

---

---

---

---

---

---

---

---

---

## CYLINDER HEAD/CYLINDER/PISTON

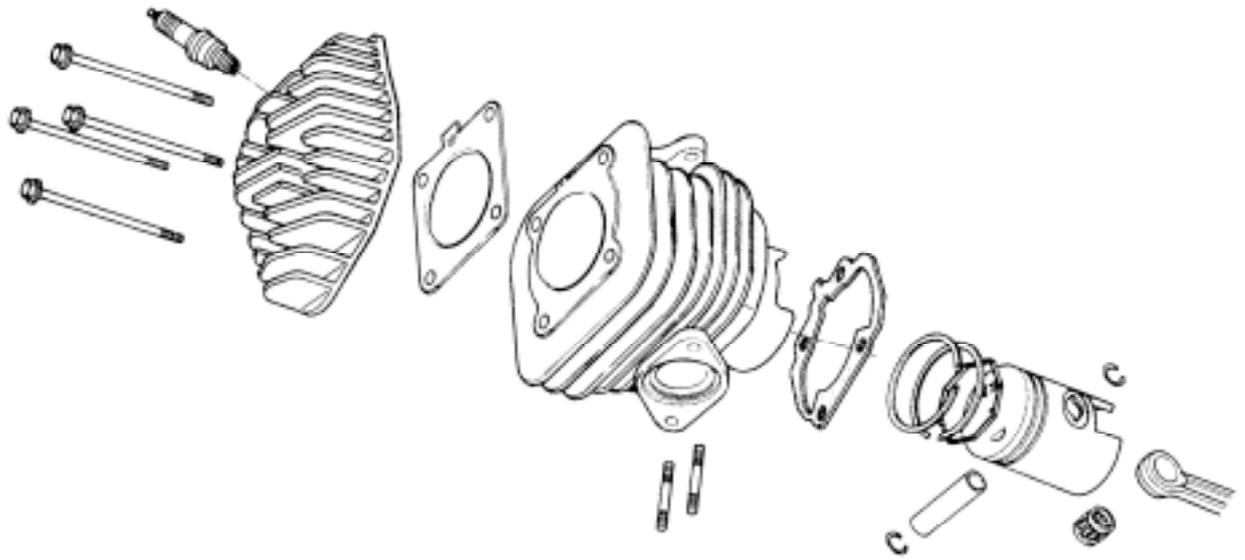
---

SERVICE INFORMATION -----	7-2
TROUBLESHOOTING -----	7-2
CYLINDER HEAD-----	7-3
CYLINDER/PISTON-----	7-6



**7. CYLINDER HEAD/CYLINDER/PISTON**

---



# 7. CYLINDER HEAD/CYLINDER/PISTON MX'er 50

## SERVICE INFORMATION

### GENERAL INSTRUCTIONS

- The cylinder head, cylinder and piston can be serviced with the engine installed in the frame.
- Before disassembly, clean the engine to prevent dust from entering the engine.
- Remove all gasket material from the mating surfaces.
- Do not use a driver to pry between the cylinder and cylinder head, cylinder and crankcase.
- Do not damage the cylinder inside and the piston surface.
- After disassembly, clean the removed parts before inspection. When assembling, apply the specified engine oil to movable parts.

Item	MX'er 50	
	Standard (mm)	Service Limit (mm)
Cylinder head warpage	□	0.10
Piston O.D.(5mm from bottom of piston)	38.970_ 38.955	38.90
Cylinder-to- piston clearance	0.03_ 0.07	0.10
Piston pin hole I.D.	12.002_ 12.008	12.03
Piston pin O.D.	11.994_ 12.0	11.98
Piston-to-piston pin clearance	0.002_ 0.014	0.03
Piston ring end gap (top/second)	0.10_ 0.25	0.40
Connecting rod small end I.D.	17.005_ 17.017	17.03
Cylinder bore	39.0_ 39.025	39.05

### TORQUE VALUES

Cylinder head bolt	1.5_ 1.7kg-m
Exhaust muffler joint lock nut	1.0_ 1.4kg-m
Exhaust muffler lock bolt	3.0_ 3.6kg-m
Spark plug	1.1_ 1.7kg-m

### °¥TROUBLESHOOTING

#### Compression too low, hard starting or poor performance at low speed

- Leaking cylinder head gasket
- Loose spark plug
- Worn, stuck or broken piston and piston rings
- Worn or damaged cylinder and piston

