



**DELKRON CYLINDER KIT INSTALLATION INSTRUCTIONS**  
**PART NUMBERS 3200/ 3201/ 3202/ 3203/ 3204/ 3205/ 3210/ 3211/ 3212/ 3213**

1. Piston ring end gap

**Correct piston ring end gap is necessary for proper engine running.**

With cylinders removed from engine and on work bench, install piston into bore of cylinder, install one compression ring at a time into the top of the cylinder 1.00" below the top of the cylinder bore, using the piston to assure that the compression ring is "Square" to the bore ... measure end gap.



Correct top compression ring and secondary compression ring end gap is equal to .004” per inch of cylinder bore ... example: 4.125” x .004” = .0165” of ring end gap. Rounding this number to the next highest number is permissible ... example: .0165” rounds to .017”



**DO NOT** round to the next lowest number ... example: .0165” to .016”. It is better to be slightly larger with your ring end gap than smaller. Insufficient clearance on the compression rings can lead to “Ring Abutment” at operating temperature while under compression causing irreparable engine damage.

To achieve correct ring end gap when ring end gap is insufficient, too small, grinding of the ring ends will be necessary. This can be done several different ways (File / Bench Grinder / Ring Grinder / Etc.), but it is recommended that a ring grinding tool be used. After grinding of ring be sure to deburr the ring ends **prior** to re-installing them into the cylinder bore.



It is very important that the ring ends are square when installed into the cylinder bore.

Ring end gaps that are not square will lead to incorrect ring end gaps that can lead to undesirable engine operation / function as well as irreparable engine damage.

## 2. Engine Reassembly and Installation

Reassemble your engine and reinstall it per your service manual instructions, making sure that all parts are thoroughly cleaned prior to reassembly.

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