



Sunbeam 500cc SV 1925-1929

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Piston	Identification	470691	470690
	Ring set	470691	470690
	Nominal over-size (in)	0.000	0.040
	Nominal finished bore size (in)	3.0315	3.0715
	Nominal finished bore size (mm)	77.00	78.02
	Nominal compression ratio	6 : 1	6 : 1
	Compression height (in)	1.53	1.53
	Pin diameter (in)	0.875	0.875
	Weight (g)	310	318
	Material	2618 - low silicon	2618 - low silicon
	Piston-bore clearance (in)	0.0062 - 0.0072	0.0062 - 0.0072
	Top ring minimum gap (in)	0.012 - 0.018	0.012 - 0.018
	Second ring minimum gap (in)	0.012 - 0.018	0.012 - 0.018
	Oil control minimum ring gap (in)	0.012 - 0.018	0.012 - 0.018

Rings		Min	Max
	Top ring minimum gap (per in of bore)	0.004	0.006
	Second ring minimum gap (per in of bore)	0.004	0.006
	Oil control ring minimum gap (per in or bore)	0.004	0.006

Important	Piston-bore clearance is diametral measured 1.1" below the bottom of the 3rd ring groove, front to rear		
	Dimensions are nominal values, the cylinder must be bored to suit the piston.		
	Rings are fitted with inside bevelled edge to the top		
	Check and adjust the ring gaps before fitting rings to piston		
	Check piston pin is a light, sliding fit in the little end		
	Check compression ratio before running		
	Check head and valve clearances before running		
	Minimum piston-head clearance (in)	0.055 - 0.060	
	Minimum piston-valve clearance (in)	IN 0.090 - EX 0.110	