#### Compression too high, overheating or knocking

- Excessive carbon build-up in cylinder head or on piston head

#### Abnormal noisy piston

- Worn cylinder and piston
- Worn piston pin or piston pin hole
- Worn connecting rod small end bearing

#### Abnormal noisy piston rings

- Worn, stuck or broken piston rings
- Worn or damaged cylinder

# 7. CYLINDER HEAD/CYLINDER/PISTON MX'er 50

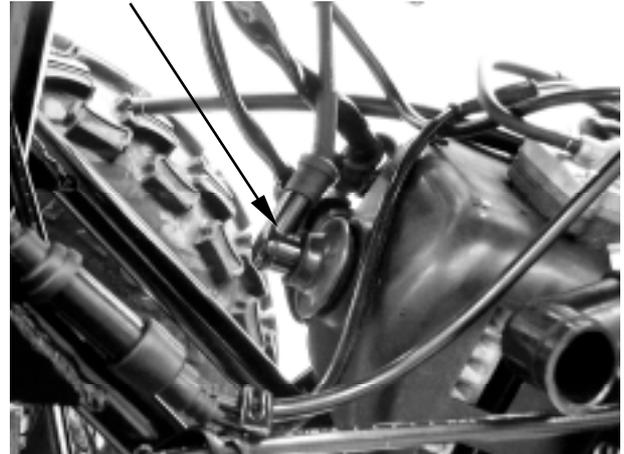
---

## CYLINDER HEAD

### REMOVAL

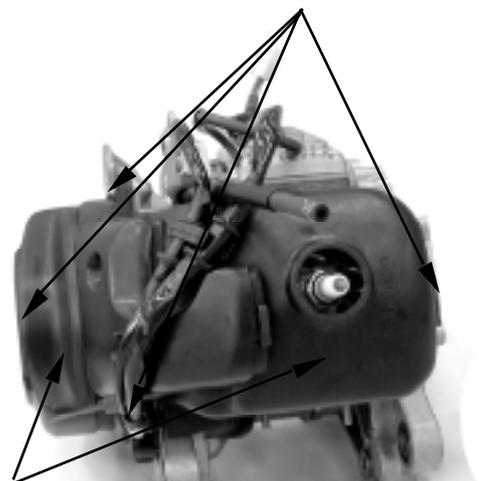
Remove the spark plug cap.  
Remove the exhaust muffler. (⇒2-5)

Spark Plug Cap



Remove the three bolts attaching the fan cover to remove the fan cover.  
Remove the bolt attaching the engine hood to remove the engine hood.  
The installation sequence is the reverse of removal.

Bolts



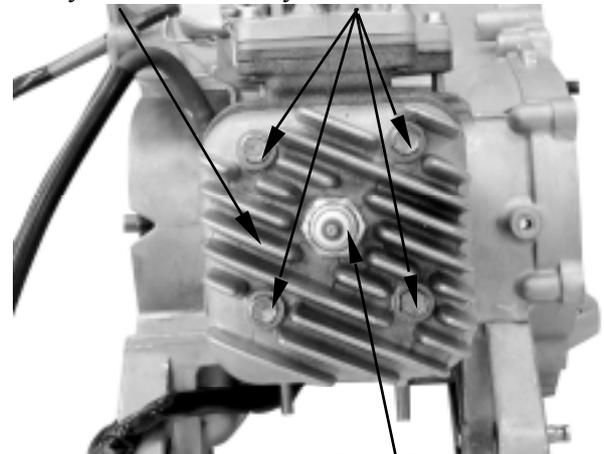
Fan Cover/Engine Hood

Remove the spark plug.  
Remove the cylinder head bolts and the cylinder head.

⚠ Loosen the bolts diagonally in 2 or 3 times.

Remove the cylinder head gasket.

