

Cylinder Inspection

BEHN-033K214050029

Refer to "Cylinder Head Assembly / Cam Chain Guide / Cylinder Removal and Installation" (Page 1D-28).

Cylinder Distortion

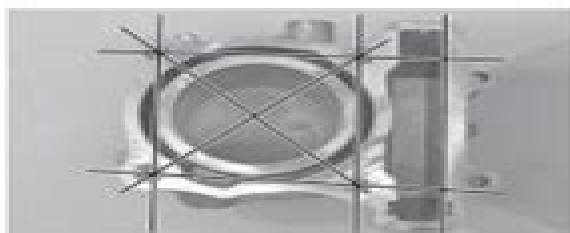
Check the gasket surface of the cylinder for distortion with a straightedge and thickness gauge, taking a clearance reading at several places as indicated. If the largest reading at any position of the straightedge exceeds the limit, replace the cylinder.

Special tool

09900-20803

Cylinder distortion

[Limit]: 0.05 mm (0.002 in)



IGT1207140100-02

Cylinder Bore

Check the cylinder wall for any scratches, nicks or other damage. Measure the cylinder bore diameter at six places.

Special tool

09900-20530

Cylinder bore

[Standard]: 62.000 – 62.015 mm (2.4410 – 2.4415 in)



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Piston Removal and Installation

BEHN-033K214050030

Refer to "Cylinder Head Assembly / Cam Chain Guide / Cylinder Removal and Installation" (Page 1D-28).

Removal

- 1) Place a clean rag over the cylinder base so as not to drop the piston pin circlip (1) into the crankcase.
- 2) Remove the piston pin circlip.

- 3) Draw out the piston pin (2) and remove the piston (3).



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Installation

- 1) When installing the piston, apply molybdenum oil solution onto the piston pin.

NOTE

When installing the piston, the indent (1) on the piston head must be faced to exhaust side.

"A": Assembly lubrication (Molybdenum oil solution)

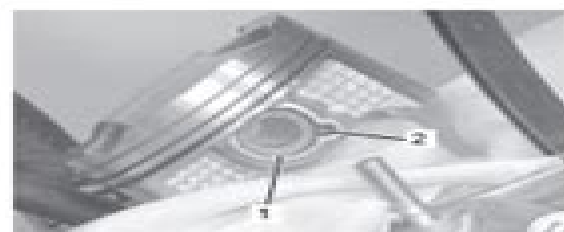


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- 2) Place a clean rag over the cylinder base so as not to drop the piston pin circlip (1) into the crankcase.
- 3) Install a new piston pin circlip.

NOTE

End gap of the circlip should not be aligned with the cutaway (2) in the piston pin bore.



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Zahn R150 Parts Manual

Engine Service Association

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