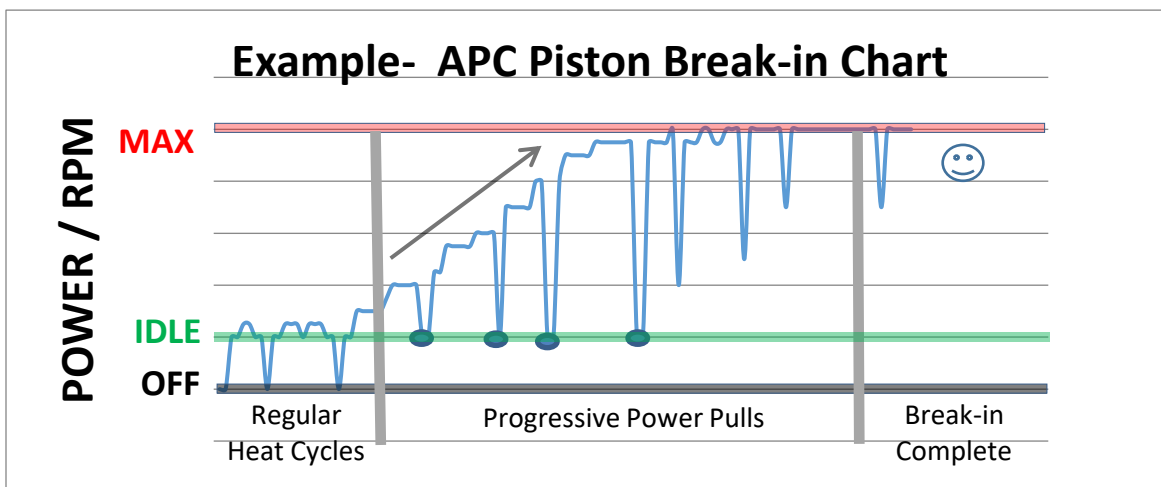




## Abradable Powder Coating™ Piston Coating Specification & Installation Instructions.

Specify Your Desired Coating Thickness
<p><b>1.</b> Do not alter metal to metal clearances to accommodate APC™. L2L needs your Finished Bore Size(s) (FBS), the Manufacturer’s Recommended Piston to Wall Clearance (RPWC), and the Target Coating Thickness (TCT) as calculated on the “How To Order” form.</p> <p><i>*Note: We measure one piston for “all same thickness” service or each piston for “individual sizing” option.</i></p>
<p><b>2.</b> On the Line2Line website “Order” page, print the Thickness Calculation Worksheet and Order Form corresponding to your home state. Complete the Order Form and include it in the box with the pistons.</p>
When They Return, Fit Your Pistons Perfectly
<p><b>3.</b> <b>25% of Manufacturer’s Recommended Clearance</b> - with no rings and no oil, a properly fitted piston will move through its ENTIRE stroke with <i>fingertip</i> pressure. It should not be necessary but if piston fitment is too tight, lightly scrub with a green scotch brite pad to gently remove the coating in tight spots (as indicated by the witness marks). <b><i>Be sure to carefully follow break-in instructions upon startup.</i></b></p>
<p><b>4.</b> Clean the pistons prior to installation. Oil the skirts and bores at assembly.</p>
<p><b>5.</b> Refer to <b>Example- APC Piston Break-in Chart</b>. After normal break-in, give the engine time to fit pistons at each power level, idle briefly, progressively raise power levels until happy at full power. <b><u>Please note that dyno sweeps may not provide enough time for complete break-in. It’s better to hold progressive power levels for approximately 5 seconds and let off for a minute before increasing to the next power level. The idea is to pinch the coating for a short time and then let the oil get back in. Each power cycle laps each piston closer to its perfect geometry!</u></b></p>



Disclaimer: Due to the nature of coating applications, L2L coatings are sold with no express warranty or implied warranty of merchantability or fitness for any particular purpose. Final decisions regarding the suitability, installation or use of L2L coatings for any application are solely the responsibility of the Customer. Line2Line, Inc. shall not, under any circumstances, be liable for any special, incidental or consequential damages related to the use of coated components.