A Division of Thiessen Products, Inc.

Instruction Sheet For Tool #3200 & 3201

PISTON RING END GAP TOOL FOR TWIN CAM PISTONS & JIMS ENGINES

No. **3200** - *Use on H-D® Twin Cam standard size pistons for 95" 103" or 110", with a 3.875" or 4.000" bore.*
No. **3201** - *Use on JIMS® Twin Cam motor standard size pistons for 120", 131", or 135" with a 4.125" or 4.310" bore.*

This tool will make compression and oil ring sizing easier, more accurate, and most importantly it assures squareness of rings to the cylinder bore.

Read complete instructions carefully before using tool.
Note: Both tools (No. **3200** & **3201**) perform the same way for the bore sizes lasered on each side of the tool. We are showing a 4" bore in this instruction.



FIG.1

ADDITIONAL TOOLS NEEDED:

1. Nitrile gloves.
2. No. **1255** JIMS piston ring end gap file, for ring fitment.
3. No. **908** JIMS feeler gauge tool or equivalent to check end gap.
4. Service manual or instruction sheet for the piston application you're working with for ring fitment specifications.
5. Safety glasses or face shield.



FIG.2

USING THE GAUGE TOOL

1. Clean and prep your work area before you start to fit rings to cylinders.
2. Before sizing rings to any cylinder, you should prepare the cylinder as stated in your service manual. Hone, de-glaze, degrease, wash, etc.
3. When you have the cylinder at the stage of installing on the case you should be ready to size the rings.
4. Place your cylinder on work bench with the tool installed in the top of the cylinder. Place the tool in the bore with the laser marked 4" bore facing into the cylinder as shown in **Fig 1.**
5. Turn cylinder over while holding tool in place in bore on work bench as shown in **Fig. 2.**
6. Insert a compression ring or oil ring into the cylinder bore with the ring end gap lined up with the center of slot in the tool as shown in **Fig 2.**
7. Make sure the ring is resting flat against the tool all the way around.
8. Refer to service manual or instruction sheet for ring gap specifications.
9. Next, use your feeler gauge to check end gap, as shown. **See Fig 3.**
10. If you need to file the rings to get more end gap use a good quality ring file like JIMS No. **1255** to get a precision end gap. **See Fig 4.**
11. Each time you insert your ring back into your cylinder repeat step 7 above until you reach the desired end gap.



FIG.3

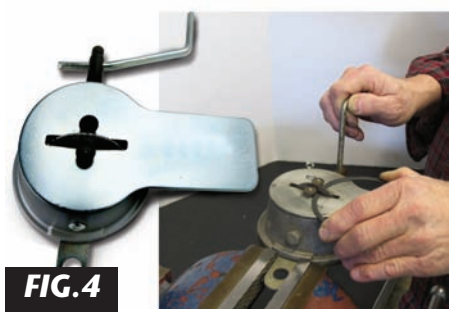


FIG.4