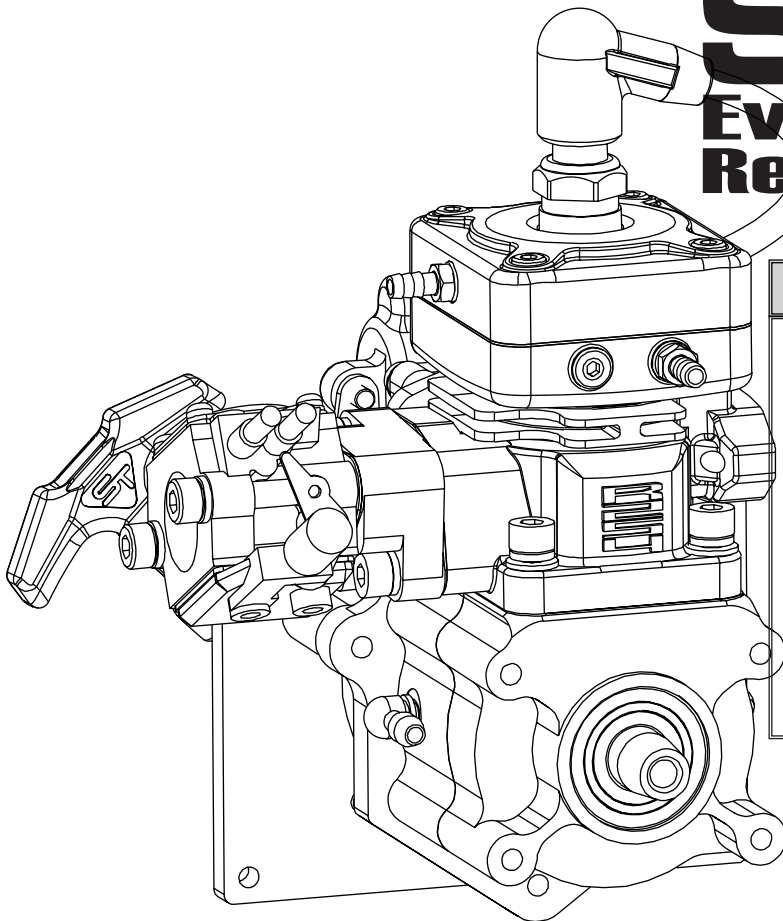


HIGH PERFORMANCE  
Model Gas Engine  
**SX254**  
Evolution Version  
Reverse Rotation



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**



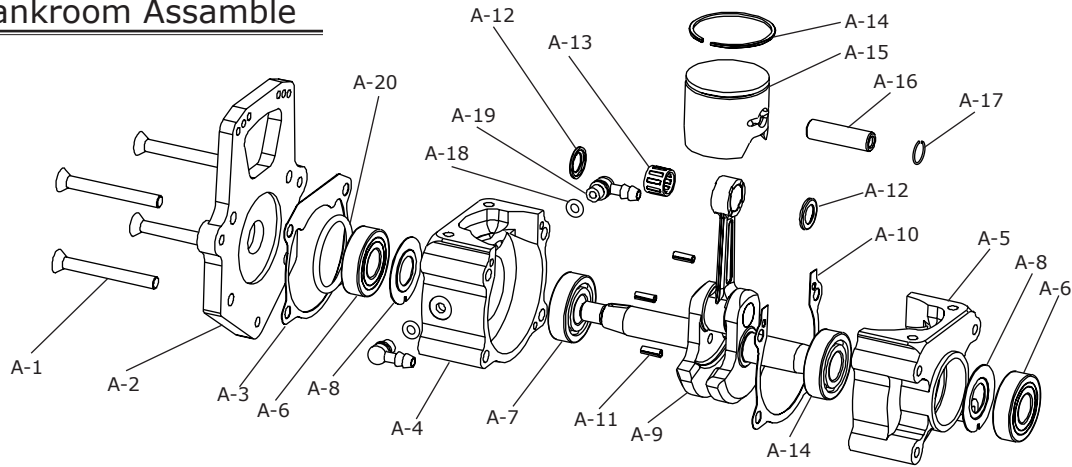
Model Gas Engine **SX254**  
[www.rcmk.com](http://www.rcmk.com)

