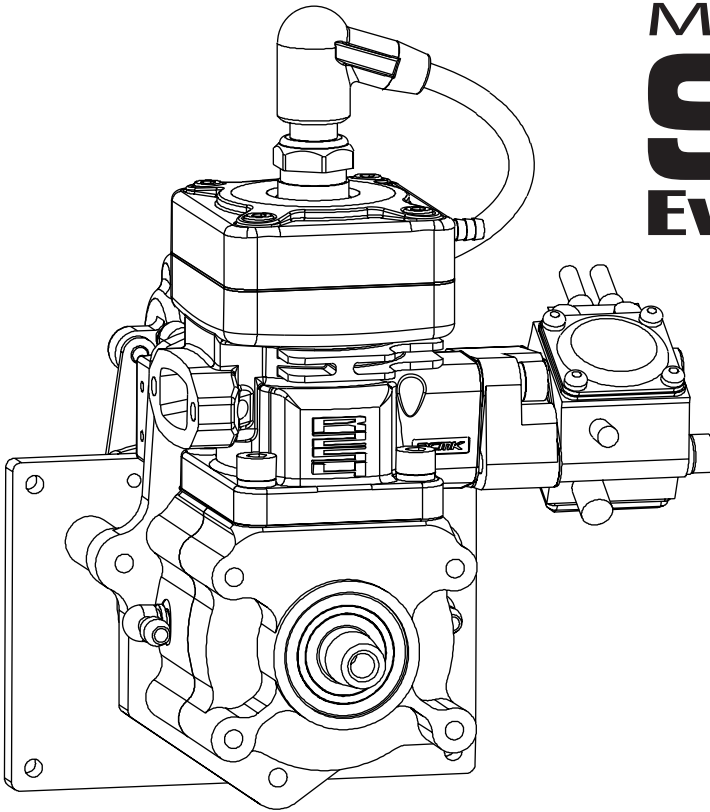


HIGH PERFORMANCE
Model Gas Engine
SX254
Evolution Version



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



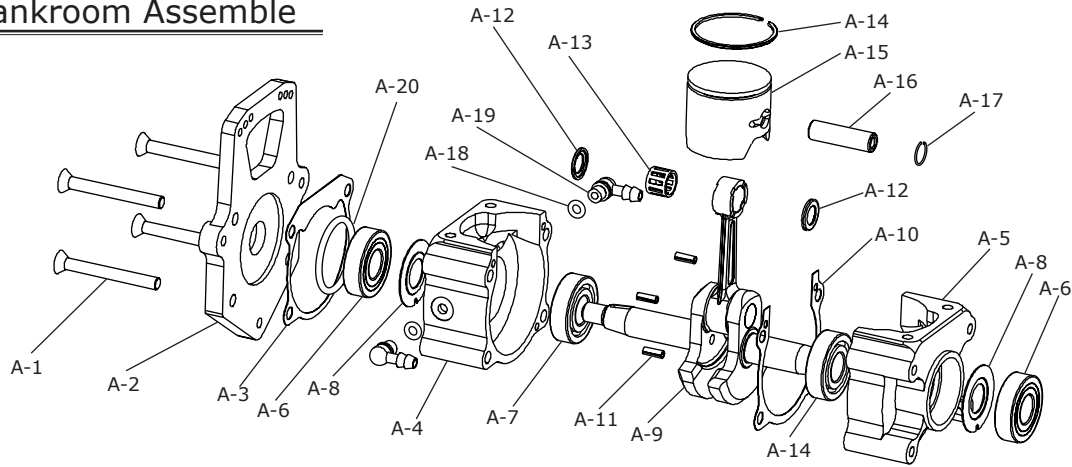
Model Gas Engine **SX254**
www.rcmk.com

- 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



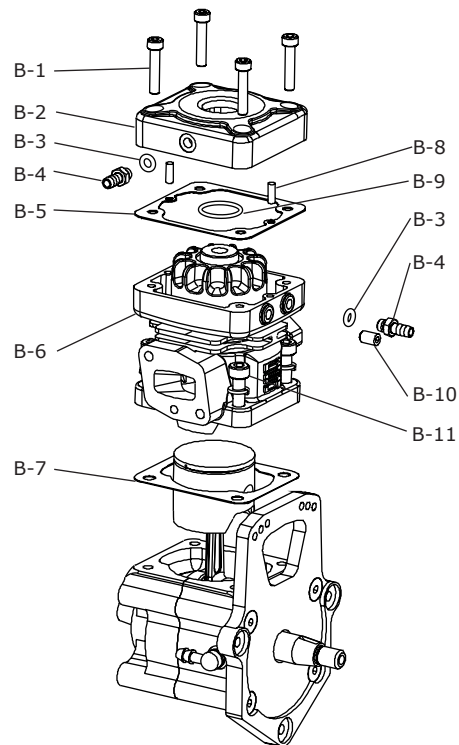
A. Crankroom Assemble



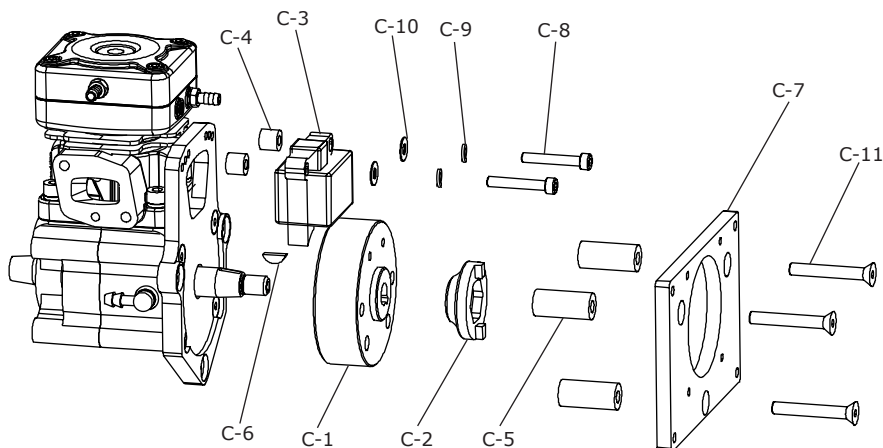
Key	Part Number	Description	Q'TY	Key	Part Number	Description	Q'TY
A-1	-	Bolt M5 X 45	4	A-11	0207000027	Pin 3P x 5	3
A-2	0207000050	SX254 Source coil mount	1	A-12	0207000012	Wrist Pin Bearing Spacer	2
A-3	0207000054	SX254 Gasket for crankcase cooler	1	A-13	3704000001	Needle Roller Bearing KT 8 11 10	1
A-4	0207000049	SX254 Crankcase front	1	A-14	0207000025	R254 Piston Ring	1
A-5	0207000049	SX254 Crankcase rear	1	A-15	0207000046	S254 Piston	1