Cylinder Head    Cylinder head Bolts



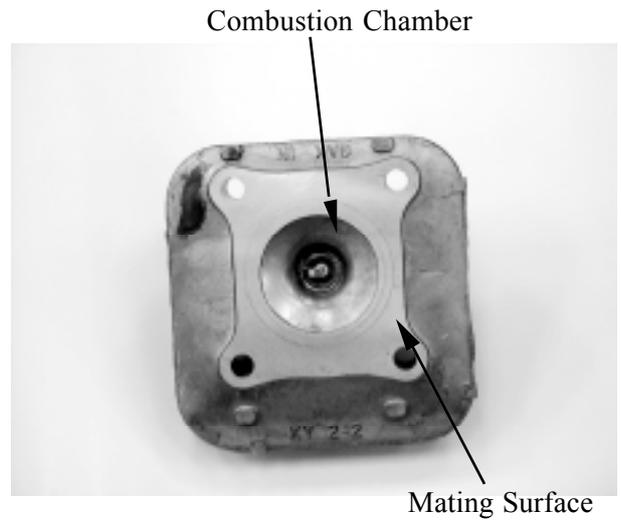
Spark Plug

## 7. CYLINDER HEAD/CYLINDER/PISTON MX'er 50

### COMBUSTION CHAMBER DECARBONIZING

Remove the carbon deposits from the combustion chamber

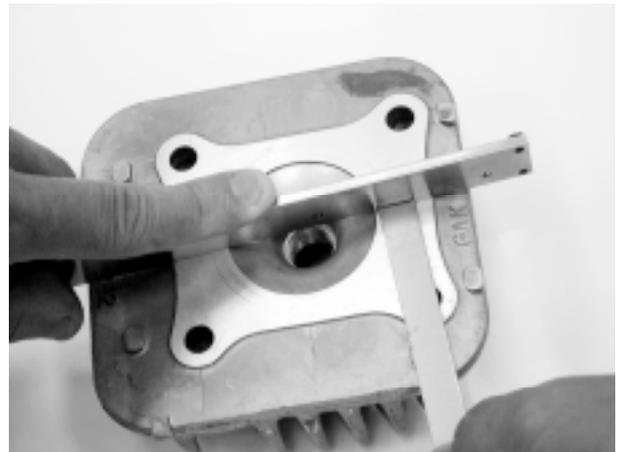
-  Avoid damaging the combustion chamber wall and cylinder mating surface.



### CYLINDER HEAD INSPECTION

Check the cylinder head for warpage with a straight edge and feeler gauge.

**Service Limit:** 0.10mm replace if over

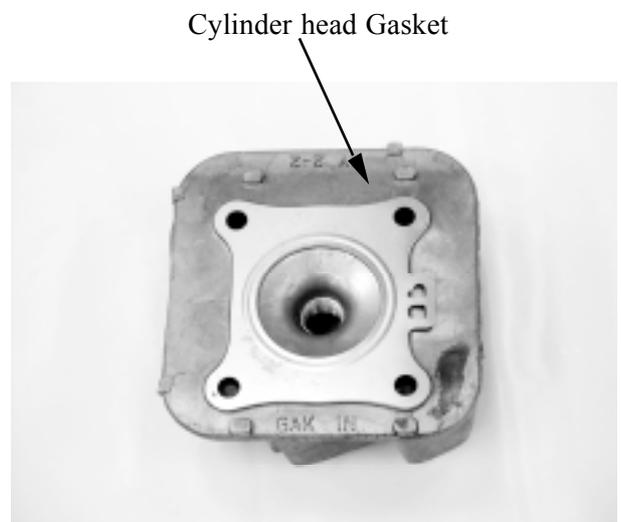


### CYLINDER HEAD INSTALLATION

Install the cylinder head on the cylinder properly.

-  Be careful not to damage the mating surfaces.

Install a new cylinder head gasket onto the cylinder.



## 7. CYLINDER HEAD/CYLINDER/PISTON

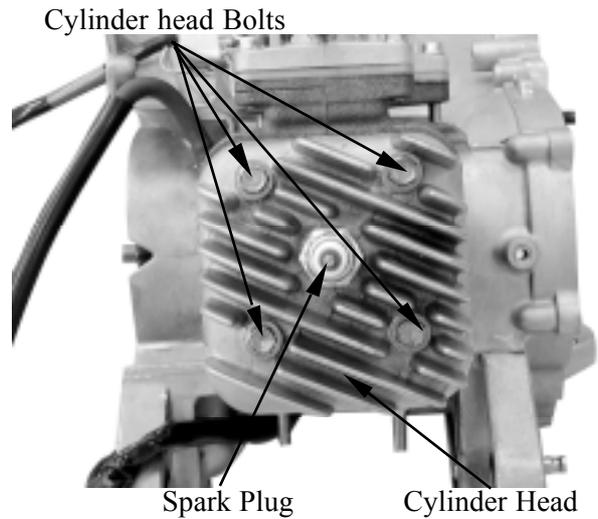
### Cylinder Head Bolts Installation

Install and tighten the cylinder head bolts diagonally in 2 or 3 times.

