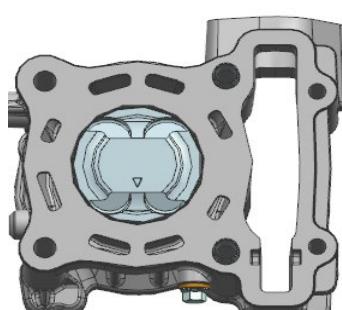
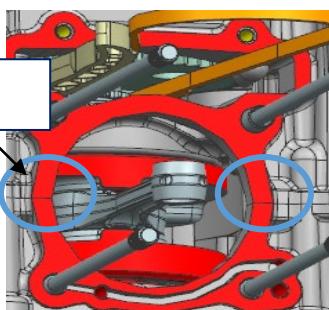


②the opening of the piston pin retaining ring should avoid the opening of the retaining ring groove by more than 90°.

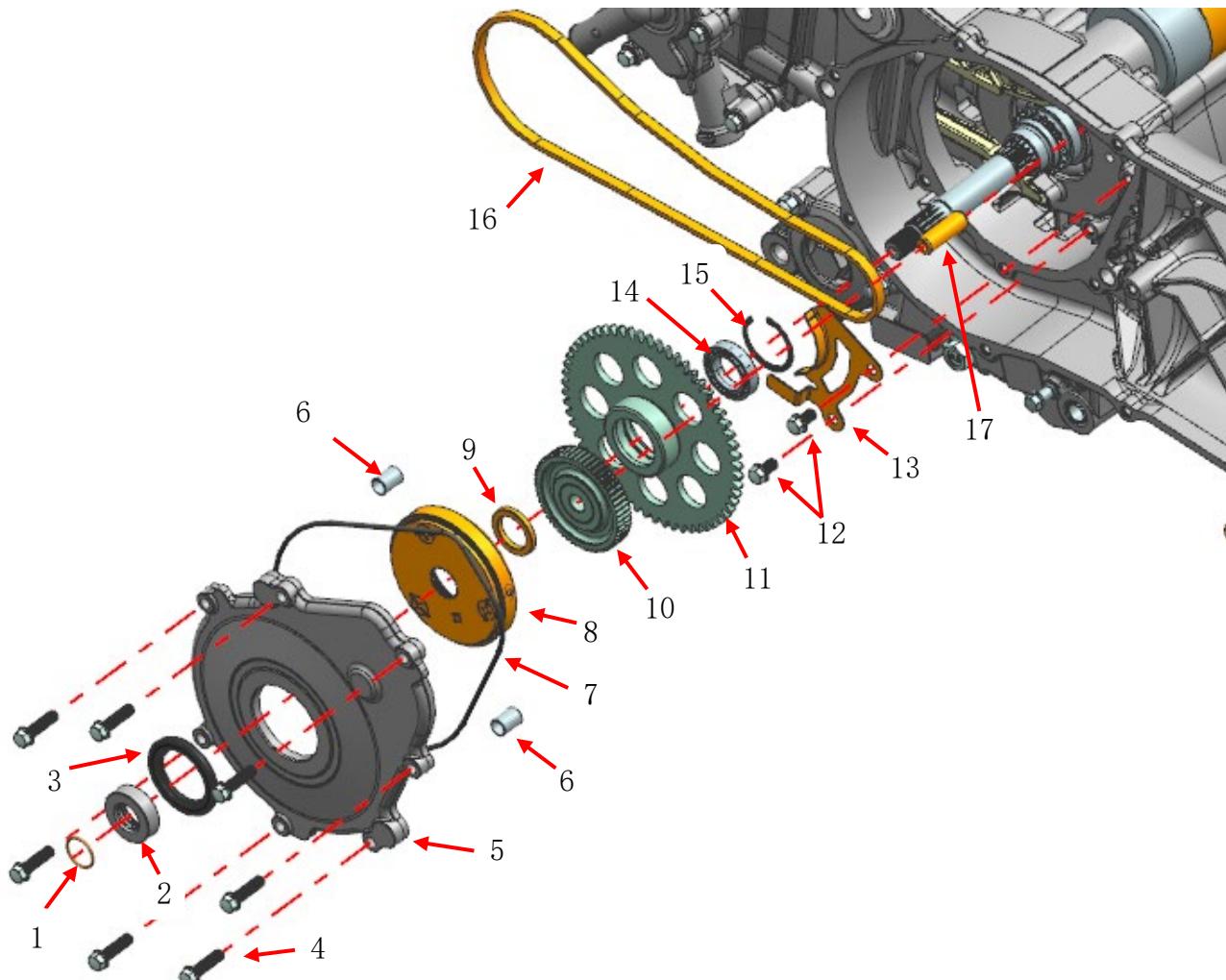
③piston pin retaining ring is installed in place.

