



**Piston Ring Sets, Ring Applications and
Recommended End Gaps and Side Clearance
for Continental Engines**

Engine Model	Steel Barrel	End Gap	Side Clearance	Chrome Barrel	End Gap	Side Clearance
C-75, 85 PISTON 40327 646287	SA2000-SC* SA2000-A2			SA1000-SC* SA1000-A2		
	C SA2000	.021 - .041	.005 - .0065 L	C SA1000	.013 - .031	.005 - .007 L
	C SA1000	.013 - .031	.0035 - .0055 L	C SA1000	.013 - .031	.0035 - .0055 L
	C SA1000	.013 - .031	.0035 - .0055 L	C SA1000	.013 - .031	.0035 - .0055 L
	O SA10206	.013 - .031	.002 - .004 L	O SA1007	.013 - .031	.002 - .004 L
C-90, O-200 PISTON SA530348 646255	SA2000-SC* SA2000-A2			SA1000-SC* SA1000-A2		
	C SA2000	.021 - .041	.006 - .008 L	C SA1000	.013 - .031	.006 - .008 L
	C SA1000	.013 - .031	.005 - .007 L	C SA1000	.013 - .031	.005 - .007 L
	C SA1000	.013 - .031	.005 - .007 L	C SA1000	.013 - .031	.005 - .007 L
	O SA10206	.013 - .031	.002 - .004 L	O SA1007	.013 - .031	.002 - .004 L
C-145, O-300 PISTON SA530348 646255	SA2000-SC* SA2000-A1			SA1000-SC* SA1000-A1		
	C SA2000	.021 - .041	.006 - .008 L	C SA1000	.013 - .031	.006 - .008 L
	C SA1000	.013 - .031	.005 - .007 L	C SA1000	.013 - .031	.005 - .007 L
	C SA1000	.013 - .031	.005 - .007 L	C SA1000	.013 - .031	.005 - .007 L
	O SA10206	.013 - .031	.002 - .004 L	O SA1007	.013 - .031	.002 - .004 L
GO-300 PISTON 626146 646279	SA2000-SC* SA2000-A1			SA1000-SC* SA1000-A1		
	C SA2000	.021 - .041	.006 - .008 L	C SA1000	.013 - .031	.006 - .008 L
	C SA1000	.013 - .031	.005 - .007 L	C SA1000	.013 - .031	.005 - .007 L
	C SA1000	.013 - .031	.005 - .007 L	C SA1000	.013 - .031	.005 - .007 L
	O SA10206	.013 - .031	.002 - .004 L	O SA1007	.013 - .031	.002 - .004 L
IO-360-A, C, D, G, H, J, K, AB, CB, DB, GB, HB, JB, KB PISTON 630687 642229 646247 648049**	SA3610-SC* SA3610-A1			SA3364-SC* SA3364-A1		
	C SA639570	.0335 - .0495	.001 - .003 L	C SA3364	.0285 - .0445	.001 - .003 L
	C SA639579	.0285 - .0445	.001 - .003 L	C SA3364	.0285 - .0445	.001 - .003 L
	O SA639758	.0085 - .0245	.003 - .005 L	O SA3365	.0085 - .0245	.003 - .005 L
	S SA630678	.0185 - .0345	.003 - .005 L	S SA630678	.0185 - .0345	.003 - .005 L

* Denotes single-cylinder ring set part number.

** Denotes pistons with a steel insert in the top ring land.

NOTE: Ring set part number for complete engine is given after the single-cylinder ring set. Individual ring numbers are then listed in the order they should be installed on the piston. End gap is measured in cylinder bore at new cylinder tolerance 4" up from the cylinder bottom. The following code is used: C=Compression Ring; O=Oil Control Ring; S=Scraper Ring. Oversize ring sets available for steel barrels.