**Torque:** 1.5\_ 1.7kg-m

Install the spark plug.

**Torque:** 1.1\_ 1.7kg-m



### Engine Hood Installation

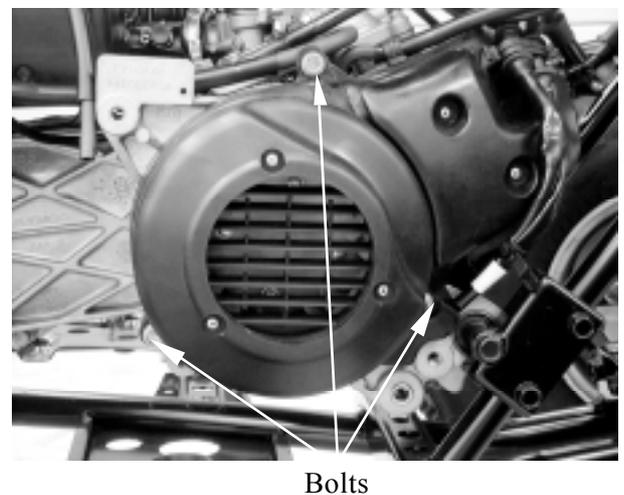
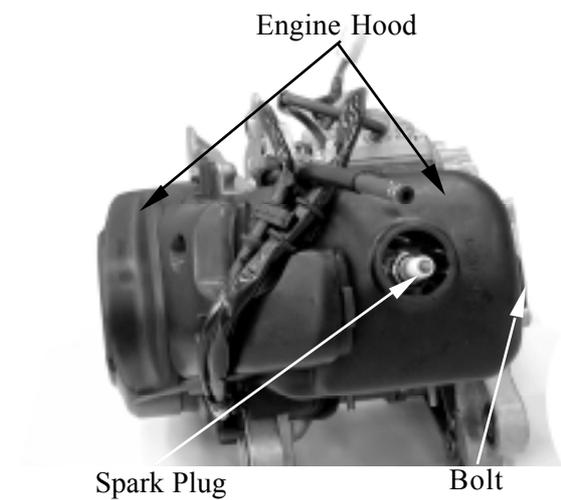
Install the engine hood. (⇒7-3)

Install the spark plug cap. (⇒7-3)

Install the exhaust muffler. (⇒7-3)

Perform the following inspections after installation:

- Compression test
- Abnormal engine noise
- Cylinder air leaks



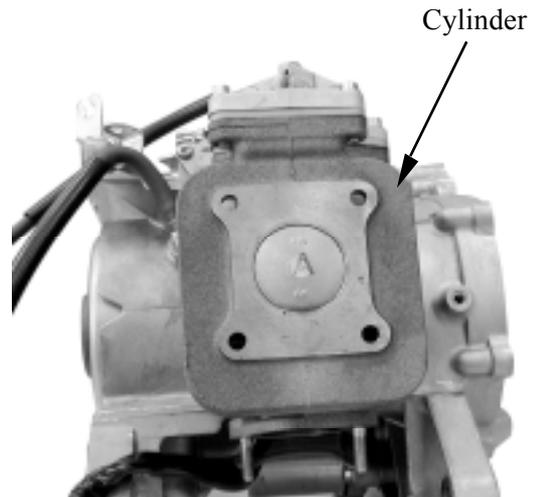
# 7. CYLINDER HEAD/CYLINDER/PISTON MX'er 50

## CYLINDER/PISTON

### CYLINDER REMOVAL

- Remove the cylinder head.
- Remove the cylinder.
- Remove the cylinder gasket.

⊘ Do not pry between the cylinder and crankcase or strike the fins.

