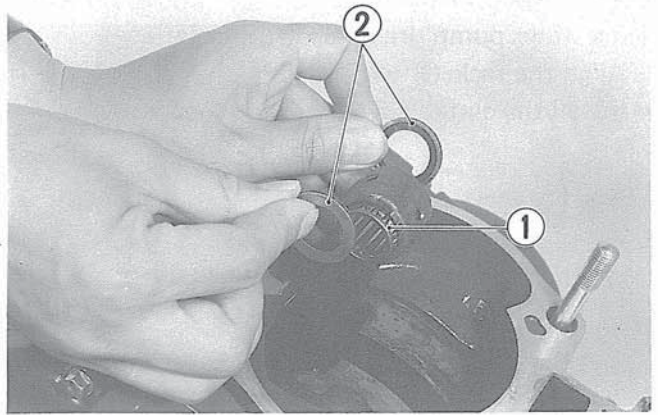
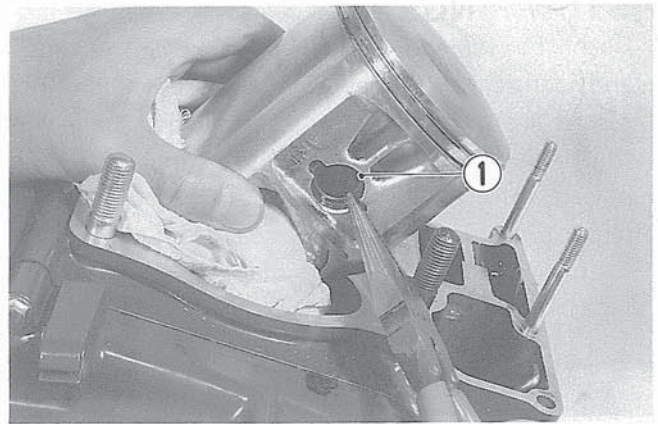


- Install the bearing ① and the two thrust washers ②.



- The circlip should be mounted in such a position ① that the matching ends of the circlip do not coincide with the groove portion of the piston.
- Before inserting the piston in the cylinder, be sure to apply SUZUKI CCI SUPER 2-CYCLE Oil or SUZUKI CCI Oil or two-stroke oil to the outer surface of the piston and piston ring grooves.

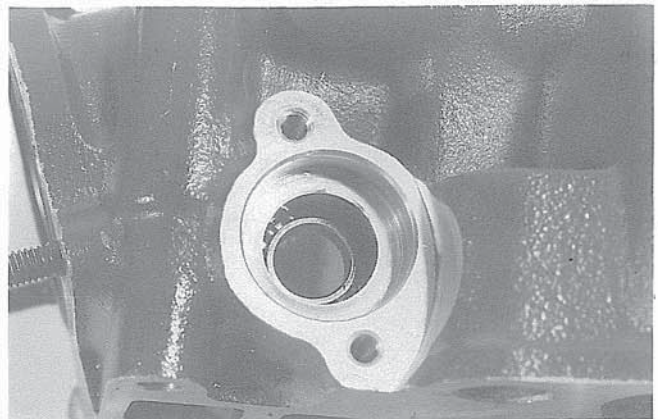
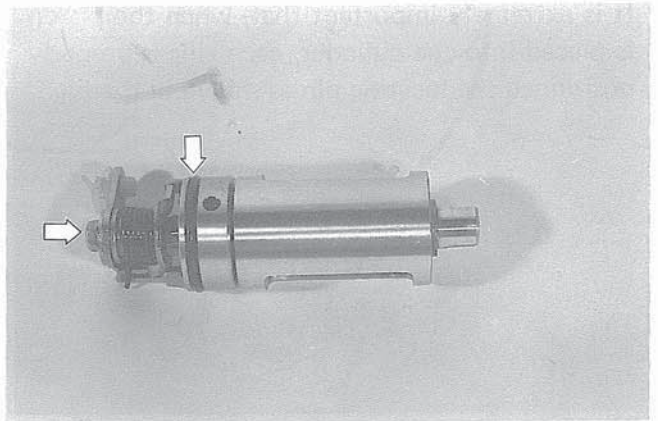


