



## PISTON

**REASSEMBLY:**

- Do not interchange the top ring and the second ring.
- After assembly, check for smooth movement of the piston ring.
- Stagger the piston ring end gaps 120° apart. Do not align with the piston pin.

**REASSEMBLY:**

- Install by setting one end of the clip in the piston groove, holding the other end with long-nosed pliers, and rotating the clip in.
- Do not align the end gap of the clip with the cutout in the piston pin bore.

## CRANKCASE SIDE COVER/GOVERNOR

**REMOVAL:** Insert a screw driver or equivalent tool into the concave in the position shown, and remove the crankcase side cover.

**REASSEMBLY:** Tighten diagonally in 2 or 3 steps to the specified torque.

**REASSEMBLY:** Check to see whether the weight opens smoothly.

**REASSEMBLY:** Be sure to set the clip in the groove in the shaft.

**REASSEMBLY:** Open the governor weight and insert the slider into the shaft.

## FLYWHEEL/IGNITION COIL

**INSTALLATION:** Be sure that there is no washer or other foreign material on the magnetic part.

**REASSEMBLY:** After installing the flywheel, check the key groove to see whether the key is set properly.

**REASSEMBLY:** Clean the tapered part of dirt, oil, grease and all foreign material before installation.

**REASSEMBLY:** Apply oil to the threads and seat surface of the nut, and tighten the nut.

**REASSEMBLY:** Check the insulator of the wire for tears and damage before connection.

## OIL CASE/CRANKSHAFT/CAMSHAFT/VALVE LIFTER

**OIL CASE INSTALLATION**

- Apply a bead 1.5 to 2.0 mm (0.06 to 0.08 in) in diameter of liquid gasket (ThreeBond 1216E or equivalent) to the mating surface of the cylinder block as shown.
- Assemble **within 3 minutes** after applying the liquid gasket.
- If it is hard to install the oil case properly, install by turning the crankshaft a little.

**LIQUID GASKET APPLICATION AREA**

**CRANKSHAFT/CAMSHAFT/VALVE LIFTER**

**INSTALLATION:**

- Install with the "Δ" mark on the head toward the IN side.
- Take care not to break the piston ring during installation.

**CRANKCASE SIDE COVER INSTALLATION**

- Apply a bead 1.5 to 2.0 mm (0.06 to 0.08 in) in diameter of the liquid gasket (ThreeBond 1216E or equivalent) to the mating surface of the cylinder block as shown.
- Assemble **within 3 minutes** after applying the liquid gasket.
- Wait for **30 minutes** after assembly. Do not add oil or start the engine during this period.

**LIQUID GASKET APPLICATION AREA**

**CAMSHAFT/TIMING MARK ALIGNMENT**

**VALVE/CYLINDER BLOCK/ROCKER ARM/PUSH ROD**

**REASSEMBLY:**

- Remove carbon deposits before installation.
- Check the valve head for damage.
- Do not interchange with the exhaust valve.

**VALVE HEAD DIAMETER:** IN: 17.5 mm EX: 15.5 mm

**VALVE COVER INSTALLATION**

- Apply a bead 1.5 to 2.0 mm (0.06 to 0.08 in) in diameter of the liquid gasket (ThreeBond 1207B or equivalent) to the position shown on the cylinder block.
- Assemble **within 3 minutes** after applying the liquid gasket.
- Wait for **20 minutes** after assembly. Do not add oil or start the engine during this period.

**LIQUID GASKET APPLICATION AREA**

## VALVE/CYLINDER BLOCK/ROCKER ARM/PUSH ROD

**REASSEMBLY:** Tighten diagonally in 2 or 3 steps to the specified torque.

**REASSEMBLY:** Tighten the bolts diagonally in 2 or 3 steps.

**REASSEMBLY:** Check for wear or deformation at both ends of the push rod. Install by aligning with the adjustment screw and the concave in the valve lifter securely.

**VALVE COVER INSTALLATION**

- Apply a bead 1.5 to 2.0 mm (0.06 to 0.08 in) in diameter of the liquid gasket (ThreeBond 1207B or equivalent) to the position shown on the cylinder block.
- Assemble **within 3 minutes** after applying the liquid gasket.
- Wait for **20 minutes** after assembly. Do not add oil or start the engine during this period.

**LIQUID GASKET APPLICATION AREA**