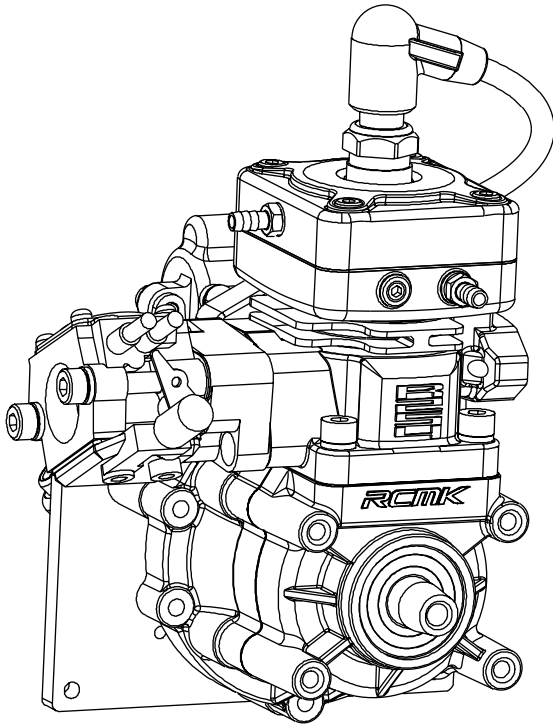


HIGH PERFORMANCE  
Model Gas Engine  
**S254**  
Evolution Version  
Reverse Rotation



Engine Features

- 4 bearings crank case
- 6001 standard bearing for crankshaft
- Stronger crankshaft and connecting rod
- Walbro WT-929 carburetor
- Modified piston
- Water cooling cylinder
- Start pulley

**WARNING**



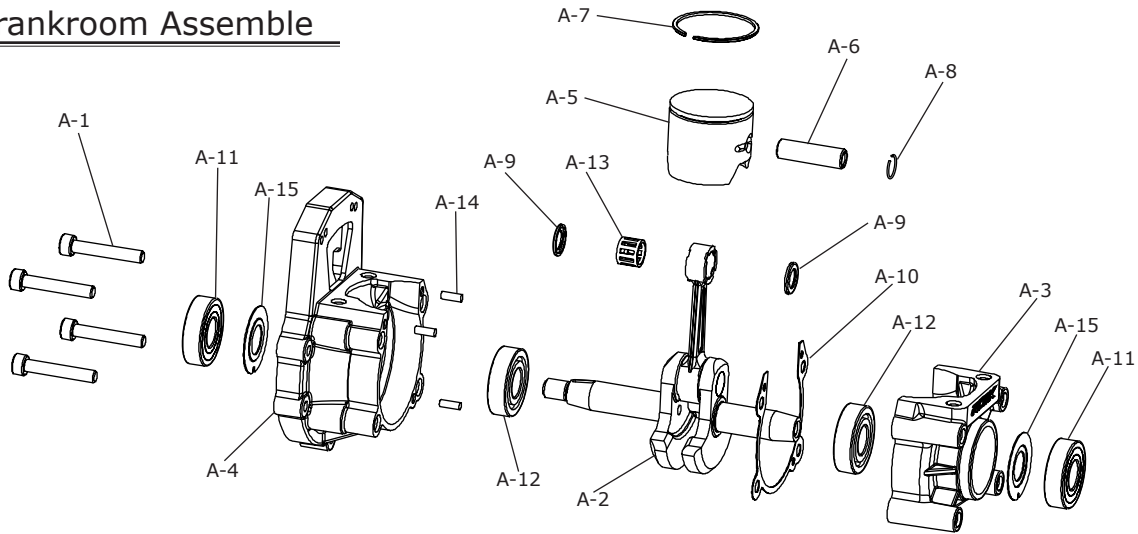
Model Gas Engine **S254-R**  
[www.rcmk.com](http://www.rcmk.com)

- Before use engine, read description necessarily.
- This engine is designed and made for use on model boat. So we recommend to use on model boat
- Use genuine parts for replacement.
- Check the bolts fixation condition of engine every time. If the bolts are loosed, fix the loosed bolt, and after check once again.

