

Duramax Forged Piston & Ring Installation Guide

- 1) We recommend honing the block with 280-320 grit stones preferably using torque plates.**
- 2) Piston to cylinder wall clearance should be set at .0060”.
- 3) We recommend a minimum top ring end gap of .025”.
- 4) Top rings should be installed with any printing, dots or the inside chamfer facing up.
- 5) We recommend a minimum second ring end gap of .020”.
- 6) The second ring should also be installed with any printing, dots or the inside chamfer facing up.
- 7) The oil ring is bi-directional and the end gap is not critical but should be trial fit in the block to be sure there is no end gap bind present.

** PPE has torque plates available for purchase.**

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