- 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**



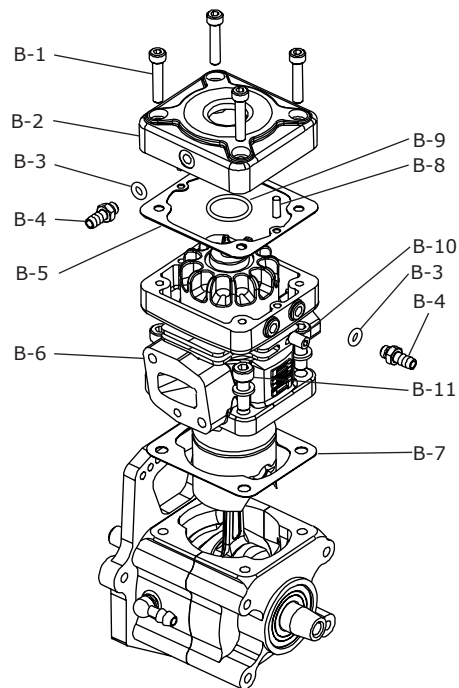
A. Crankroom Assamble



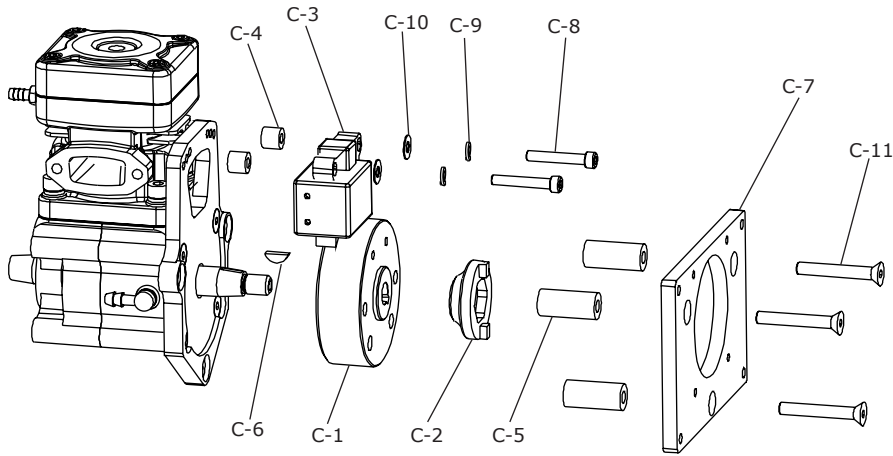
Key	Part Number	Description	Q'TY	Key	Part Number	Description	Q'TY
A-1	-	Bolt M5 X 45	4	A-11	0207000027	Pin 3P x 8	3
A-2	0207000050	SX254 Source coil mount	1	A-12	0207000012	Wrist Pin Bearing Spacer	2
A-3	0207000054	SX254 Gasket for crankcase cooler	1	A-13	3704000001	Needle Roller Bearing KT 8 11 10	1
A-4	0207000086	SX254 Crankcase - R (front)	1	A-14	0207000025	R254 Piston Ring	1
A-5	0207000086	SX254 Crankcase - R (rear)	1	A-15	0207000072	S254 Piston - R	1
A-6	3703000004	Bearing 6001JRXLLU	2	A-16	0207000006	Piston Pin	1
A-7	3703000003	Bearing 6001C3	2	A-17	0207000028	Snap-ring - C type	1
A-8	0207000071	Brass oil plate	2	A-18	4602000004	O-ring P4	2
A-9	0207000039	Crank assembly - R	1	A-19	0403000006	Fitting AD M5-90	2
A-10	0207000053	SX254 Gasket for Crankcase	1	A-20	4602000007	O-ring AN123	1

