

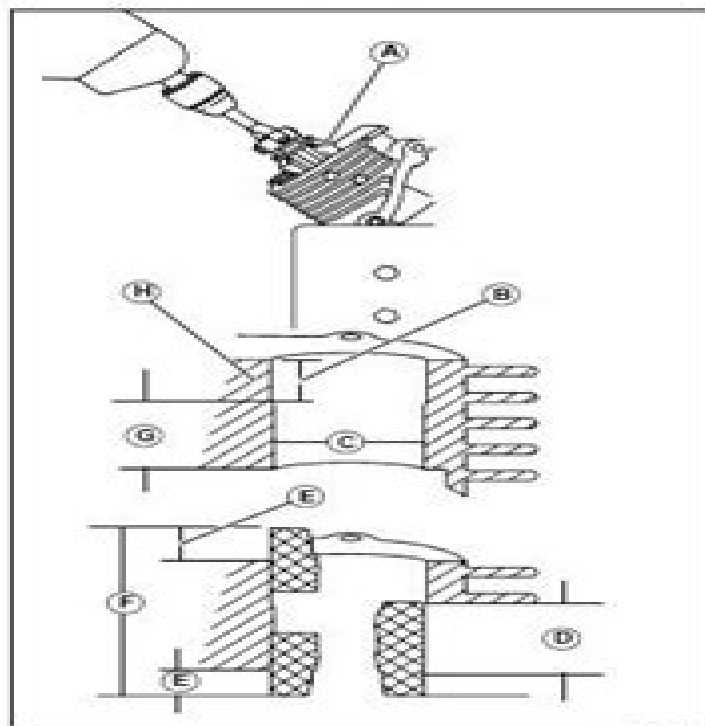
When there is no trace of honing grit on rag, the cylinder is properly cleaned. Then oil cylinder bore to prevent rusting.

## Resizing Cylinder Bore

### Procedure:

1. If the cylinder bore is not within specifications, it will have to be resized using a boring bar or hone. Always resize to exactly 0.51 mm (0.020 in.) over standard size.
2. If this is done accurately, the service oversize rings and pistons will fit correctly and proper clearances will be maintained.

**Important: Avoid Damage!** If a boring bar is used, a hone must be used after the boring operation to produce the proper cylinder cross hatch. See "Cylinder Bore Honing" above.



3. If a hone is used to resize the cylinder bore, place hone (A) in middle of cylinder bore (C). Tighten adjusting knob with finger until stones fit snugly against cylinder wall. DO

### NOT FORCE.

4. Connect drive shaft to hone. Be sure that cylinder and hone are centered and aligned with drive shaft and drill spindle. Lubricate hone as recommended by hone manufacturer.
5. The recommended drill speed is 300 to 700 rpm maximum and 40 - 60 strokes per minute.
6. Because cylinder bores normally wear (H) only in the area of ring travel (B), the cylinder bore will be round above and below ring travel (G).
7. Start drill and, as hone spins, move it up and down at the bottom of the cylinder bore (D).
8. Gradually increase the length of the strokes until hone travels full length of cylinder bore (F). Do not travel more than 19.05 mm (0.750 in.) to 25.4 mm (1.0 in.) above cylinder bore (E).
9. Lubricate hone frequently to prevent build up on stones.
10. As cutting tension decreases, stop hone and tighten adjusting knob following hone manufacturer's recommendations.
11. Check cylinder bore size frequently.
12. Check cylinder bores at top and bottom for burrs. Remove burrs. Cylinder head and crankcase cover surfaces must be free of burrs and gasket material.
13. After cylinder bore has been brought to proper resizing dimension, a cross hatch must be applied to bore.

### Specifications:

Standard Bore Size ..... 79.25 mm (3.120 in.)  
Oversize Bore..... 79.36 mm (3.122 in.)

## Flywheel Removal and Installation

### Equipment:

- Flywheel Tool (part number 19203)

### Procedure:

1. Remove blower housing and rotating screen.
2. Remove two screws securing fan. Remove fan.
3. Loosen ignition coil screws and move ignition coils away from flywheel, or remove ignition coils completely.

**Note:** If the engine crankshaft rotates while loosening the flywheel nut, secure the flywheel with a strap wrench.

4. Use an impact wrench and 32 mm (1-1/4 in.) socket to loosen flywheel nut. Do not remove at this time.
5. Unscrew nut until it extends just beyond engine input shaft threads.

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**Marcel A. Müller**



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