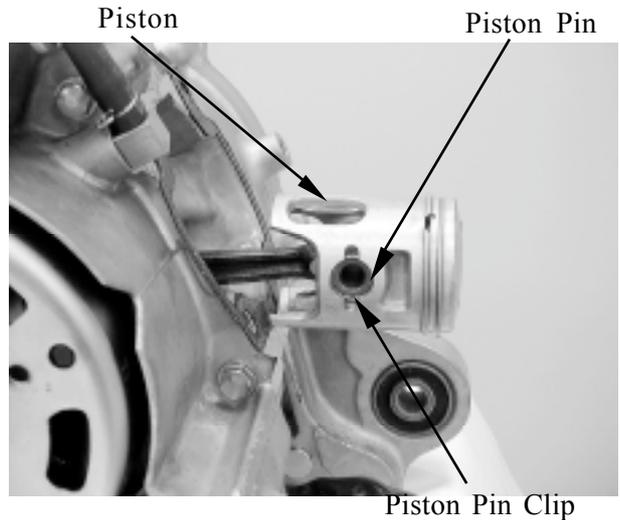


### PISTON REMOVAL

- Remove the piston pin clip to remove the piston pin and piston.

⊘

- Do not damage or scratch the piston.
- Do not apply side force to the connecting rod when removing the piston pin.
- Place clean shop towels in the crankcase to keep the piston pin clip from falling into the crankcase.



- Spread each piston ring and remove by lifting it up at a point just opposite the gap.
- Remove the expander.



# 7. CYLINDER HEAD/CYLINDER/PISTON MX'er 50

## CYLINDER/PISTON INSPECTION

Check the cylinder and piston for wear or damage.

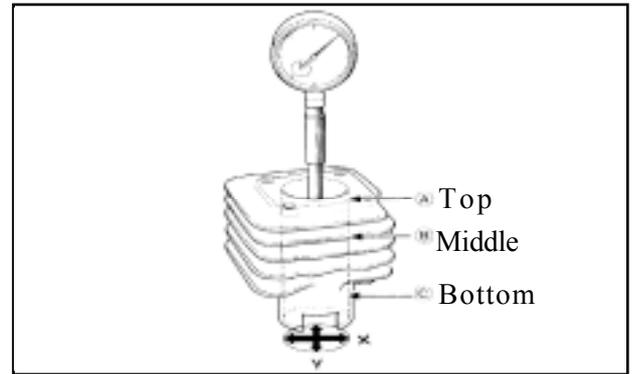
Clean carbon deposits from the exhaust port area.

- Be careful not to damage the cylinder inside wall.



Measure the cylinder bore at three levels of A, B and C in both X and Y directions. Avoid the port area. Take the maximum figure measured to determine the cylinder bore.

**Service Limit:** 39.05mm replace if over



Inspect the top of the cylinder for warpage.

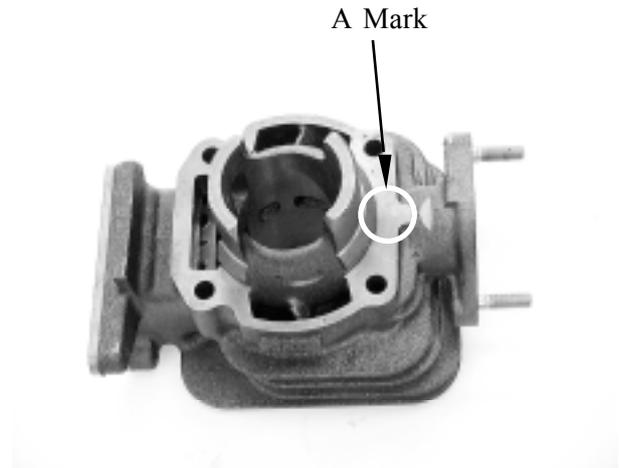
**Service Limit:** 0.10mm replace if over



# 7. CYLINDER HEAD/CYLINDER/PISTON MX'er 50

---

Ⓢ The cylinder has an “A” mark or no mark on it. When replacing the cylinder with a new one, use a cylinder having the same mark as the old one.



Measure the piston O.D. at a point 5mm from the bottom of the piston skirt.  
**Service Limit:** 38.90mm replace if below



Measure the piston-to-cylinder clearance.  
**Service Limit:** 0.10mm replace if over

Measure the piston pin hole I.D.  
**Service Limit:** 12.03mm replace if over

Measure the piston pin O.D.  
**Service Limit:** 11.98mm replace if below



Measure the piston-to-piston pin clearance.  
**Service Limit:** 0.03mm replace if over

# 7. CYLINDER HEAD/CYLINDER/PISTON MX'er 50

## PISTON RING INSPECTION

Measure each piston ring end gap.