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TSIO-360-A, B, C, D, E, F, G, H, AB, DB, CB, EB, FB, GB, HB, JB, KB, LB, LTSIO- 360-E, EB, KB	SA3610-SC** SA3610-A1			SA3364-SC** SA3364-A1		
PISTON 633428	C SA639570	.0335 - .0495	.001 - .003 L	C SA3364	.0285 -0445	.001 - .003 L
642230	C SA639579	.0285 - .0445	.001 - .003 L	C SA3364	.0285 -0445	.001 - .003 L
SA646743***	O SA639758	.0085 - .0245	.003 - .005 L	O SA3365	.0085 -0245	.003 - .005 L
	S SA630678	.0185 - .0345	.003 - .005 L	S SA630678	.0185 -0345	.003 - .005 L
E-185, E-225, O-470-A, E, J, IO-470-J, K	SA4000-SC5** SA4000-A5			SA4700-SC5** SA4700-A5		
PISTON 534895	C SA4001	.043 - .059	.0065- .0085L	C SA4700	.043 - .059	.0075 - .0095 L
	C SA4001	.043 - .059	.006 - .008 L	C SA4700	.043 - .059	.007 - .009 L
	O SA4707	.033 - .049	.0025-.0045 L	O SA4707	.033 - .049	.0025 - .0045 L
E-185, E-225 O-470-A, E, J IO-470-J, K	SA4000-SC2** SA4000-A2			SA4701-SC2** SA4701-A2		
PISTON 649044***	C SA4003	.038 - .054	.015 - .0039 L	C SA4701	.043 - .059	.0015 - .0039 L
	C SA4003	.038 - .054	.015 - .0039 L	C SA4701	.043 - .059	.0015 - .0039 L
	O SA4705	.016 - .037	.002 - .004 L	O SA4706A	.016 - .037	.0015 - .0035 L
	S SA4709	.033 - .049	.006 - .008 L	S SA4709	.033 - .049	.006 - .008 L
O-470-K, L, R	SA4000-SC6** SA4000-A6			SA4700-SC6** SA4700-A6		
PISTON 626992	C SA4001	.043 - .059	0065 -.0085 L	C SA4700	.043 - .059	.0075 - .0095 L
	C SA4001	.043 - .059	006 - .008 L	C SA4700	.043 - .059	.0075 - .0095 L
	O SA4707	.033 - .049	025 - .0045 L	O SA4707	.033 - .049	.0025 - .0045 L
	S SA4709	.033 - .049	006 - .008 L	S SA4709	.033 - .049	.006 - .008 L
O-470-K, L, R	SA4000-SC3** SA4000-A3			SA4700-SC3** SA4700-A3		
PISTON 632932	C SA4001	.043 - .059	.065 - .0085 L	C SA4700	.043 - .059	.0075 - .0095 L
	C SA4001	.043 - .059	.006 - .008 L	C SA4700	.043 - .059	.007 - .009 L
	O SA4705	.016 - .037	.002 - .004 L	O SA4706A	.016 - .037	.0015 - .0035 L
	S SA4709	.033 - .049	.006 - .008 L	S SA4709	.033 - .049	.006 - .009 L;

* SA1007 is interchangeable with SA1004.

