

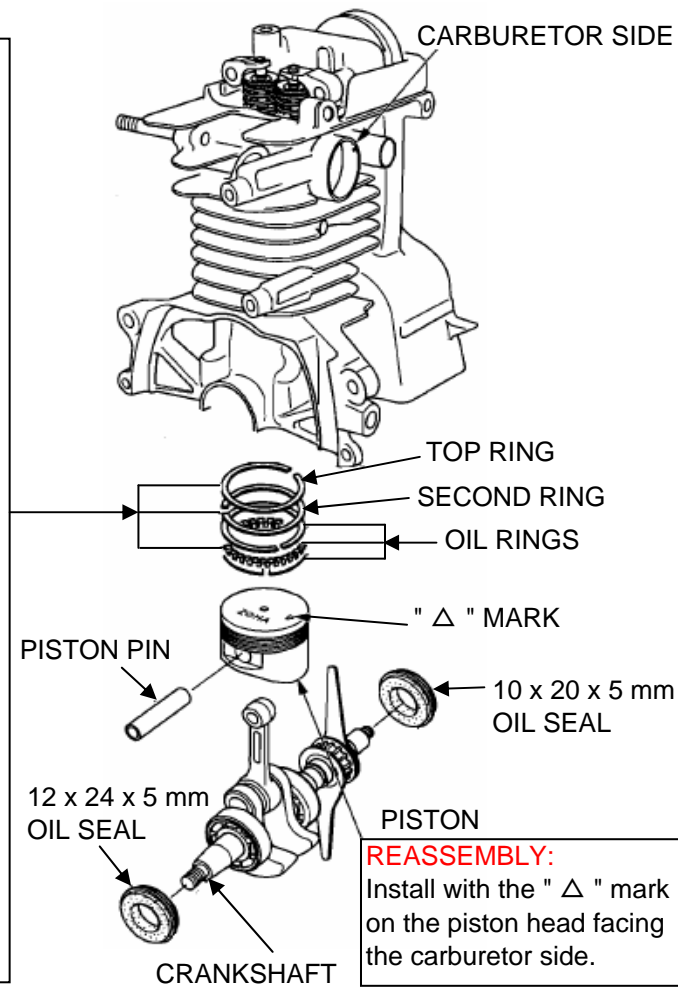
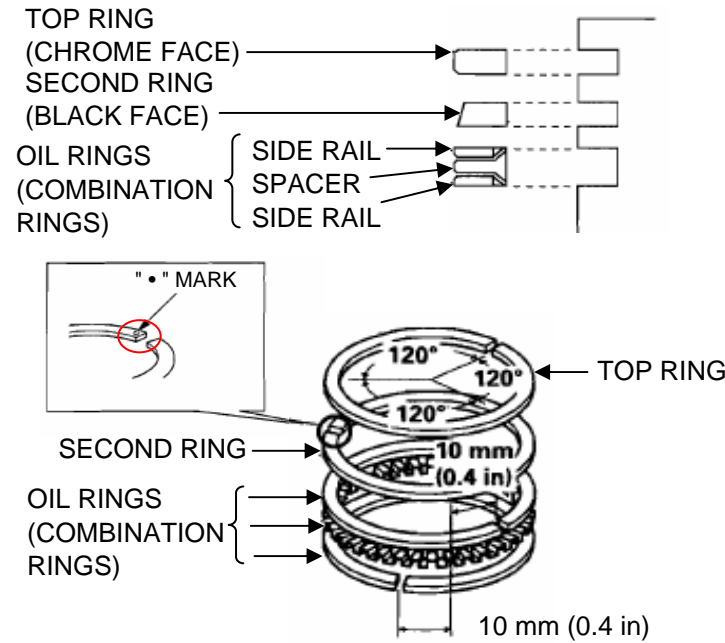


## CRANKSHAFT/PISTON

### PISTON RING

#### REASSEMBLY:

- Install the second ring with the "•" mark facing up.
- Do not interchange the top ring and the second ring.
- After assembly, check for smooth movement of the piston rings.
- Stagger the piston ring end gaps 120° apart. Do not align with the piston pin.
- Space the oil ring side rail end gaps at least 10 mm (0.4 in) apart. Coat the oil ring with oil after assembly.



