

PISTON INSTALLATION

PISTON RING INSTALLATION

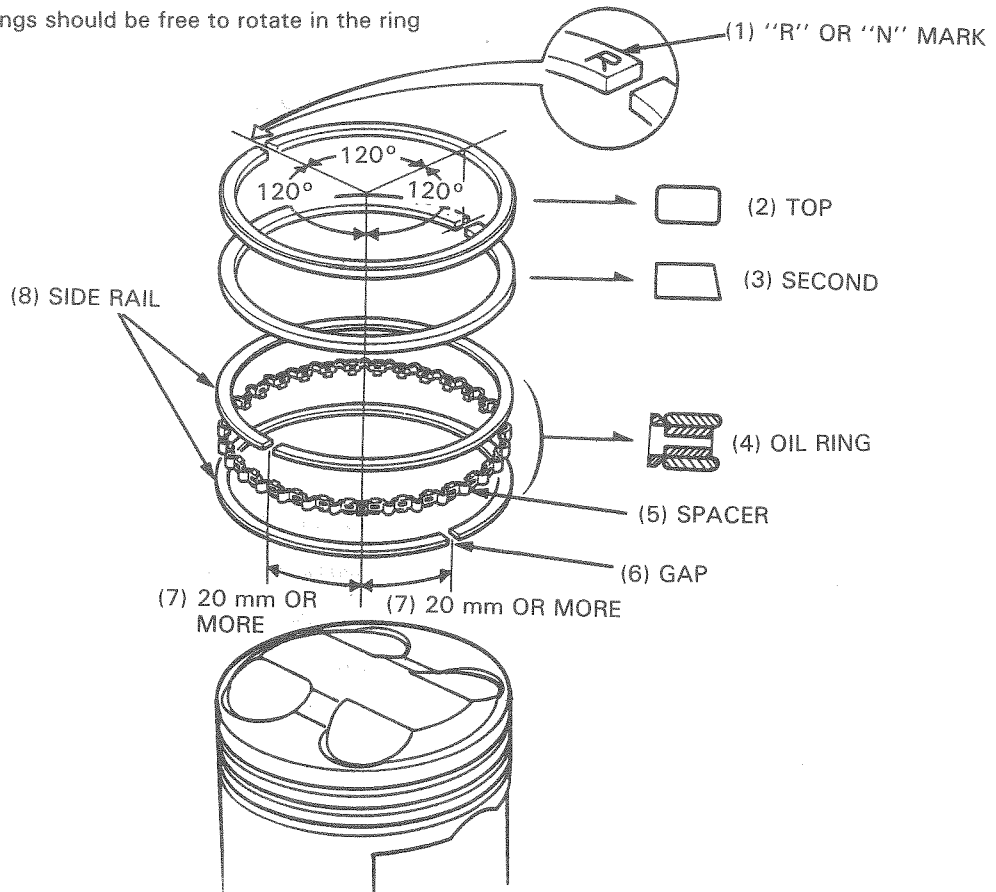
Clean the piston ring grooves thoroughly and install the piston rings with the marks facing up.

NOTE

- Avoid piston and piston ring damage during installation.
- Do not interchange the top and second rings.

Space the piston ring end gaps 120 degrees apart. Do not align the gaps in the oil rings (side rails).

After installation, the rings should be free to rotate in the ring grooves.



PISTON INSTALLATION

Apply MoS₂ grease (page 2-13) to the inside of the connecting rod small end.

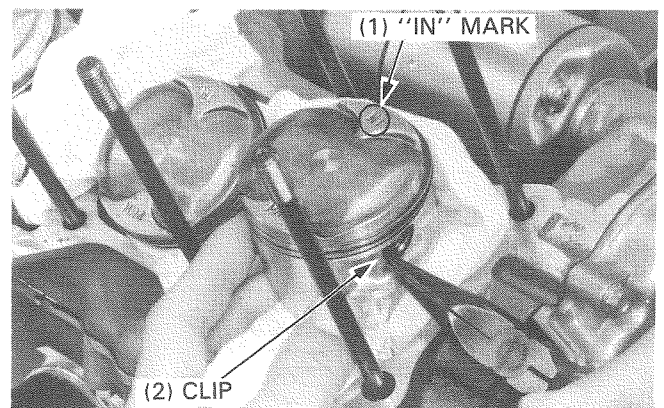
Install the piston with its "IN" mark on the intake valve side.

Install the piston pin with new pin clips.

Do not align the piston pin clip end gap with the piston cutout.

NOTE

- Do not allow the clip to fall into the crankcase.

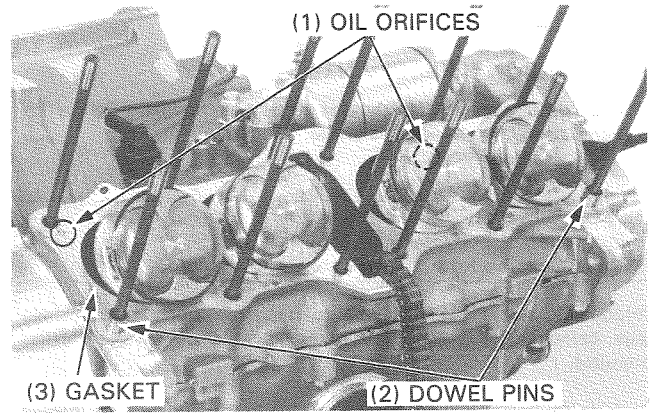


CYLINDER INSTALLATION

Install the oil orifices, dowel pins and gasket.

