

Cylinder, Pistons

Cylinder Removal

• Remove:

- Cylinder Head (see *Cylinder Head Removal*(5-25))
- Front Engine Mounting Bolt (Both Sides) (A) (see *Engine Removal*(5-5))
- Front Engine Bracket (Both Sides) (B) (see *Engine Removal*(5-5))
- Cylinder (C)



Cylinder Installation

NOTE

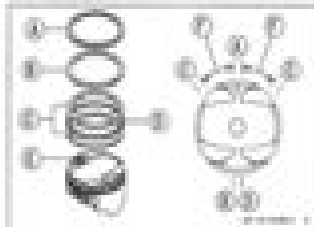
If a new cylinder is used, use new piston ring.

- Replace the cylinder gasket (A) with a new one.
- Install the dowel pins (B) and new cylinder gasket.



- The piston ring openings must be positioned as shown. The openings of the oil ring steel rails must be about 30 - 40° of angle from the opening of the top ring.

- Top Ring (A)
- Second Ring (B)
- Oil Ring Steel Rails (C)
- Oil Ring Expander (D)
- Dent (E)
- 30 - 40° (F)



- Apply molybdenum disulfide oil solution to the cylinder bore, piston rings and piston skirt.
- Prepare two auxiliary head bolts with their head out. Insert the two bolts (A) diagonally in the crankcase.
- Position the crankshaft so that all the piston heads are almost level.
- Install the cylinder block.
- Insert the piston rings with your thumbs.
- Install the removed parts.



Piston Removal

- Remove the cylinder (see *Cylinder Removal*(5-39)).
- Place a clean cloth under the pistons and remove the piston pin snap ring (A) from the outside of each piston.

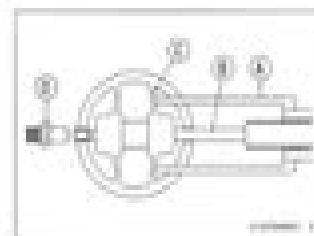


Cylinder, Pistons

- Remove the piston pins with the piston pin puller (A).
Center Bolt (B)
Shell of Piston (C)

Special Tools -Piston Pin Puller: S7501-1488
Piston Pin Puller Adapter, v12 (B): S7501-1487

- Remove the pistons.



- Carefully spread the ring opening with your thumbs and then push up on the opposite side of the ring (A) to remove it.
- Remove the 3-piece oil ring with your thumbs in the same manner.



Piston Installation

NOTE

If a new piston is used, use new piston ring.

- Apply molybdenum disulfide oil solution to the oil ring expander. Install the oil ring expander (A) in the bottom piston ring groove so the ends (B) butt together.
- Apply molybdenum disulfide oil solution to the oil ring steel rails, and install the oil ring steel rails, one above the expander and one below it.

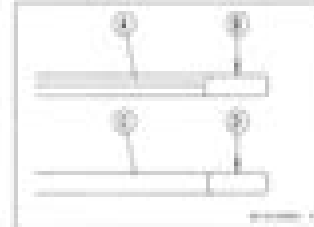
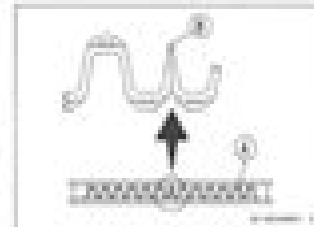
Oilspread the rail with your thumbs, but only enough to fit the rail over the piston.

Release the rail into the bottom piston ring groove.

NOTE

□ The oil ring rails have no "top" or "bottom".

- Apply molybdenum disulfide oil solution to the top and second rings.
- Do not rise up the top and second ring.
- Install the top ring (A) so that the "R" mark (B) faces up.
- Install the second ring (C) so that the "RM" mark (D) faces up.



Webtrons 650 Service Manual

Scott C. Dulebohn



Webtrons 650 Service Manual:

Mergent OTC Industrial Manual ,2003 *Paperboard Packaging* ,1977 **Modern Packaging** ,1967 FSM 650
Władysław Górny, Andrzej Hajnos, Henryk Okniński, Fabryka Samochodów Małolitrażowych, 1990

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