



Sunbeam 500cc OHV

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Piston	Identification	450648	450648	450650
	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	6.5 : 1	6.5 : 1	6.5 : 1
	Compression height (in)	1.065	1.065	1.065
	Pin diameter (in)	0.875	0.875	0.875
	Weight (g)	267	267	270
	Material	4032 - high silicon	4032 - high silicon	4032 - high silicon
	Piston-bore clearance (in)	0.002 - 0.003	0.002 - 0.003	0.002 - 0.003
	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 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
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