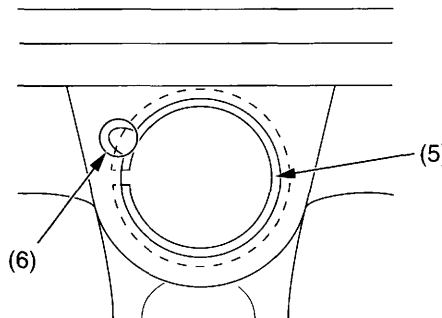
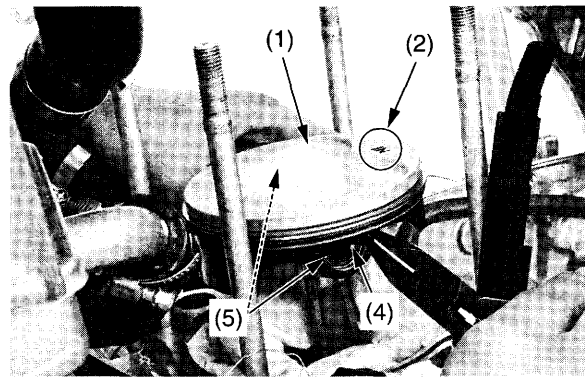
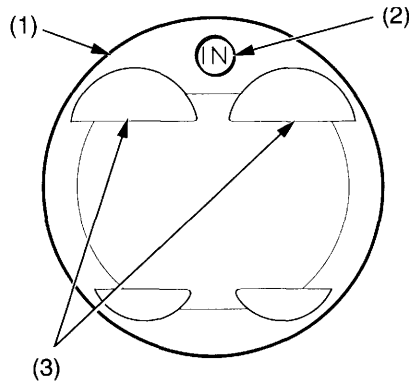


Piston Installation

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 (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 inner surface.
3. Install the piston (1) with the "IN" mark (2) and/or the large valve recesses (3) facing the intake side of the engine.
4. Apply engine oil to the piston pin (4) outer surface.
Apply engine oil to the piston outer surface and piston pin hole inner surface.
Install the piston pin and new piston pin clips (5).

NOTICE

*Use new pin clips. Never reuse old clips.
Do not let the clips fall into the crankcase.
Do not align the piston pin clip end gap with the piston cut-out (6).*



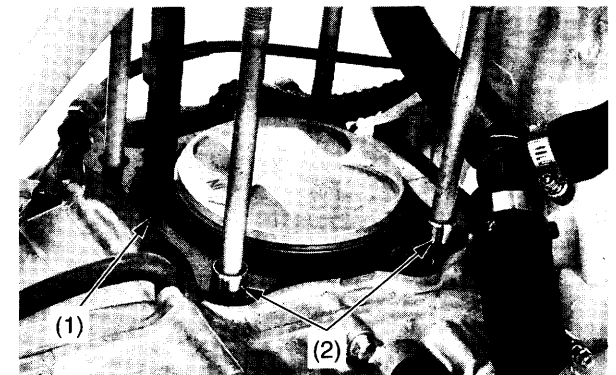
- | | |
|--------------------------|----------------------|
| (1) piston | (4) piston pin |
| (2) "IN" mark | (5) piston pin clips |
| (3) large valve recesses | (6) piston cut-out |

Cylinder Installation

1. Clean off any gasket material from the gasket surface of the crankcase, being careful not to let any material fall into the crankcase.
Be careful not to remove any metal from the gasket surface.
2. Remove the shop towel. Do not let any gasket debris fall into the crankcase.
3. Install a new cylinder gasket (1) and dowel pins (2).

NOTICE

Do not let the dowel pins fall into the crankcase.



- (1) cylinder gasket (2) dowel pins

4. Clean any gasket material off the cylinder.

(cont'd)