## EXHAUST VALVE

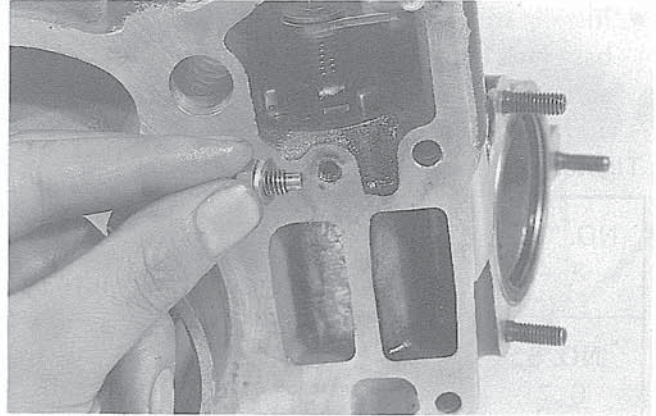
- Apply a small quantity of THREAD LOCK SUPER "1303" to the exhaust valve bolt and tighten it.

99000-32030	THREAD LOCK SUPER "1303"
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- Replace the O-ring with a new one.
- Lubricate the exhaust valve bearing with SUZUKI CCI Oil or two-stroke oil.



- Fit a new gasket onto the exhaust valve stopper bolt, and install the exhaust valve stopper bolt.

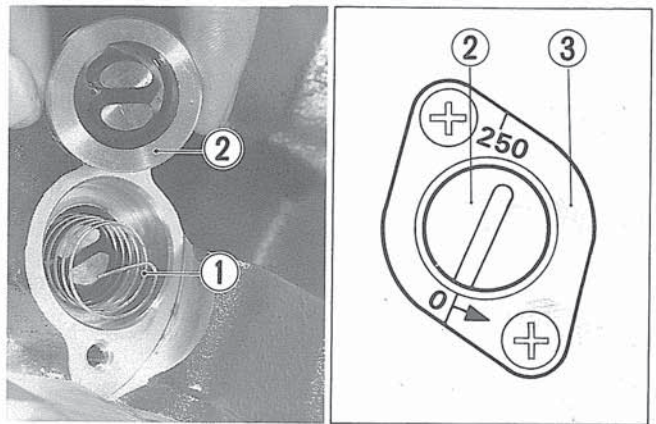


- Set the spring ①, cap ② and cap retainer ③.

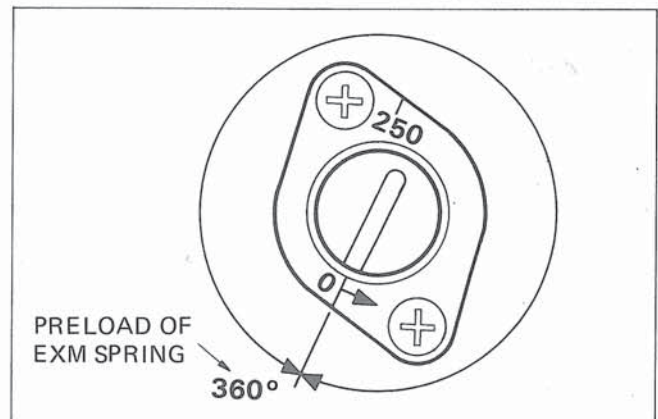
**NOTE:**

*Do not tighten the cap retainer screws at this stage.*

*Be sure that the mark "250" of the cup retainer is at the top.*

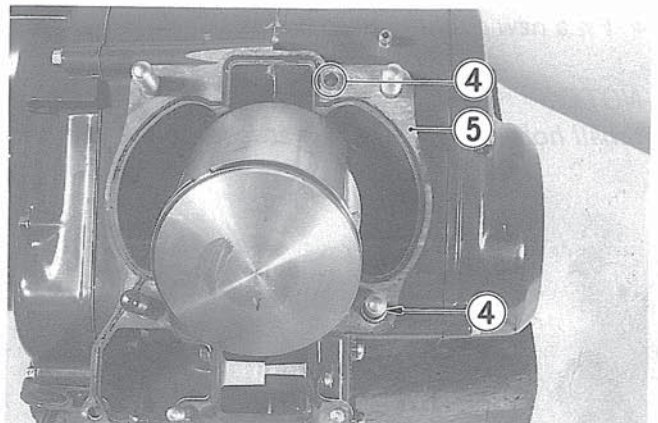


- Turn the cap ② counterclockwise 360 deg and tighten the screws.



