

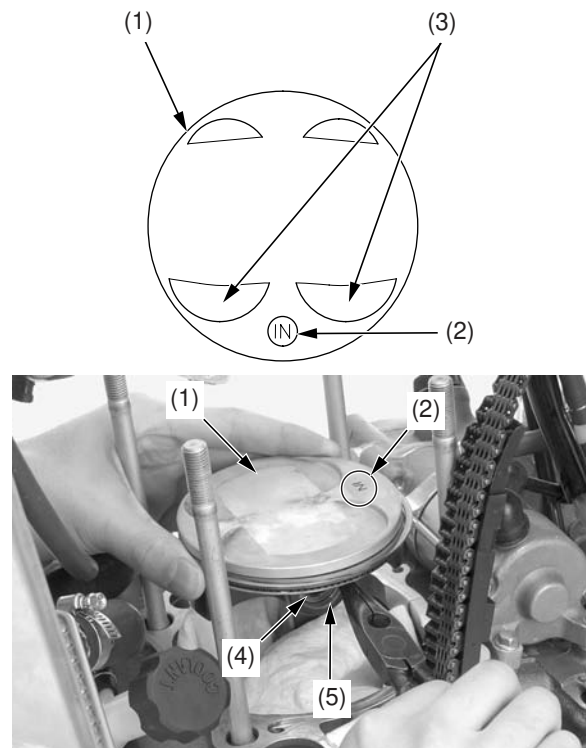
Piston/Piston Rings/Piston Pin

Piston Installation

1. Place clean shop towels over the crankcase opening to keep the piston pin clips from falling into the crankcase.
2. Apply molybdenum disulfide oil solution (a mixture of 1/2 engine oil and 1/2 molybdenum disulfide grease containing more than 3% molybdenum disulfide additive) to the connecting rod small end.
3. Apply clean engine oil to the piston pin outer surface and piston pin hole inner surface.
4. Install the piston (1) with the "IN" mark (2) and/or the large valve recesses (3) facing the intake side of the engine.
Install the piston pin (4) and new piston pin clips (5).

NOTICE

*Use new piston pin clips. Never reuse old piston pin clips.
Do not let the piston pin clips fall into the crankcase.
Do not align the piston pin clip end gap with the piston cut-out.*



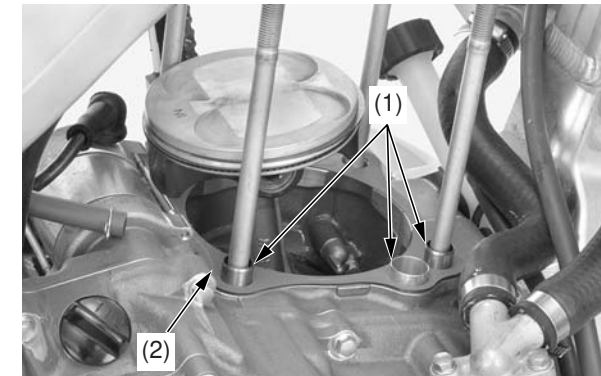
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|--------------------------|---------------------|
| (1) piston | (4) piston pin |
| (2) "IN" mark | (5) piston pin clip |
| (3) large valve recesses | (6) cut-out |

Cylinder Installation

1. Place clean shop towels over the crankcase opening to prevent dust or dirt from entering the engine.
2. Clean off any gasket material from the gasket surface of the crankcase.
3. Remove the shop towel.
4. Install the dowel pins (1) and new cylinder gasket (2).

NOTICE

Do not let the dowel pins fall into the crankcase.



- (1) dowel pins
(2) cylinder gasket

5. Clean the any gasket material off the cylinder.