**Service Limits:** Top/Second

0.40mm replace if over



Set each piston ring squarely into the cylinder using the piston and measure the end gap.



## CONNECTING ROD SMALL END INSPECTION

Install the piston pin and bearing in the connecting rod small end and check for excessive play.

Measure the connecting rod small end I.D.

**Service Limit:** 17.03mm replace if over



## PISTON/CYLINDER INSTALLATION

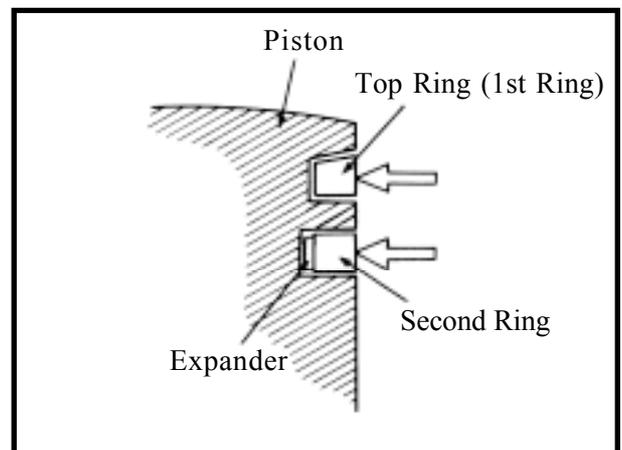
First install the expander in the second ring groove.

Then install the top and second rings in their respective ring grooves.

The piston rings should be pressed into the grooves with even force.

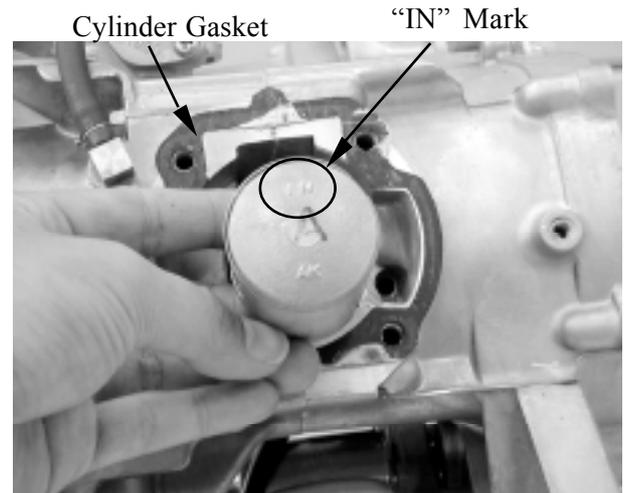
After installation, check and make sure that each ring is flush with the piston at several points around the ring.

A ring that will not compress means that the ring groove has carbon deposits in it and should be cleaned.



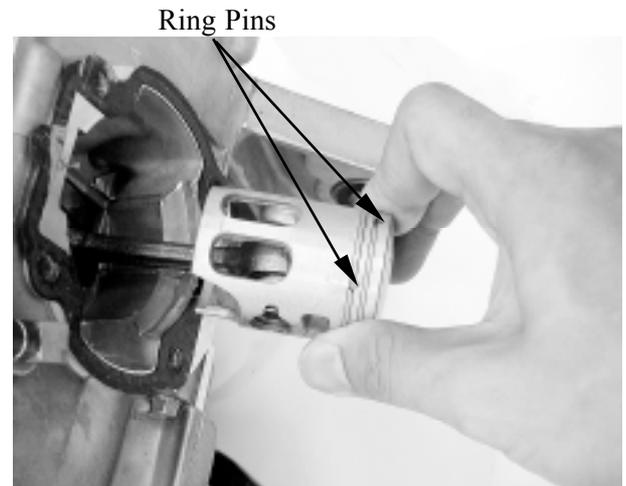
# 7. CYLINDER HEAD/CYLINDER/PISTON MX'er 50

Install a new cylinder gasket on the mating surface between the cylinder and crankcase. Position the piston "IN" mark on the intake valve side.



Make sure that the ring end gaps are aligned with the piston ring pins in the ring grooves. Lubricate the cylinder inside and piston rings with engine oil and install the piston into the cylinder while compressing the piston rings.

- Be careful not to damage the piston.



Install the cylinder head.

**Torque:** 1.5\_ 1.7kg-m

The installation sequence is the reverse of removal .