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O-470-K, L, R, S, -4, -13, -13A PISTON SA640518 646263	SA4000-SC2* SA4000-A2 C SA4003 C SA4003 O SA4705 S SA4709	 .038 - .054 .038 - .054 .016 - .037 .033 - .049	 .0015 - .0039 L .0015 - .0039 L .002 - .004 L .006 - .008 L	SA4701-SC2* SA4701-A2 C SA4701 C SA4701 O SA4706A S SA4709	 .043 - .059 .043 - .059 .016 - .037 .033 - .049	 .0015 - .0039L .0015 - .0039L .0015 - .0035L .006 - .008 L
O-470-G IO-470-C, G, P, R, T PISTON 539814	SA4000-SC8* SA4000-A8 C SA4003 C SA4003 O SA4707	 .038 - .054 .038 - .054 .033 - .049	 .0015 - .0039 L .0015 - .0039 L .0025 - .0045 L	SA4701-SC8* SA4701-A8 C SA4701 C SA4701 O SA4707	 .043 - .059 .043 - .059 .033 - .049	 .0015 - .0039L .0015 - .0039L .0025 - .0045L
O-470-B-G, M, P IO-470-C, G, P, R, T PISTON 646772** 648028**	SA4000-SC2* SA4000-A2 C SA4003 C SA4003 O SA4705 S SA4709	 .038 - .054 .038 - .054 .016 - .037 .033 - .049	 .0015 - .0039 L .0015 - .0039 L .002 - .004 L .006 - .008 L	SA4701-SC2* SA4701-A2 C SA4701 C SA4701 O SA4706A S SA4709	 .043 - .059 .043 - .059 .016 - .037 .033 - .049	 .0015 - .0039L .0015 - .0039L .0015 - .0035L .006 - .008 L
O-470-B, M, P PISTON 537883	SA4000-SC5* SA4000-A5 C SA4001 C SA4001 O SA4707	 .043 - .059 .043 - .059 .033 - .049	 .0065 - .0085 L .006 - .008 L .0025 - .0045 L	SA4700-SC5* SA4700-A5 C SA4700 C SA4700 O SA4707	 .043 - .059 .043 - .059 .033 - .049	 .0075 - .0095L .007 - .009 L .0025 - .0045L
O-470-11 O-470-7B PISTON 531510 534895	SA4000-SC5* SA4000-A5 C SA4001 C SA4001 O SA4707	 .043 - .059 .043 - .059 .033 - .049	 .0065 - .0085 L .006 - .008 L .0025 - .0045 L	SA4700-SC5* SA4700-A5 C SA4700 C SA4700 O SA4707	 .043 - .059 .043 - .059 .033 - .049	 .0075 - .0095L .007 - .009 L .0025 - .0045L

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** Denotes pistons with a steel insert in the top ring land.

NOTE: Ring set part number for complete engine is given after the single-cylinder ring set. Individual ring numbers are then listed in the order they should be installed on the piston. End gap is measured in cylinder bore at new cylinder tolerance 4" up from the cylinder bottom. The following code is used: C=Compression Ring; O=Oil Control Ring; S=Scraper Ring. Oversize ring sets available for steel barrels.

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O-470-4, -13, -13A PISTON 535133	SA4000-SC5* SA4000-A5 C SA4001 C SA4001 O SA4707	 .043 - .059 .043 - .059 .033 - .049	 .0065 - .0085 L .006 - .008 L .0025 - .0045 L	SA4700 -SC5* SA4700-A5 C SA4700 C SA4700 C SA4707	 .043 - .059 .043 - .059 .033 - .049	 .0075 - .0095L .0075 - .009 L .0025 - .0045L
IO-470-D, E, F, H, L, M, N, S, U, V PISTON SA627738	SA4000-SC7* SA4000-A7 C SA4003 C SA4003 O SA4707 S SA4709	 .038 - .054 .038 - .054 .033 - .049 .033 - .049	 .0015 - .0039 L .0015 - .0039 L .0025 - .0045 L .006 - .008 L	SA4701-SC7* SA4701-A7 C SA4701 C SA4701 O SA4707 S SA4709	 .043 - .059 .043 - .059 .033 - .049 .033 - .049	 .0015 - .0039L .0015 - .0039L .0025 - .0045L .006 - .008 L
IO-470-D, E, F, H, L, M, N, S, U, V O-470-U PISTON 631481 646280** SA648029**	SA4000-SC2* SA4000-A2 C SA4003 C SA4003 O SA4705 S SA4709	 .038 - .054 .038 - .054 .016 - .037 .033 - .049	 .0015 - .0039 L .0015 - .0039 L .002 - .004 L .006 - .008 L	SA4701-SC2* SA4701-A2 C SA4701 C SA4701 O SA4706A S SA4709	 .043 - .059 .045 - .059 .016 - .037 .033 - .049	 .0015 - .0039L .0015 - .0039L .0015 - .0035L .006 - .008 L
TSIO-470-B, C, D PISTON 629185	SA4000-SC7* SA4000-A7 C SA4003 C SA4003 O SA4707 S SA4709	 .038 - .054 .038 - .054 .033 - .049 .033 - .049	 .0015 - .0039 L .0015 - .0039 L .0025 - .0045 L .006 - .008 L	SA4701-SC7* SA4701-A7 C SA4701 C SA4701 O SA4707 S SA4709	 .043 - .059 .045 - .059 .033 - .049 .033 - .049	 .0015 - .0039L .0015 - .0039L .0025 - .0045L .006 - .008 L
TSIO-470-B, C, D PISTON 631540	SA4000-SC2* SA4000-A2 C SA4003 C SA4003 O SA4705 S SA4709	 .038 - .054 .038 - .054 .016 - .037 .033 - .049	 .0015 - .0039 L .0015 - .0039 L .002 - .004 L .006 - .008 L	SA4701-SC2* SA4701-A2 C SA4701 C SA4701 O SA4706A S SA4709	 .043 - .059 .043 - .059 .016 - .037 .033 - .049	 .0015 - .0039L .0015 - .0039L .0015 - .0035L .006 - .008 L