B. Cylinder Assamble

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	Gasket for Cylinder Head	1
B-6	0207000075	R254 evolution Cylinder	1
B-7	0207000031	Gasket for Cylinder	1
B-8	0207000027	Pin 3P x 8	2
B-9	4602000006	O-ring 16 x 2	1
B-10	-	Set screw M5 x 8	1
B-11	-	Bolt M5 X 17	4

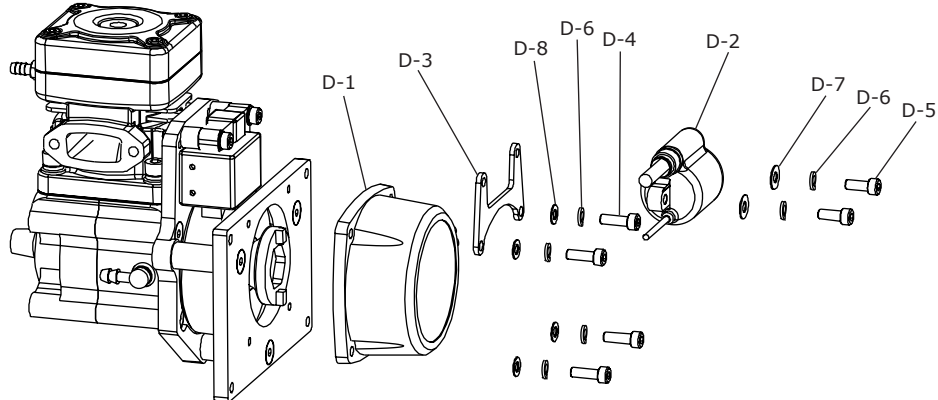


**C. Rotor Assamble**



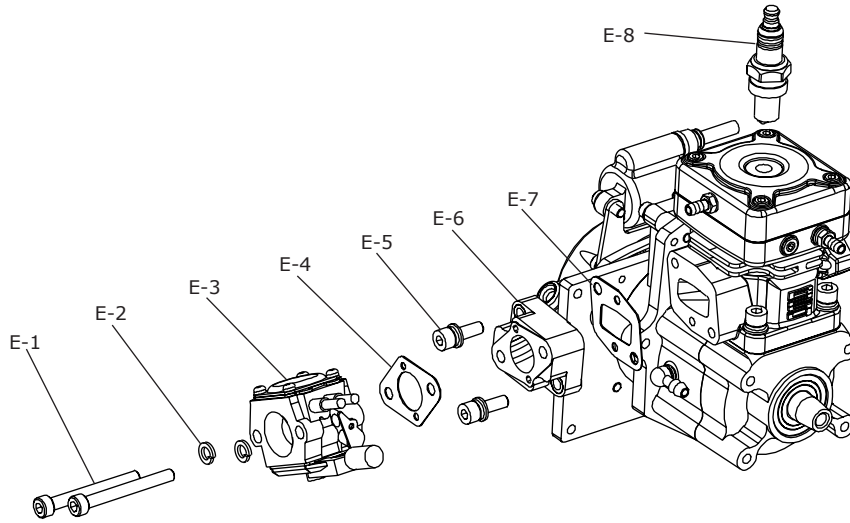
Key	Part Number	Description	Q'TY	Key	Part Number	Description	Q'TY
C-1	0207000069	S254 Rotor - R	1	C-7	-	Mount (Not include)	1
C-2	0207000084	Starter pulley Nut2 - R	1	C-8	-	Bolt M4 X 25	2
C-3	0207000010	R254 Source coil	1	C-9	-	Spring washer P4	2
C-4	-	Spacer 8.5mm	2	C-10	-	Washer P4	2
C-5	0207000051	SX254 Source coil mount spacer	3	C-11	-	Bolt M5 X 35	3
C-6	0207000024	Woodruff key	1				

**D. Pulley Assamble**



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 Assamble



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	Gasket for Insulator	1
E-4	0207000030	Gasket for Carburetor	1	E-8	4801000001	Spark Plug - CMR7H	1