P-1004-02B	Gap clearance of piston ring	groove 1 mm	≤ 1.0	≤ 1.0	≤ 1.0
		groove 2 mm	≤ 1.0	≤ 1.0	≤ 1.0
		groove 3 mm	≤ 1.0	≤ 1.0	≤ 1.0



Pliers

Commercially available tools (see Workshop Equipment Manual)

Number	Designation	Make (e.g.)	Order number
WH58.30-Z-1008-12A	Feeler gage	Stiefelmayer D-73734 Esslingen	59