

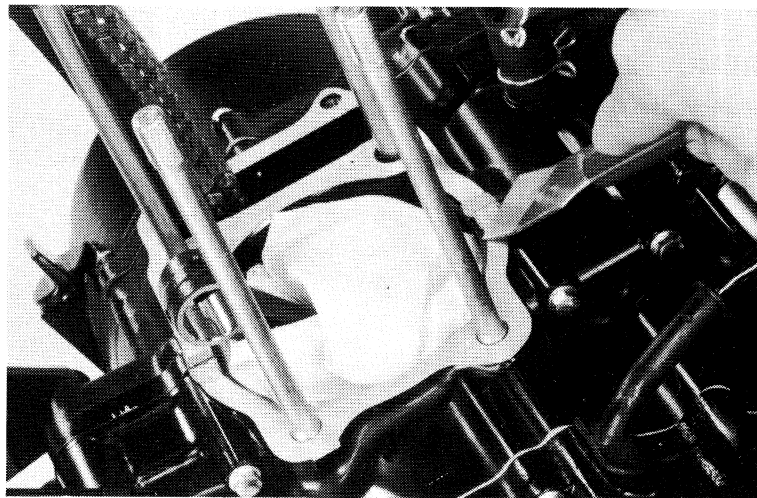
## CYLINDER/PISTON

### PISTON/CYLINDER INSTALLATION

Clean off any gasket material from the crankcase surface.

#### NOTE

Be careful not to remove any metal from the gasket surface.



Install the piston and piston pin, using new piston pin clips.

#### NOTE

- Position the piston "IN" mark on the intake valve side.
- Do not align the piston pin clip end gap with the piston cutout.
- Do not let the clip fall into the crankcase.

Install a new gasket the dowel pins and a new O-ring.



Stagger the piston ring end gaps 120° part.

Coat the cylinder bore and piston rings with engine oil and install the cylinder.

#### NOTE

- Avoid piston ring damage during installation.
- Do not let the cam chain fall into the crankcase.

Install the cam chain guide.  
Tighten the cylinder mount bolts.

**TORQUE: 8–12 N·m (0.8–1.2 kg·m, 6–9 ft·lb)**