④the direction of the arrow on the top of the piston points to the exhaust side, do not install it backwards.



Electric starter box cover, starter mechanism, timing chain

System components



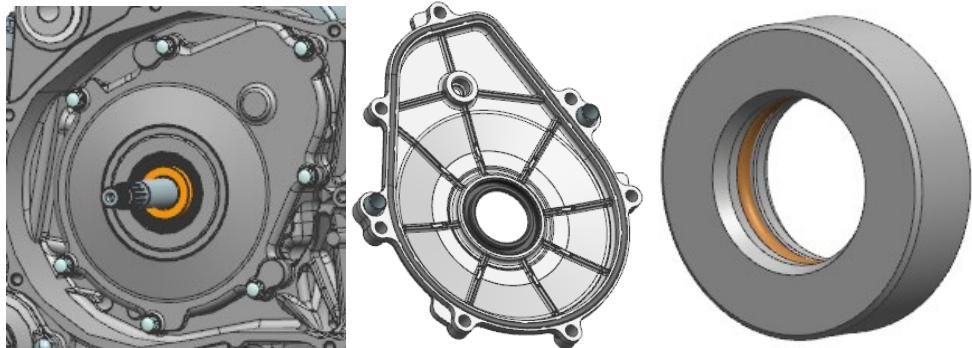
No.	Material name	Quantity	Remark
1	15.6×1.9 fluorine rubber O-ring	1	
2	Φ 16×φ30×9 bushing	1	
3	Fb30×45×5 fluorine rubber oil seal	1	
4	M6×22 hex flange bolts	7	Tool: t-sleeve-8# fixed torque: 12±1.5 N.m
5	ZT1P58MJ electric starter box cover	1	
6	Φ 10×14 hollow positioning pin	2	

7	151×3 acrylic glue O-ring	1	
8	Cg-78h overrunning clutch	1	
9	Φ19.4 ×φ27.8×3.6 bushing	1	
10	ZT1P58MJ electric starter reduction gear assembly	1	
11	ZT1P58MJ electric starter large gear assembly	1	
12	M6×10 top pin bolt	2	Tool: t-sleeve-8#. Apply thread glue, fixed torque: 12±1.5 N.m
13	ZT1P58MJ guide bar pressure plate	1	
14	Gb276-6804/p5c3 deep groove ball bearings	1	
15	Circlip for non-standard holes φ 32×1.2	1	
16	6.35×5×96 toothed chain	1	
17	ZT1P58MJ electric starter reduction gear shaft	1	

Electric starter box cover

Assembly

1. Use a t-shaped sleeve -8# to remove the locking bolt of the electric starter box cover, and take out the electric starter box cover, $\phi 16 \times \phi 30 \times 9$ bushing , 15.6×1.9 fluorine rubber O-ring , and positioning pin.

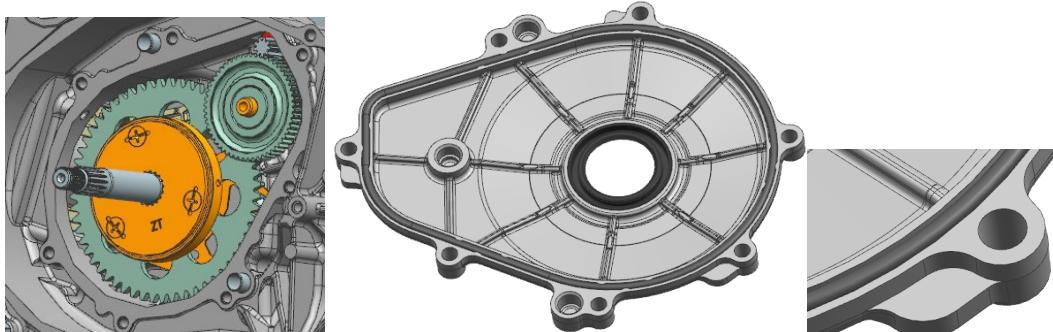


Inspection

1. Check the electric starter box cover oil seal, 151×3 acrylate rubber O-ring , $\phi 16 \times \phi 30 \times 9$ bushing outer ring, 15.6×1.9 fluorine rubber O-ring without scratches or damage, and replace if scratched or damaged .

