**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.
- Space the oil ring side rail end gaps at least 10 mm (0.4 in) apart.
- Coat the oil ring with oil after assembly.

**TOP RING (CHROME FACE)**
- **SECOND RING (BLACK FACE)**
- **OIL RINGS (COMBINATION RINGS)**
- **SIDE RAIL SPACER SIDE RAIL**

**PISTON PIN**
- **12 x 24 x 5 mm OIL SEAL**
- **10 x 20 x 5 mm OIL SEAL**

**CRANKSHAFT/PISTON**
- **CARBURETOR SIDE**
- **12 x 24 x 5 mm OIL SEAL**
- **10 mm (0.4 in)**

**LOWER CRANKCASE**
- **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.

**CAM PULLEY/CRANKSHAFT**
- **TIMING BELT**
- **CAM PULLEY SHAFT**
- **HEAD COVER MATING SURFACE**
- **FLYWHEEL**
- **PISTON**

**LOWER CRANKCASE/CYLINDER BARREL/VALVES**
- **VALVE SPRING (2)**
- **VALVE STEM SEAL (Intake valve only)**
- **VALVE LIFTER (2)**
- **VALVE ROCKER ARM (2)**

**LOWER CRANKCASE**
- **VALVE SPRING RETAINER (2)**
- **DISASSEMBLY:**
  - Do not remove the valve spring retainers while the lower crankcase is installed, or the valves will drop into the cylinder.
- **SPARK PLUG CMR5H (NGK)**
- **CYLINDER BARREL**
- **EXHAUST VALVE REASSEMBLY:**
  - Do not interchange with the exhaust valve.
  - **VALVE HEAD DIAMETER: EX. 12.5 mm (0.49 in)**

**OIL FILLER CAP PACKING**
- **CARBURETOR SIDE**
- **TOP RING**
- **SECOND RING**
- **OIL RINGS**
- **"△" MARK**

**OIL SEAL**
- **10 x 20 x 5 mm**
- **12 x 24 x 5 mm**

**PISTON PIN**
- **10 mm (0.4 in)**

**OIL OUTLET VALVE**
- **STOPPER PLATE**

**OIL FILLER CAP**
- **OIL FILLER CAP PACKING**

**PISTON**
- **10 mm (0.4 in)**

**CRANKSHAFT**
- **12 x 24 x 5 mm OIL SEAL**
- **10 mm (0.4 in)**

**LOWER CRANKCASE**
- **12.3 x 2.4 mm O-RING**
- **WASHER (Serial number: GCAAM-1001494 ~)**
- **D12 TUBE CLIP (Color: Silver)**
- **D13 TUBE CLIP (Color: Gold)**

**OIL TUBE**
- **3.5 mm SCREW**
- **5 x 16 mm HEX BOLT (3)**
- **6.4 N·m (0.65 kgf·m, 4.7 lbf·ft)**
- **5 x 20 mm HEX BOLT (2)**
- **6.4 N·m (0.65 kgf·m, 4.7 lbf·ft)**

**LOWER CRANKCASE**
- **REASSEMBLY:**
  - Clean the inside of the crankcase and remove foreign material before reassembly.

**PISTON RING**
- **"•" MARK**
- **SECOND RING**
- **OIL RINGS (COMBINATION RINGS)**

**PISTON PIN**
- **10 mm (0.4 in)**

**CRANKSHAFT**
- **12 x 24 x 5 mm OIL SEAL**
- **10 mm (0.4 in)**

**CAM PULLEY**
- **ALIGNMENT MARKS**
- **HEAD COVER MATING SURFACE**

**CAM PULLEY SHAFT**
- **FLYWHEEL**

**FAN COVER BOLT HOLE**
- **ALIGNMENT MARK**

**PISTON**
- **10 mm (0.4 in)**

**CRANKSHAFT**
- **12 x 24 x 5 mm OIL SEAL**
- **10 mm (0.4 in)**

**LOWER CRANKCASE**
- **REASSEMBLY:**
  - Install with the "△" mark on the piston head facing the carburetor side.

**EXHAUST VALVE INTAKE VALVE REASSEMBLY:**
- Do not interchange with the exhaust valve.

**VALVE HEAD DIAMETER:**
- **EX: 12.5 mm (0.49 in)**

See the shop manual for additional information.
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