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IO-520-A, B, C, D, E, F, J, K, L, M, BA, BB, CB, MB PISTON SA631475 646072** SA648013 ** 648045**	SA5000-SC5* SA5000-A5 C SA5003 C SA5004 O SA5208 S SA5209	.028 - .044 .023 - .039 .030 - .046 .033 - .049	.0015 - .004 L .0015 - .004 L .0035 - .0055 L .006 - .008 L	SA5201-SC2* SA5201-A2 C SA5201 C SA5202 O SA5205 S SA5209	.043 - .059 .043 - .059 .024 - .040 .033 - .049	.0015 - .004 L .0015 - .004 L .0035 - .0055L .006 - .008 L
TSIO-520B, C, D, E, G, H, J, K, L, M, N, P, R, T, AF, BB, BE, CE, DB, EB, JB, KB, LB, NB, U, UB, VB, WB PISTON 632585 642761** 643619** SA646303** 648033** SA648044**	SA5000-SC5* SA5000-A5 C SA5003 C SA5004 O SA5208 S SA5209	.028 - .044 .023 - .039 .030 - .046 .033 - .049	.0015 - .004 L .0015 - .004 L .0035 - .0055 L .006 - .008 L	SA5201-SC2* SA5201-A2 C SA5201 C SA5202 O SA5205 S SA5209	.043 - .059 .043 - .059 .024 - .040 .033 - .049	.0015 - .004 L .0015 - .004 L .0035 - .0055L .006 - .008 L
L/TSIO-520-AE PISTON 648037**	SA5000-SC5* SA5000-A5 C SA5003 C SA5004 O SA5208 S SA5209	.028 - .044 .023 - .039 .030 - .046 .033 - .049	.0015 - .004 L .0015 - .004 L .0035 - .0055 L .006 - .008 L	SA5201-SC2* SA5201-A2 C SA5201 C SA5202 O SA5205 S SA5209	.043 - .059 .043 - .059 .024 - .040 .033 - .049	.0015 - .004 L .0015 - .004 L .0035 - .0055L .006 - .008 L
GTSIO-520-C, D, F, G, H, K, L, M, N PISTON 640945 642761** 641782** 641883 641350 SA646303** 648033** SA 648044**	SA5000-SC5* SA5000-A5 C SA5003 C SA5004 O SA5208 S SA5209	.028 - .044 .023 - .039 .030 - .046 .033 - .049	.0015 - .004 L .0015 - .004 L .0035 - .0055 L .006 - .008 L	SA5201-SC2* SA5201-A2 C SA5201 C SA5202 O SA5205 S SA5209	.043 - .059 .043 - .059 .024 - .040 .033 - .049	.0015 - .004 L .0015 - .004 L .0035 - .0055L .006 - .008 L

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IO-550-B, C, D, E, F, L	SA5000-SC5* SA5000-A5			SA5201-SC2* SA5201-A2		
PISTON						
646533**	C SA5003	.028 - .044	.0015 - .004 L	C SA5201	.043 - .059	.0015 - .004 L
648046**	C SA5004	.023 - .039	.0015 - .004 L	C SA5202	.043 - .059	.0015 - .004 L
	O SA5208	.030 - .046	.0035 - .0055 L	O SA5205	.024 - .040	.0035 - .0055L
	S SA5209	.033 - .049	.006 - .008 L	S SA5209	.033 - .049	.006 - .008 L

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