pins must have will be known. Check the sizes of the piston pins before paying for the pistons and taking them away. Piston pin diameters do vary so if there is not enough interference fit, yet the connecting rod is 'on size,' try another set of pistons.

The sizes of connecting rod piston pin tunnels can vary within the range of 0.012-0.040mm/0.0005-0.0015in which is a tolerance of 0.240mm/0.001in. The size of piston pins also varies (by as much as 0.010mm/0.0004in) so it is possible to end up with a piston pin and connecting rod piston pin bore combination that has virtually no interference fit. Check all piston pin sizes and all connecting rod piston pin tunnel diameters.

Match the piston pin sizes of the piston set to connecting rod piston pin bore diameters that give the maximum interference fit for each combination. By selectively matching the piston pins to the connecting rod piston pin bores, the maximum available interference fit will be present in each connecting rod and piston pin combination.

Caution! - note that piston pins are selectively fitted to each piston and they must not be swapped around. Measure the connecting rods' piston pin tunnel diameters before the piston set is purchased: this way, the minimum size of piston pin acceptable will be known before the piston set is paid for and taken away. Piston pin sizes do vary by as much as 0.010mm/0.0004in so the amount of variation possible in 'interference fit' can be very significant.

If the inside diameter of the piston pin bore is no longer 'on size' the connecting rod will have to be replaced. The piston pin bore can be honed out oversize, but an oversized piston pin will have to be procured and the piston's piston pin bore will have to be honed out to suit the new pin. Generally, a new connecting rod is found in an effort to keep everything stock.

**CHECKING CONNECTING ROD BIG END TUNNEL SIZE**

Measure the rod's big end tunnel diameter using an inside micrometer. Measure in three positions - vertically (in-line with the I-beam of the connecting rod) and then at 10mm/0.375in above the partline of the connecting rod and the cap respectively.

The connecting rod big end tunnel diameter tolerance is listed by Ford as being 55.0mm/2.1653in (bottom size) to 55.02mm/2.1660in (top size). Consider the bottom size to be best for high-performance applications but, provided there is still sufficient bearing crush, having a top size tunnel diameter will not cause any problems.

If the big end tunnel is found to be misshapen, or just too large in diameter, the connecting rod will have to be resized on a connecting rod honing machine. In fact, it's good