A-6	3703000004	Bearing 6001JRLLU	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	0207000007	Crank assembly	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 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	0207000075	R254 evolution Cylinder	1
B-7	0207000031	R254 Gasket for Cylinder	1
B-8	0207000027	Pin 3P x 5	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

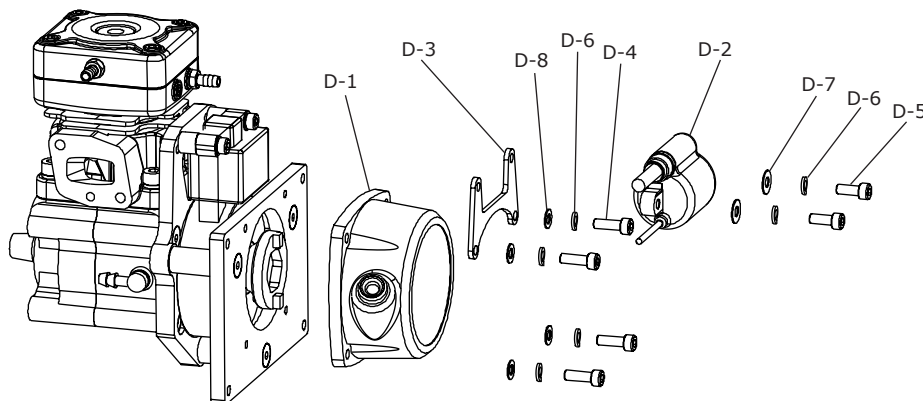


C. Rotor Assemble



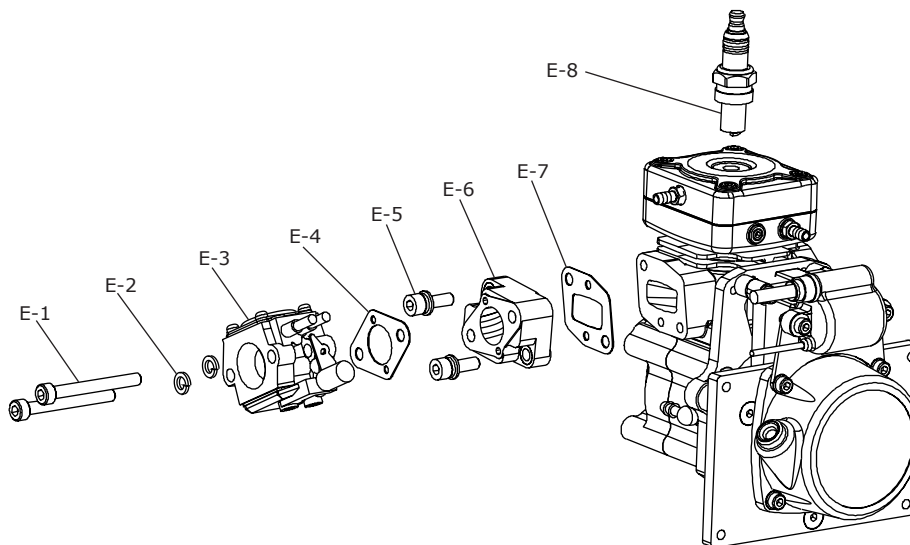
Key	Part Number	Description	Q'TY	Key	Part Number	Description	Q'TY
C-1	0207000061	S254 Rotor	1	C-7	-	Mount (Not include)	1
C-2	0207000060	Starter pulley Nut2	1	C-8	-	Bolt M4 X 25	2
C-3	0207000010	R254 Source coil	1	C-9	-	Spring washer P4	2
C-4	-	Spacer 7.2mm	2	C-10	-	Washer P4	2
C-5	0207000051	SX254 Source coil mount spacer	3	C-11	-	Bolt M5 X 35	3
C-6	0207000024	Woodruff key	1				

D. Pulley Assemble



Key	Part Number	Description	Q'TY	Key	Part Number	Description	Q'TY
D-1	0207000047	Recoil Starter	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 16	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