

Piston Fitting

Meets NATEF Task: (A1-C-11) Determine piston-to-bore clearance.
(P-2)

Name _____ Date _____ Time on Task _____

Make/Model/Year _____ VIN _____ Evaluation: 4 3 2 1

_____ 1. Check service information for the specified piston-to-cylinder wall clearance.

_____ 2. With a micrometer, measure the piston skirt diameter.

Specification = _____

Actual = Piston #1 _____ Piston #5 _____

Piston #2 _____ Piston #6 _____

Piston #3 _____ Piston #7 _____

Piston #4 _____ Piston #8 _____



(Hint: Label the size on the pistons using a marker for identification.)

_____ 3. With a telescoping gauge and micrometer measure the smallest diameter of the cylinder.

Cylinder #1 _____ Cylinder #5 _____

Cylinder #2 _____ Cylinder #6 _____

Cylinder #3 _____ Cylinder #7 _____

Cylinder #4 _____ Cylinder #8 _____



_____ 4. Select the largest diameter piston and, using a thickness gauge, fit the piston to the largest diameter cylinder. Continue selecting pistons and fit each to the cylinder that results in the best fit with the correct clearance (usually between 0.001 and 0.003 in).

_____ 5. Match the cylinder number on the top of the selected piston for each cylinder.

Cylinder #1 uses piston # _____ Cylinder #5 uses piston # _____

Cylinder #2 uses piston # _____ Cylinder #6 uses piston # _____

Cylinder #3 uses piston # _____ Cylinder #7 uses piston # _____

Cylinder #4 uses piston # _____ Cylinder #8 uses piston # _____