

NOTE

- Do not damage the gasket surface.
- Do not let any material fall into the crankcase.

Requisite Service

- Cylinder head removal/installation (page 7-8)

| Procedure | | Q'ty | Remarks |
|----------------------------------|-------------------------------|------|--|
| Removal Order | | | Installation is in the reverse order of removal. |
| (1) | Reed valve case mounting bolt | 4 | Switzerland and Austria model only |
| (2) | Reed valve case | 2 | |
| (3) | Reed valve case joint pipe | 1 | |
| (4) | O-ring | 6 | |
| (5) | Cylinder holding nut | 4 | |
| (6) | Oil hose stay | 1 | |
| (7) | Cylinder | 1 | |
| (8) | Dowel pin | 2 | |
| (9) | Gasket | 1 | |
| (10) | Piston pin clip | 8 | Install new piston pin clips. |
| (11) | Piston pin | 4 | |
| (12) | Piston assembly | 4 | NOTE • At installation, install the piston with the "IN" mark facing towards the intake side. |
| Piston Ring Removal Order | | | Installation is in the reverse order of removal. |
| (13) | Top ring | 4 | NOTE • Use care when removing or installing the rings. • Insert the outside surface of the ring into the proper ring groove and roll the ring around the groove to make sure that the ring has a free fit around the piston's circumference. |
| (14) | Second ring | 4 | |
| (15) | Side rail | 8 | |
| (16) | Spacer | 4 | |
| (17) | Piston | 4 | |