**REASSEMBLY:**  
Install with the "Δ" mark on the piston head facing the carburetor side.

## LOWER CRANKCASE

4 x 8 mm SCREW (2)

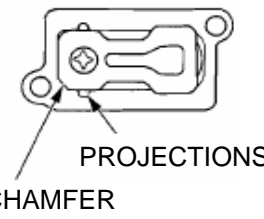
#### REASSEMBLY:

Clean the threads and apply liquid sealant ( Loctite® 648, Hondalock 2 or equivalent ) to the threads.

### OIL OUTLET VALVE PLATE

#### INSTALLATION:

Install the oil outlet valve to the oil outlet valve plate by aligning the chamfer and projections.

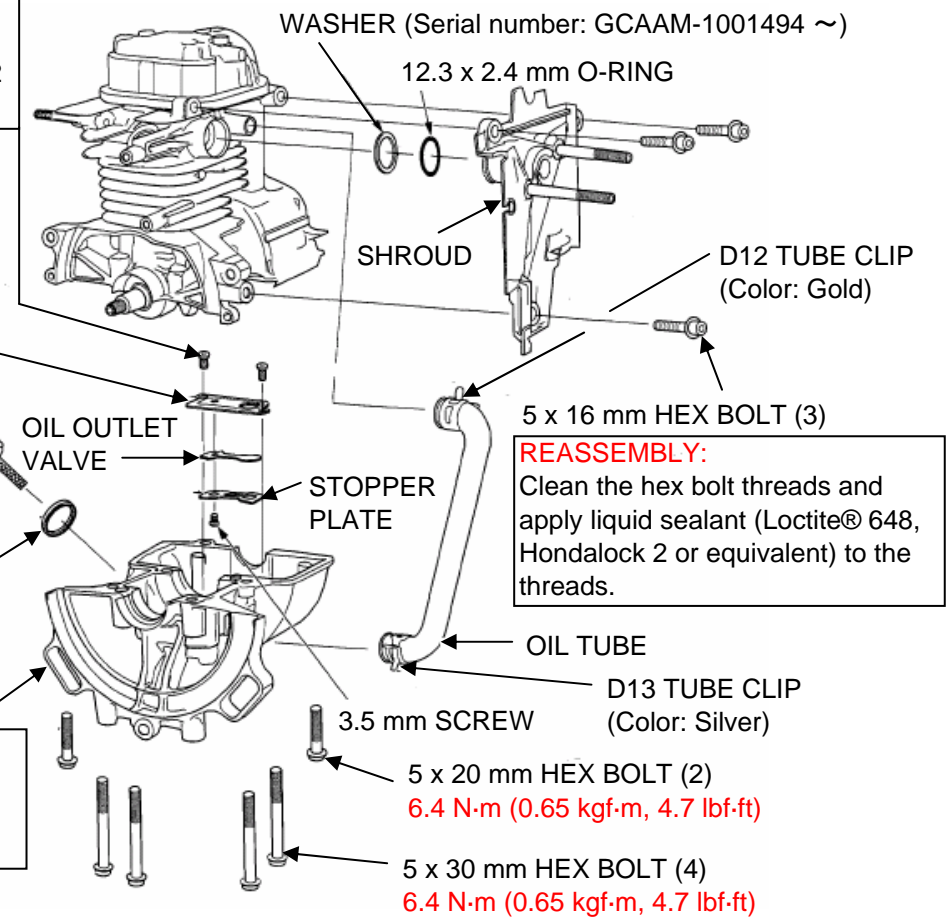


OIL FILLER CAP PACKING

### LOWER CRANKCASE

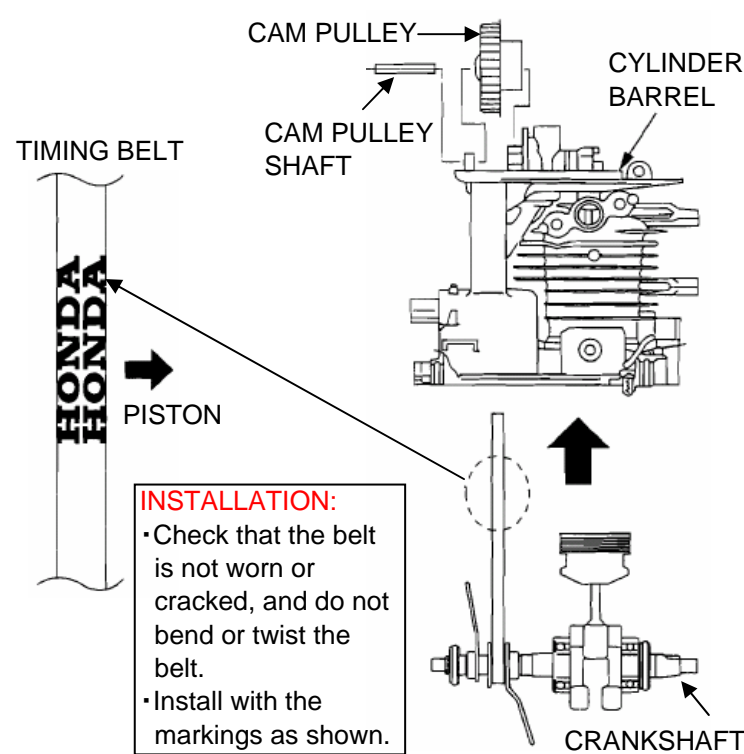
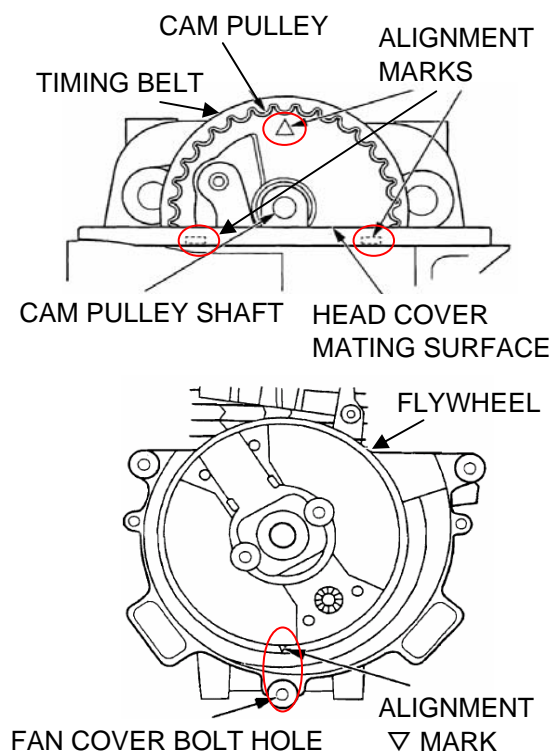
#### REASSEMBLY:

Clean the inside of the crankcase and remove foreign material before reassembly.



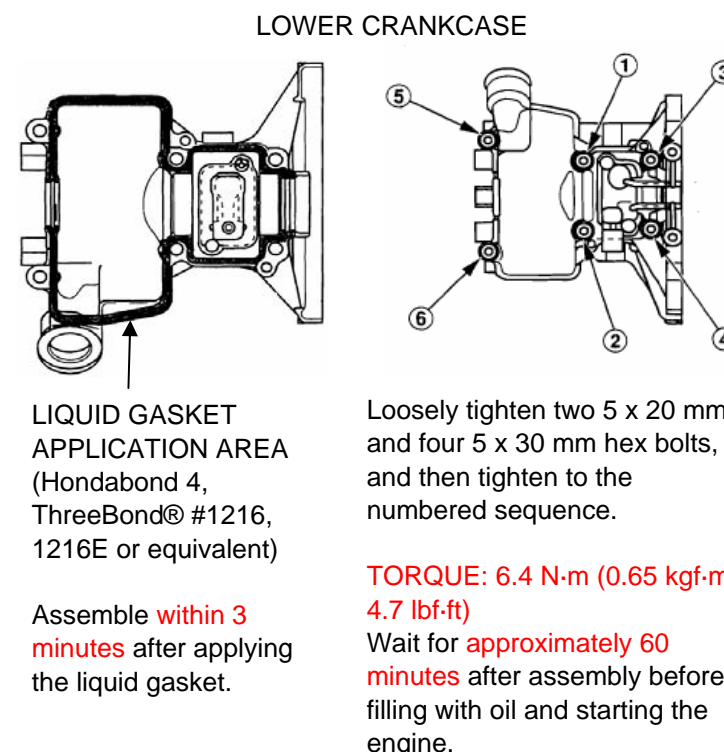
**REASSEMBLY:**  
Clean the hex bolt threads and apply liquid sealant (Loctite® 648, Hondalock 2 or equivalent) to the threads.