**Assembly Method**



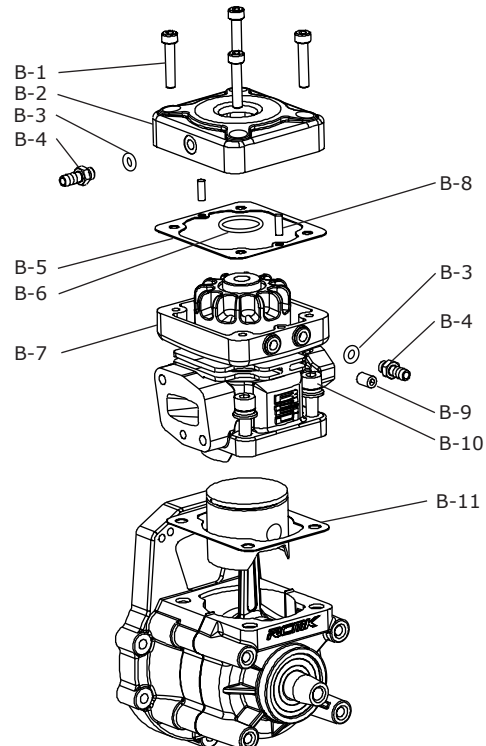
**A. Crankroom Assemble**



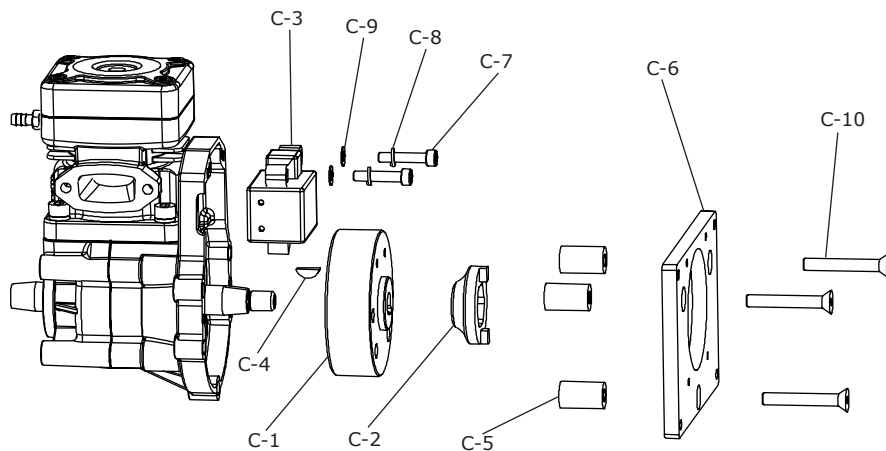
Key	Part Number	Description	Q'TY	Key	Part Number	Description	Q'TY
A-1	-	Bolt M5 X 30	4	A-9	0207000012	Wrist Pin Bearing Spacer	2
A-2	0207000039	Crank assembly - R	1	A-10	0207000064	S254 Gasket for Crankcase	1
A-3	0207000068	S254 crankcase - R front	1	A-11	3703000004	Bearing 6001JRXLLU	2
A-4	0207000068	S254 crankcase - R rear	1	A-12	3703000003	Bearing 6001C3	2
A-5	0207000072	S254 Piston - R	1	A-13	3704000001	Needle roller bearing KT 8 11 10	1
A-6	0207000006	Piston pin	1	A-14	0207000027	Pin 3P x 5	3
A-7	0207000025	Piston Ring	1	A-15	0207000071	Brass oil plate	2
A-8	0207000028	Snap-ring C type	1				

**B. Cylinder Assemble**

Key	Part Number	Description	Q'TY
B-1	-	Bolt M4 x 20	4
B-2	0207000076	R254 evolution Cylinder Cap	1
B-3	4602000004	O-ring P4	2
B-4	0403000002	Fitting M5	2
B-5	0207000032	R254 Gasket for Cylinder Head	1
B-6	4602000006	O-ring 16 x 2	1
B-7	0207000075	R254 evolution Cylinder	1
B-8	0207000027	Pin 3P x 5	2
B-9	-	Set screw M5 x 8	1
B-10	-	Bolt M5 x 17	4
B-11	0207000031	R254 Gasket for Cylinder	1