## CYLINDER

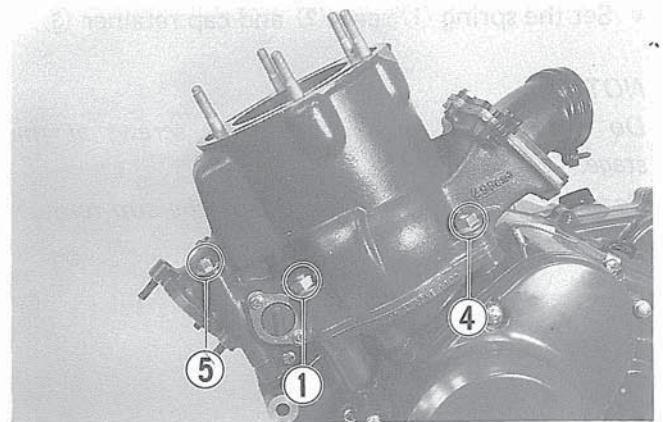
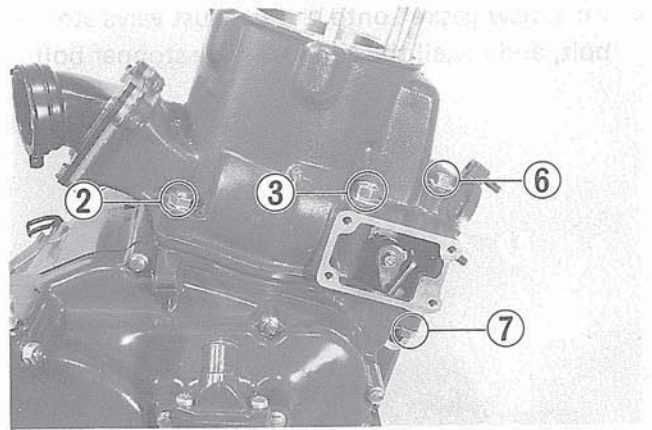
- Fit the two dowel pins ④ and a new cylinder base gasket ⑤ over the cylinder base.



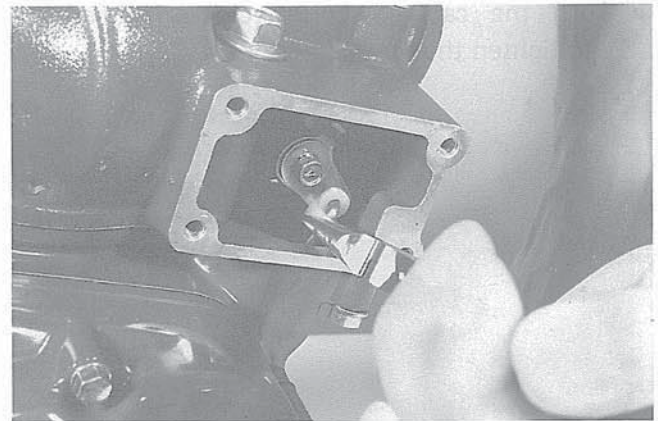
- Install the cylinder and tighten the cylinder base nuts and bolts to the specified torque in the ascending order of numbers indicated in Fig.

#### Tightening torque

NO. 1, 2, 3, 4	10 mm	36 – 40 N·m ( 3.6 – 4.0 kg·m ) ( 26.0 – 29.0 lb·ft )
NO. 5, 6, 7	6 mm	8 – 12 N·m ( 0.8 – 1.2 kg·m ) ( 6.0 – 8.5 lb·ft )



- Connect the exhaust valve rod to the exhaust valve lever by hooking the clip with a long-nose pliers.



- Fit a new cylinder head gasket.

#### NOTE:

*Small holes slide of the gasket faces to the exhaust.*