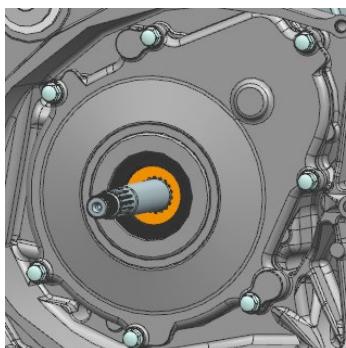
Install

1. Install the positioning pin on the corresponding position of the left box, and place the 151×3 acrylic glue O-ring on the corresponding position of the electric starter box cover groove.



2. Install the electric starter box cover to the corresponding position, put in 7 m6×22 hexagon flange bolts, pretighten diagonally from the positioning pin hole, and the fixed torque is 12 ± 1.5 N.m. Put the $\phi 16 \times \phi 30 \times 9$ bushing with 15.6×1.9 fluorine rubber

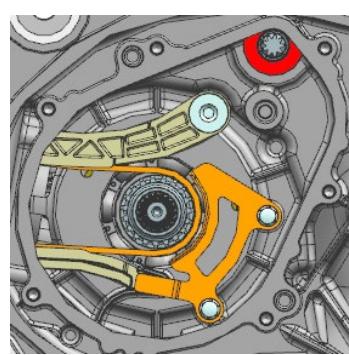
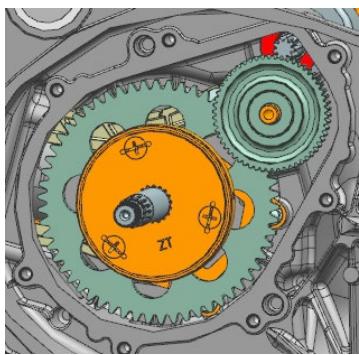
O-ring into the crankshaft and push it in place, and check that there is no misalignment of the oil seal dust lip of the electric starter case cover.



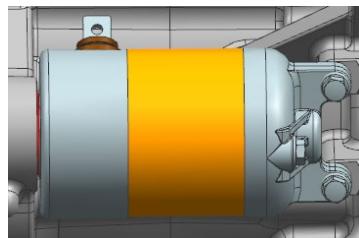
Start agency

Assembly

1. take out ZT1P58MJ electric starter reduction gear assembly, ZT1P58MJ electric starter reduction gear shaft, CG-78H overrunning clutch, $\phi 19.4 \times \phi 27.8 \times 3.6$ bushing, ZT1P58MJ electric starter large gear press-fit assembly.



2. Use t-shaped sleeve -8# to remove the starter motor locking bolt and remove the starter motor.



Inspection

1. Check that the deceleration gear, deceleration gear shaft, overrunning clutch, electric starter large gear bearing, etc. Have no abnormal wear.

Install

1. Install the ZT1P58MJ electric starter gear assembly, $\phi 19.4 \times \phi 27.8 \times 3.6$ bushing, cg-78h overrunning clutch, ZT1P58MJ electric starter reduction gear shaft, and ZT1P58MJ electric starter reduction gear assembly in order. (note: $\phi 19.4 \times \phi 27.8 \times 3.6$ bushings cannot be missing, and the reduction gear shaft, overrunning clutch rollers and starting large tooth bearings need to be coated with engine oil.)

2. Check the O-ring of the starter motor for no cracks or trimmed edges. After the starter motor is installed in place, put in 2 m6×22 bolts, tighten and set the torque. Torque: 12 ± 1.5 N.m.

Timing chain

Assembly

1. Use a t-shaped sleeve -8# to remove the bolts of the guide strip pressure plate, take out the guide strip pressure plate, and remove the timing chain (6.35×5×96 toothed chain).