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Important - Before modifying these pistons, be sure they match what you ordered!

Used or altered components cannot be returned for refund, credit or exchange regardless of the circumstances. If your pistons are not as you ordered, immediately contact your point of purchase: your ARIAS PISTONS dealer or the ARIAS customer service department. Refer to the six-digit sales order / jobcard number stamped on the underside of the piston pin tower. All credits, exchanges or repairs must be completed within 90 days of invoice date.

Prior to returning any ARIAS component, please contact our customer service department. All returns must be pre-approved and assigned a Returned Goods Authorization (RGA) number by an ARIAS agent. Any returned package received at the factory must have the RGA number clearly marked on the outside.

Please remove all installed hardware (rings, wrist pins, lox) from the piston(s) and thoroughly clean all components. Failure to do so may incur a handling and/or cleaning fee.

- 1) ARIAS FORGED PISTONS are manufactured from either 2618 (non silicon) or 4032 (high silicon) aluminum alloy. All 4032 alloy pistons custom or stocking, are identified by a star '☆' stamped under the pin boss (as of 9/93).
 - 2) **FINISHED BORE SIZE** is indicated on the printed customer specification sheet provided. Any variation of the finished bore diameter will affect the assembled piston to cylinder wall clearance. All ARIAS pistons are manufactured from the information provided at the time of order. ARIAS engineers determine proper piston to wall clearance and incorporate this into the manufacturing process. This clearance is based on several variables: Bore size, alloy used, fuel used, power enhancements (Supercharged, Turbocharged, Nitrous, etc.).
 - 3) **COMPRESSION HEIGHT** The compression height is the dimension or measurement from the center of the pin hole to the deck of piston. Check pistons in the block to verify the compression height. We recommend a minimum piston to head clearance of .040 on steel connecting rod motors and .055 if aluminum rods are to be used. This includes the deck clearance plus the gasket. (Example .038 compressed gasket and .017 deck + total .055).
 - 4) **VALVE POCKET DEPTH** Minimum acceptable valve-to-piston clearance is dependent to many factors, including cam lobe lift rate, valve spring tension, and valve actuating mechanism weight, etc. However, we have found that .090 intake (.125 blown) and .110 exhaust (.175 blown) clearance is sufficient in most instances. Check valve to piston clearance (using clay or light spring method) making sure that the camshaft is degreed as it will be operated, as a few degrees of advance or retard at the camshaft can radically alter the valve-to-piston clearance.
 - 5) **CHECK PISTON-TO-COUNTERWEIGHT CLEARANCE** with a minimum of .060 being acceptable.
 - 6) Check rod pin end to piston boss clearance with the piston in the bore and the rod installed on the crankshaft, to insure that the side of the rod is not contacting the side of the pin boss.
- FOR RING AND END GAP CLEARANCE** Check with ring manufacturer for their recommendations.

In the event you do not understand any of the above guidelines, or have any questions, please feel free to call our customer service department for technical assistance.

WARRANTY DISCLAIMER - ALL ARIAS INDUSTRIES, INC. PRODUCTS ARE WARRANTIED TO BE FREE FROM DEFECTS IN MATERIAL AND WORKMANSHIP. IT IS THE RESPONSIBILITY OF THE PURCHASER TO INSPECT ALL THE GOODS CAREFULLY BEFORE USE. ANY RETURNS ARE TO BE MADE BEFORE THE PRODUCT IS USED. CREDIT, REPAIR, OR REPLACEMENT OF GOODS IS PREDICATED UPON FACTORY INSPECTION OF THE PRODUCT IN QUESTION. DUE TO THE NATURE OF HIGH PERFORMANCE APPLICATIONS, ARIAS PRODUCTS ARE SOLD WITHOUT ANY EXPRESS OR IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. ARIAS SHALL NOT UNDER ANY CIRCUMSTANCES, BE LIABLE FOR ANY SPECIAL, CONSEQUENTIAL OR INCIDENTAL DAMAGES, INCLUDING, BUT NOT LIMITED TO, LOSS OF PROFITS OR REVENUE, LOSS OF OTHER PROPERTY OR EQUIPMENT, COST OF PURCHASED OR REPLACEMENT GOODS, OR CLAIMS OF CUSTOMERS OF THE PURCHASER, WHICH MAY ARISE AND/OR RESULT FROM THE SALE, INSTALLATION OR USE OF THESE PARTS. INSTALLATION OF THESE PARTS COULD ADVERSELY AFFECT THE VEHICLE MANUFACTURER'S WARRANTY COVERAGE. SUBJECT TO APPLICABLE STATE LAW. SOME ITEMS MAY NOT BE LEGAL FOR USE IN SOME STATES ON POLLUTION CONTROLLED VEHICLES. CHECK WITH YOUR LOCAL OR STATE AUTHORITIES.