



HEPLEX LOW EXPANSION SILICON ALLOY PISTONS

FITTING INSTRUCTIONS

These pistons are ready for immediate assembly in the engine, the correct allowance having been made at the piston ring joints to allow for expansion under working conditions. The gudgeon pins have been selectively assembled to each piston to ensure the correct fit, and are not interchangeable.

It is recommended that the pistons be washed off in clean paraffin to ensure clean assembly.

Piston Clearances

The cylinder bores should always be opened out to the nominal size (as shown in the Hepolite Catalogue) plus the required oversize. The tolerance on this size should be minus .0000" and plus .0005". When the bores are finished to these limits, the piston skirts will have the correct working clearances. Generally clearances will be as follows, but in some cases special clearances have been developed to suit particular engines.

	Type of Piston	Skirt Clearance (per inch of cyl. diam.)	
		Open end	Land end
Water-cooled engines	Split skirt0006"
	T-slot		
	I-slot00125"
	Solid (up to 3½" bore) skirt (over 3½" bore)		
Air-cooled engines	Solid skirt0015"
	T-Slot00225"
	Thermal slot0015"

Piston Rings

The gaps when in a cylinder of correct size will not be less than the following:—

Air-cooled racing engines005" per inch of bore
All other engines003" " " " "
Air compressors and refrigerators001" " " " "

Gudgeon Pins

To remove the gudgeon pins first heat the piston in hot water or oil, to avoid damage to the piston or pin.

Where pins are clamped in the conn-rod, check to see that the piston is still free on the pin after tightening the clamp screw. Overtightening can result in a distorted pin.

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