

**Piston ring end gap****Top ring****End gap (installed)**

0.19–0.31 mm (0.0075–0.0122 in)

Limit

0.56 mm (0.0220 in)

2nd ring**End gap (installed)**

0.30–0.45 mm (0.0118–0.0177 in)

Limit

0.80 mm (0.0315 in)

Oil ring**End gap (installed)**

0.10–0.35 mm (0.0039–0.0138 in)

EACH STEP

CHECKING THE PISTON PIN**1. Check:**

- Piston pin

Blue discoloration/grooves → Replace the piston pin and then check the lubrication system.

2. Measure:

- Piston pin outside diameter "a"

Out of specification → Replace the piston pin.

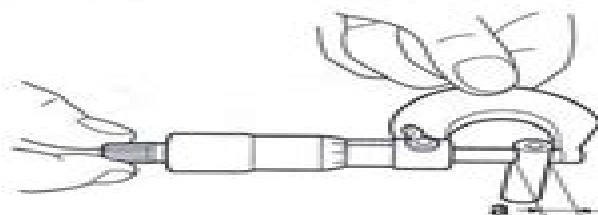
**Piston pin outside diameter**

16.991–17.000 mm

(0.6689–0.6693 in)

Limit

16.970 mm (0.6681 in)

**3. Measure:**

- Piston pin bore diameter "b"

Out of specification → Replace the piston.

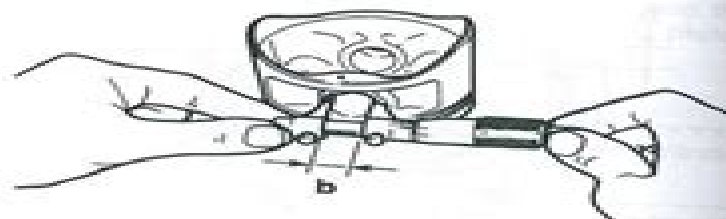
**Piston pin bore inside diameter**

17.002–17.013 mm

(0.6694–0.6698 in)

Limit

17.043 mm (0.6710 in)

**4. Calculate:**

- Piston-pin-to-piston-pin-bore clearance
Out of specification → Replace the piston pin and piston as a set.

- Piston-pin-to-piston-pin-bore clearance =
Piston pin bore diameter "b" -
Piston pin outside diameter "a"

**Piston-pin-to-piston-pin-bore clearance**

0.002–0.022 mm (0.0001–0.0009 in)

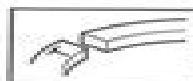
EACH STEP

INSTALLING THE PISTON AND CYLINDER**1. Install:**

- Top ring "1"
- 2nd ring "2"
- Lower oil ring rail "3"
- Upper oil ring rail "4"
- Oil ring expander "5"

TIP

Be sure to install the top ring and 2nd ring so that the manufacturer's marks or numbers face up.

**2. Install:**

- Piston "1"
- Piston pin "2"
- Piston pin clips "3" **New**

TIP

- Apply engine oil to the piston pin.
- Make sure the mark "a" on the piston points to-

Manual Fr Sportsman Polaris 2002

Ying Liu



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