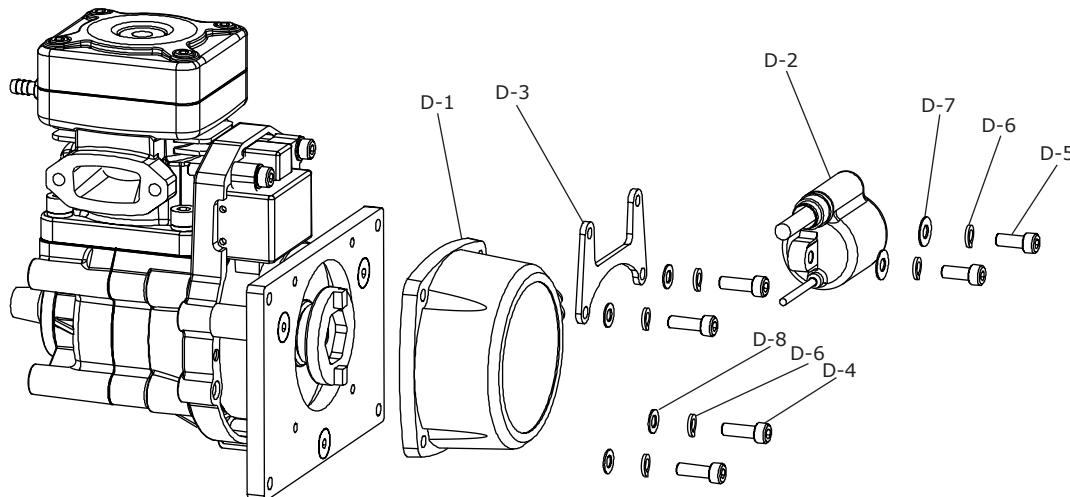


### C. Rotor Assemble



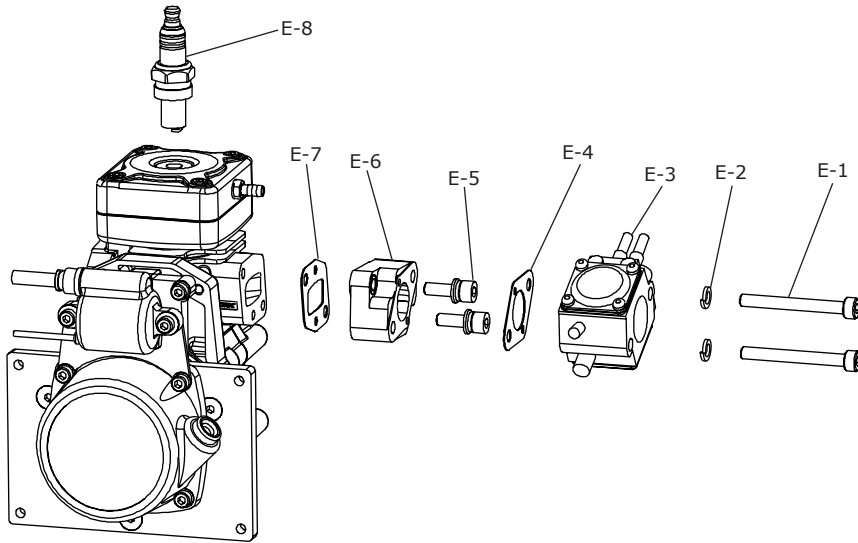
Key	Part Number	Description	Q'TY	Key	Part Number	Description	Q'TY
C-1	0207000069	S254 Rotor -R	1	C-6	-	Mount (Not include)	1
C-2	0207000084	Starter pulley nut2 - R	1	C-7	-	Bolt M4 X 20	2
C-3	0207000010	R254 Source coil	1	C-8	-	Spring washer P4	2
C-4	0207000024	Woodruff key	1	C-9	-	Washer P4	2
C-5	0207000058	S254 Crankcase washer	3	C-10	-	Bolt M5 X 35	3

### D. Pulley Assemble



Key	Part Number	Description	Q'TY	Key	Part Number	Description	Q'TY
D-1	0207000048	Recoil Starter - R	1	D-5	-	Bolt M4 X 10	2
D-2	0207000011	R254 Ignition coil	1	D-6	-	Spring washer P4	6
D-3	0204000006	Ignition plate 2	1	D-7	-	Washer P4	2
D-4	-	Bolt M4 X 12	4	D-8	-	Washer P4 (small)	4

E. Caburator Assemble



Key	Part Number	Description	Q'TY	Key	Part Number	Description	Q'TY
E-1	-	Bolt M5 x 45	2	E-5	-	Bolt M5 X 20	2
E-2	-	Spring Washer P5	2	E-6	0207000016	R254 Insulator block	1
E-3	4001000002	Carburator WT-929	1	E-7	0207000034	R254 Gasket for Insulator	1
E-4	0207000030	R254 Gasket for Carburator	1	E-8	4801000001	Spark Plug - CMR7H	1