



No.: 06 TS - 24  
September 15, 2006

TO: Service Locations  
FROM: Service Support  
SUBJECT: **Series 60® Piston Ring Identification**

**ISSUE**

Identification of the piston rings and installation position on the pistons on Series 60 engines

**CAUSE**

Improper piston ring installation

**REPAIR PROCEDURE**

1. Install the oil expander then install the oil control ring. Ensure that the expander spring gap is located 180° from the oil control ring gap. There is a white paint mark on the expander (see figure 1), make sure that it is visible at the ring gap.

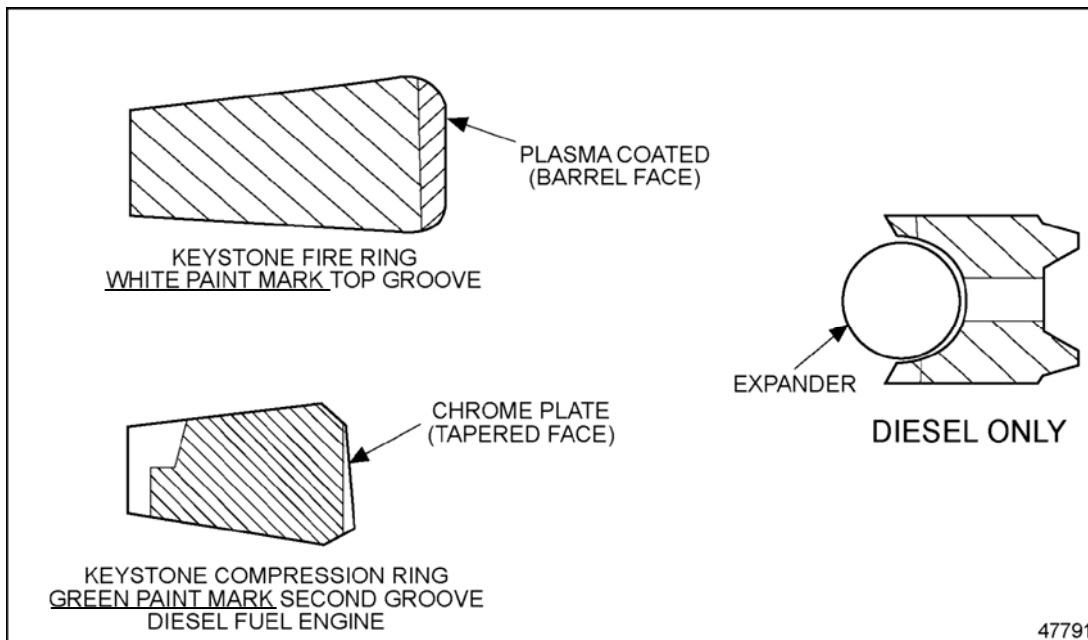


Figure 1

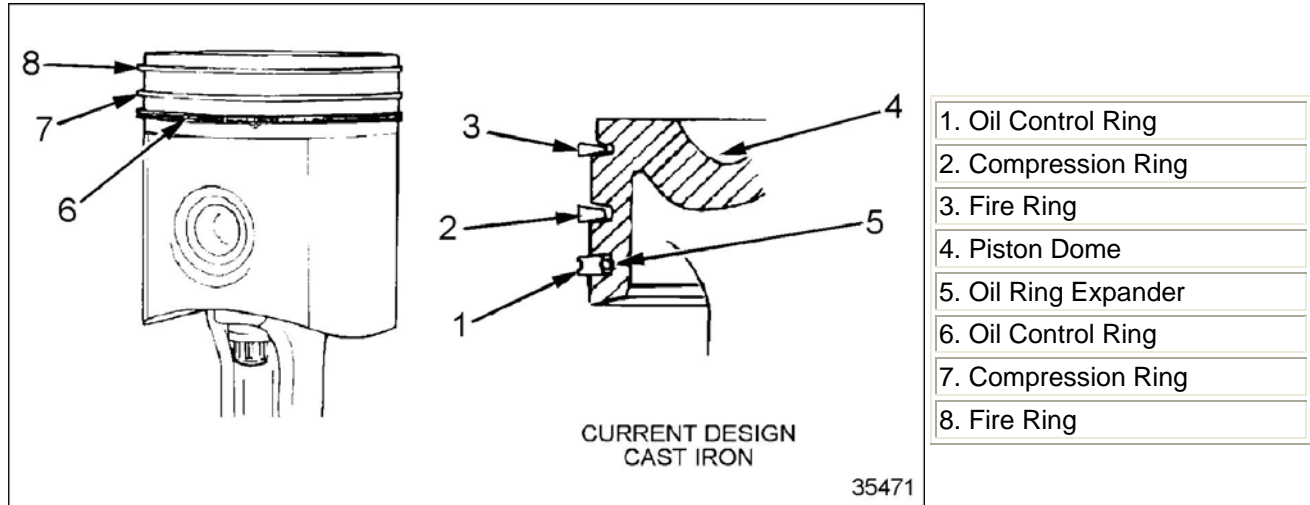


Figure 2

2. Install the compression ring into the second groove (see figure 2). The compression ring has a green paint on the outer edge (see figure 1). Make sure the identifying dimple on the ring is installed up, toward the dome of the piston. To aid installing the rings use tool #J-22405-02 or equivalent (see figure 3).
3. Install the fire ring into the top groove (see figure 2). It has a white paint mark on the outer edge. Make sure the identifying dimple on the rings is installed up, toward the dome of the piston. To aid installing the rings use tool #J-22405-02 or equivalent.
4. Stagger the ring gaps around the piston before installing the piston in the liner (see figure 3).

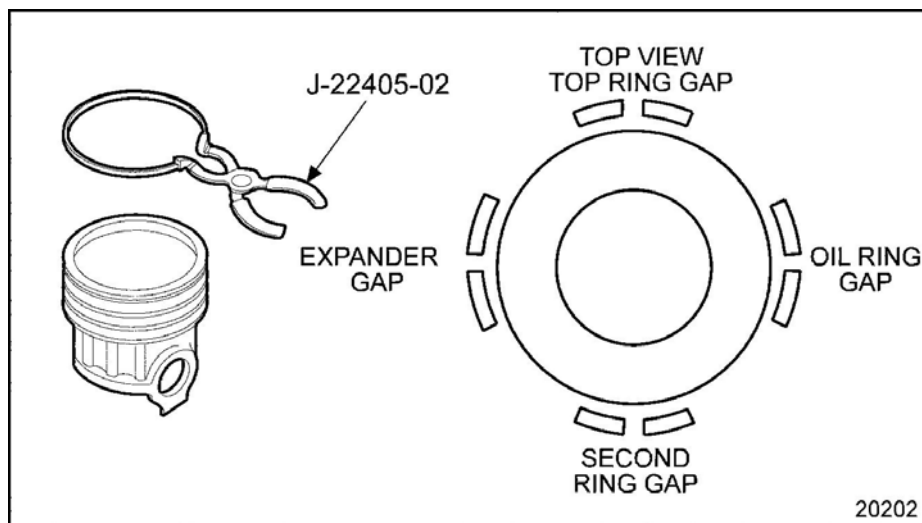


Figure 3

### CONTACT INFORMATION

Please contact the DDC Customer Support Center at 313-592-5800 if you have any questions.