



PISTON

MARKING

TOP RING (CHROME FACED)
SECOND RING (BLACK FACED)
OIL RING { SPACER
SIDE RAIL (2)
PISTON PIN CLIP (2)
PISTON
PISTON PIN

PISTON RINGS
REASSEMBLY:
Refer to GX120-GX160-GX200 Engine Assembly Information.

TOP RING (CHROME FACED)
SECOND RING (BLACK FACED)
OIL RING (COMBINATION RINGS)

CONNECTING ROD
REASSEMBLY:
Install the connecting rod with the long end toward the triangle-marked side of the piston.

REASSEMBLY:
Refer to GX120-GX160-GX200 Engine Assembly Information.

PISTON PIN CLIP
CUT OUT

BALANCER

BALANCER
BALANCER DRIVE GEAR (large gear on the crankshaft)
PUNCH MARKS
TIMING GEAR (smaller gear on the crankshaft)
CAMSHAFT

CRANKCASE COVER/GOVERNOR

LOCK PIN
REASSEMBLY:
• Install the lock pin immediately after installing the governor arm shaft, and move the shaft to the cylinder side as shown.
• The lock pin must be installed with the straight side of the pin against the groove in the shaft.

GOVERNOR SLIDER
REASSEMBLY:
Spread the governor weights to install the slider; then check to be sure the slider moves smoothly.

GOVERNOR WEIGHT (2)
REASSEMBLY:
Check that the weights move freely.

GOVERNOR WEIGHT HOLDER
REASSEMBLY:
Before installing, check for wear and damage of the gear.

WASHER
REASSEMBLY:
Install inside the case.

GOVERNOR ARM SHAFT
REASSEMBLY:
After installing, rotate the shaft to the cylinder barrel side.

6 x 16 mm WASHER (Equipped type)
CLIP
REASSEMBLY:
Install firmly into the shaft groove.

BALL BEARING

GOVERNOR PIN (2)
WASHER
CRANKCASE GASKET
CRANKCASE COVER
OIL SEAL 30 x 46 x 8 mm
8 x 35 (7)
24 N·m (2.4 kgf·m, 17 lbf·ft)

Do not reuse.

CRANKSHAFT/BALANCER/PISTON

PISTON
REASSEMBLY:
Install with the triangle mark toward the pushrod hole.
TRIANGLE MARK

CAMSHAFT
REASSEMBLY:
Before installing, inspect for worn and weakened springs and check that the decompressor weight moves smoothly.

DECOMPRESSOR WEIGHT

VALVE LIFTER (2)
DISASSEMBLY:
When removing, mark so that the IN and EX sides can be distinguished.
REASSEMBLY:
Install the lifters immediately before installing the camshaft.

OIL SEAL 30 x 46 x 8 mm

GREASE

10 mm FLANGE NUT
10 N·m (1.0 kgf·m, 7 lbf·ft)

OIL DRAIN BOLT (2)
23 N·m (2.3 kgf·m, 17 lbf·ft)

DRAIN BOLT WASHER
Replace.

OIL LEVEL SWITCH

CONNECTING ROD BOLT (2)
14 N·m (1.4 kgf·m, 10 lbf·ft)

CONNECTING ROD CAP
REASSEMBLY:
Install with the oil dipper toward the camshaft and the ribs on the cap and connecting rod aligned.

BALL BEARING

7 x 7 x 33 mm KEY (L,S type only)
6.3 x 6.3 x 43 mm KEY (Q type only)

TIMING GEAR/BALANCER GEAR

BALANCER

CRANKSHAFT
REASSEMBLY:
Push in until the bearing touches the crankcase. Be careful not to damage the oil seal.

CYLINDER HEAD/VALVES

Refer to GX340 · GX390 Engine Assembly Information.

FLYWHEEL/IGNITION COIL

WOODRUFF KEY
REASSEMBLY:
After installing the flywheel, check to be sure that the woodruff key is still in its slot on the crankshaft.

BLACK WIRE
REASSEMBLY:
Insert securely into the two ribs on the crankcase as shown.

SPARK PLUG CAP

IGNITION COIL
6 x 28 (2)

COOLING FAN
NOTICE: When disassembling and reassembling, take care not to damage the fan blades.
REASSEMBLY: Attach by aligning the three lugs on the rear side of the fan with the three holes in the flywheel.

FLYWHEEL
DISASSEMBLY:
• Remove the ignition coil before removing the flywheel.
• Do not hit the flywheel with a hammer. Remove with the special tool.
REASSEMBLY:
Clean the crankshaft tapered surface before installation.

FLYWHEEL PULLER
07935-8050004 (Honda's special tool)

16 mm FLANGE NUT
TORQUE:
115 N·m (11.5 kgf·m, 83 lbf·ft)
DISASSEMBLY/REASSEMBLY:
• Apply oil to the threads.
• Hold the flywheel by placing a screwdriver into the pulley.

STARTER PULLEY
REASSEMBLY:
Align the hole of the starter pulley with the boss of the cooling fan.
(SD, SN, QD types only)

ALIGN

HOLE (3) LUG (3)