## CAM PULLEY/CRANKSHAFT



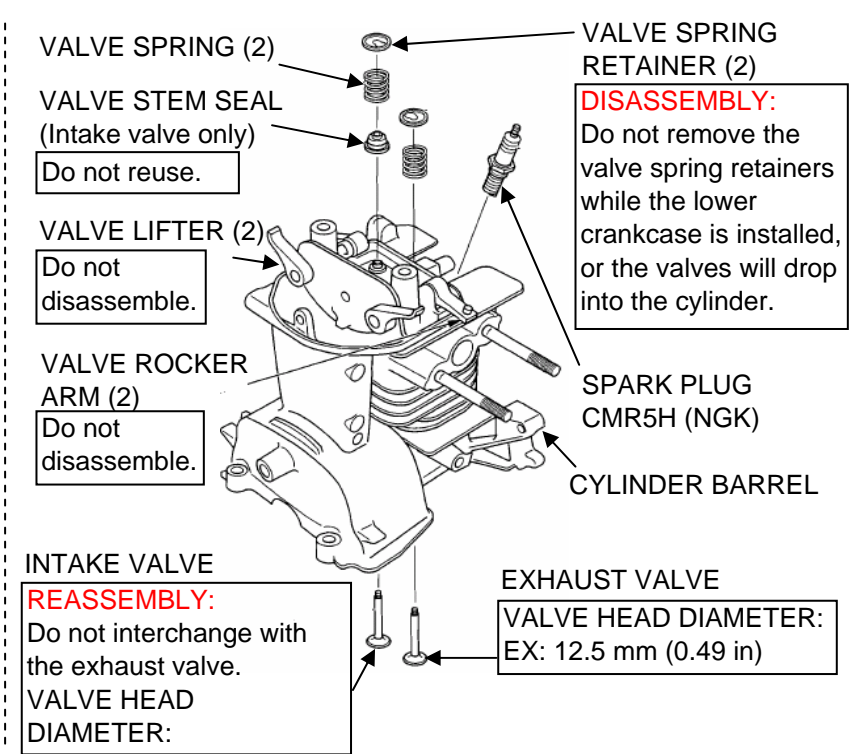
**INSTALLATION:**  
• Check that the belt is not worn or cracked, and do not bend or twist the belt.  
• Install with the markings as shown.

## LOWER CRANKCASE/CYLINDER BARREL/VALVES



LIQUID GASKET APPLICATION AREA (Hondabond 4, ThreeBond® #1216, 1216E or equivalent)  
Assemble **within 3 minutes** after applying the liquid gasket.

Loosely tighten two 5 x 20 mm and four 5 x 30 mm hex bolts, and then tighten to the numbered sequence.  
**TORQUE: 6.4 N-m (0.65 kgf-m, 4.7 lbf-ft)**  
Wait for **approximately 60 minutes** after assembly before filling with oil and starting the engine.



Do not reuse.  
Do not disassemble.  
Do not disassemble.

**DISASSEMBLY:**  
Do not remove the valve spring retainers while the lower crankcase is installed, or the valves will drop into the cylinder.

**REASSEMBLY:**  
Do not interchange with the exhaust valve.  
VALVE HEAD DIAMETER:

EXHAUST VALVE  
VALVE HEAD DIAMETER:  
EX: 12.5 mm (0.49 in)