NOTE

- Install the oil orifices with their smaller holes facing up.

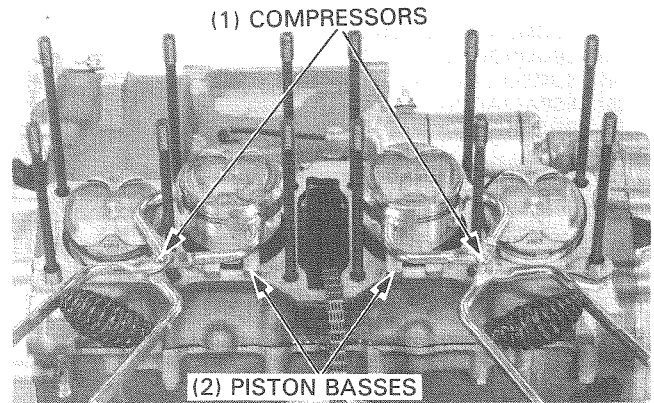


Coat the cylinder bore with the clean engine oil.
Position the No. 2 and No. 3 pistons at T.D.C.
Insert the piston bases under the pistons and attach the piston ring compressors to the pistons.

Slide the cylinder over the No.2 and No. 3 pistons and remove the piston bases and compressors.

TOOL:

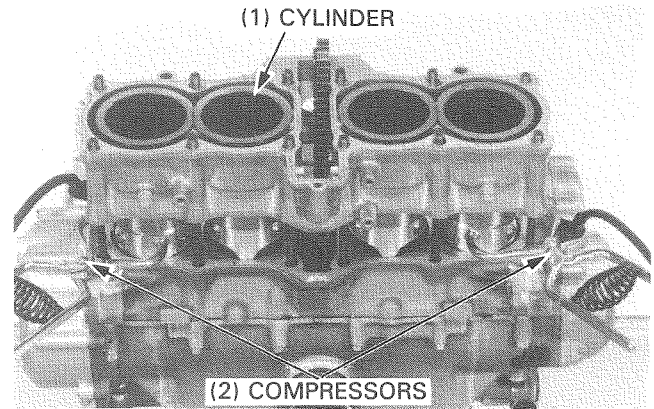
- Piston ring compressor 07954-4140000
- Piston base 07958-2500001



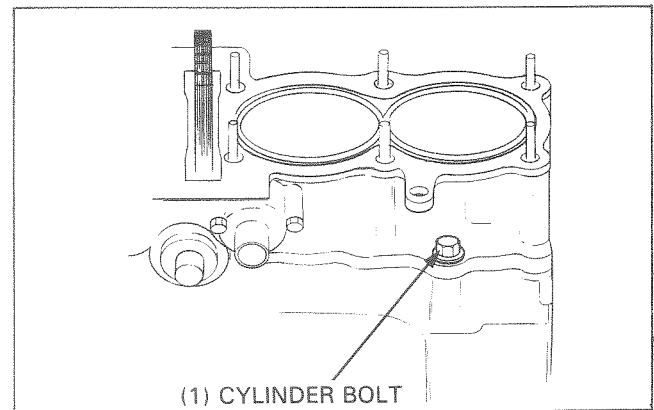
Attach the piston ring compressors to the No. 1 and No. 4 pistons.
Slide the cylinder over the No. 1 and No. 4 pistons and remove the compressors.

TOOL:

- Piston ring compressor 07954-4140000



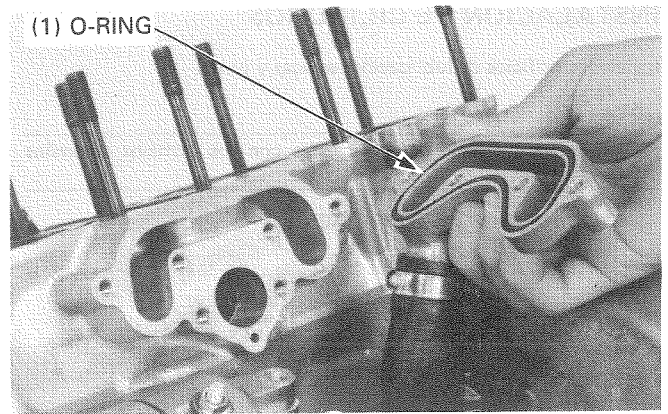
Install the cylinder bolt and tighten it securely.



CYLINDER/PISTON

Check the O-ring for damage or fatigue.

Install the water joint to the cylinder.

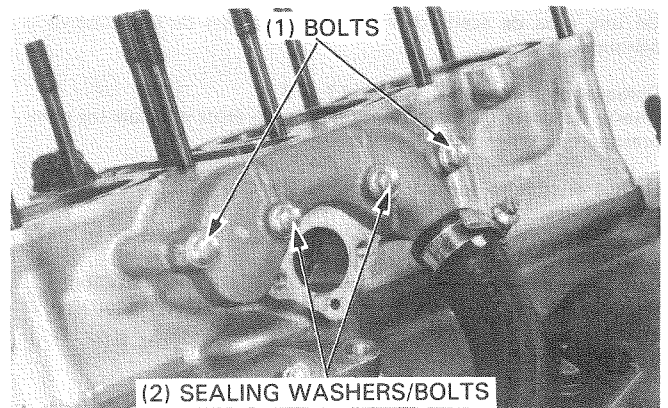


Install and tighten the water joint bolts securely.

NOTE

- Install new sealing washers to the shown positions.

Install the cylinder head (page 8-16).



MEMO

CRANKCASE

CARTER

BASAMENTO

