



INSTRUCTIONS

-J00700

REV. 8-18-98

Kit Numbers 22528-86RA and 22529-86RA

XR-750 PISTON RING SET

General

This instruction sheet covers the following standard and oversize XR-750 Piston Ring Sets:

PISTON RING SET PART NO.	PISTON RING SIZE
22528-86RA	Standard
22529-86RA	+0.010 in.
22530-86RA	+0.020 in.

Each Piston Ring Set contains the following components:

QTY	DESCRIPTION
1	Piston ring expander/spacer, oil control
2	Piston ring rail, oil control
1	Piston ring, second compression
1	Piston ring, top compression

Installation

CAUTION

Install piston rings so that end gaps of adjacent rings are staggered a minimum of 90° from each other. Ring end gaps must not be within 10° of the piston thrust face centerline.

OIL CONTROL RING

1. Install expander/spacer in oil control ring groove of piston.

End gaps of each ring rail must be staggered from end gap of expander/spacer.

CAUTION

Ends of expander/spacer should butt together in piston groove; they must not overlap. Do not cut off the ends of expander/spacer.

2. Hold expander/spacer so that its ends butt together in ring groove of piston. Install a ring rail in oil control ring groove so that ring rail is positioned against lower side of expander/spacer. End gap of this lower ring rail should be positioned approximately 90° (staggered) to right of expander/spacer end gap.
3. Install second ring rail in oil control ring groove so that this ring rail is positioned against upper side of expander/spacer. End gap of this upper ring rail should be positioned approximately 90° (staggered) to left of expander/spacer end gap.

SECOND COMPRESSION RING

1. Check end gap of second compression ring with the ring installed in its respective cylinder. Ring end gap must be a minimum of 0.012.
2. Install second compression ring in middle ring groove of piston. This ring is of the tapered twist design. "TOP" marking of ring must face upward; inside bevel of ring must be positioned downward.

TOP COMPRESSION RING

1. Check end gap of top compression ring with the ring installed in its respective cylinder. Ring end gap must be a minimum of 0.012 in.
2. Install top compression ring in top ring groove of piston. Since this ring has a symmetrical barrel (curved) face, allowing it to be installed with either side up, you will not find any markings on it which indicate top or bottom side.