

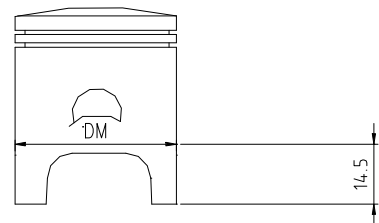
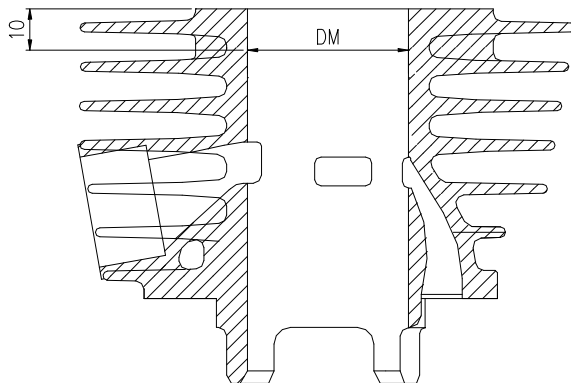
**ENGINE COMPONENT INSPECTION AND SERVICE****CYLINDER - PISTON TABLE**

| Part                   | Value (mm)                 |
|------------------------|----------------------------|
|                        | 50cc                       |
| Cylinder               | Ø 39                       |
| Piston                 | Ø 39                       |
| Piston rings :         |                            |
| 1)Piston ring 1st slot | Ø 39 x 2 - 0.01 - 0.025    |
| 2)Piston ring 2nd slot | Ø 39 x 1.25 - 0.01 - 0.025 |

## CYLINDER - PISTON ASSEMBLY SELECTION TABLE

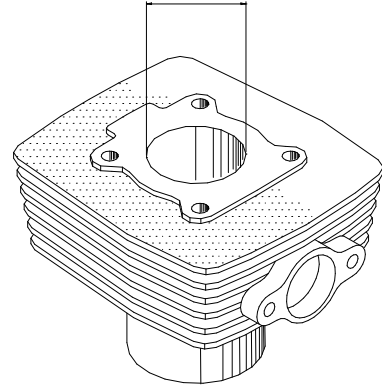
| SIZE CODE<br>(stamped on part) | CYLINDER - PISTON<br>DIMENSIONS    |                                    | ASSEMBLY<br>CLEARANCE |
|--------------------------------|------------------------------------|------------------------------------|-----------------------|
|                                | CYLINDER                           | PISTON                             |                       |
| A (RED)                        | $\varnothing 39^{+0,026}_{+0,021}$ | $\varnothing 39^{-0,036}_{-0,040}$ | 0.050-0.067<br>mm     |
| B (YELLOW)                     | $\varnothing 39^{+0,020}_{+0,016}$ | $\varnothing 39^{-0,041}_{-0,046}$ |                       |
| C<br>(NEUTRAL)                 | $\varnothing 39^{+0,015}_{+0,010}$ | $\varnothing 39^{-0,047}_{-0,052}$ |                       |
| D (GREEN)                      | $\varnothing 39^{+0,009}_{+0,004}$ | $\varnothing 39^{-0,053}_{-0,058}$ |                       |

### CHECK POSITION For correct dimension control



### CYLINDER CHECK

- Check the internal surface of the cylinder for signs of seizure or abnormal wear.
- Measure the internal diameter of the cylinder using a bore gauge.
- Wear limit: Minimum indicated cylinder selection diameter + 0.03mm.**
- Take measurements in three different positions along the axis of the cylinder.
- In each position take two measurements, one parallel with and the other perpendicular to the crankshaft axis.



### PISTON CHECK

- Remove the piston rings and check the piston for abnormal signs and wear.

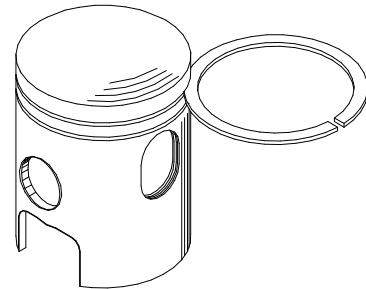
**N.B.**

The piston rings are fragile, handle with care.



### RING-TO-GROOVE MEASUREMENT.

**Wear limit: 0,08 mm max.**



### PISTON BORE MEASUREMENT.

- Maximum permitted diameter:  $12 + 0,18$  mm
- Measure the piston outside diameter in the direction perpendicular to the piston axis at **14,5 mm** from the skirt.

