



Sunbeam 500cc OHV

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Piston	Identification	470810	441281	441282
	Ring set	1012283150	1012283169	1012283189
	Nominal over-size (in)	0.000	0.020	0.040
	Nominal finished bore size (in)	3.150	3.170	3.190
	Nominal compression ratio	7.5 : 1	7.5 : 1	7.5 : 1
	Compression height (in)	1.075	1.075	1.075
	Pin diameter (in)	0.875	0.875	0.875
	Weight (g)	300	303	307
	Material	2618 - low silicon	2618 - low silicon	2618 - low silicon
	Piston-bore clearance (in)	0.003 - 0.004	0.003 - 0.004	0.003 - 0.004
	Top ring minimum gap (in)	0.013 - 0.019	0.013 - 0.019	0.013 - 0.019
	Second ring minimum gap (in)	0.011 - 0.019	0.011 - 0.019	0.011 - 0.019
	Oil control minimum ring gap (in)	0.063 - 0.189	0.063 - 0.190	0.064 - 0.191

Rings		Min	Max
	Top ring minimum gap (per in of bore)	0.004	0.006
	Second ring minimum gap (per in of bore)	0.0035	0.006
	Oil control ring minimum gap (per in or bore)	0.020	0.060

Important	Piston-bore clearance is diametral measured at the bottom of piston skirt, front to rear		
	Dimensions are nominal values, the cylinder must be bored to suit the piston.		
	Rings are fitted with marks or writing to the top		
	Check crankshaft is central		
	Check and adjust the ring gaps in bore before fitting rings to piston		
	Check piston pin is a light, sliding fit in the little end		
	Check sufficient clearance for little end and bush		
	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	