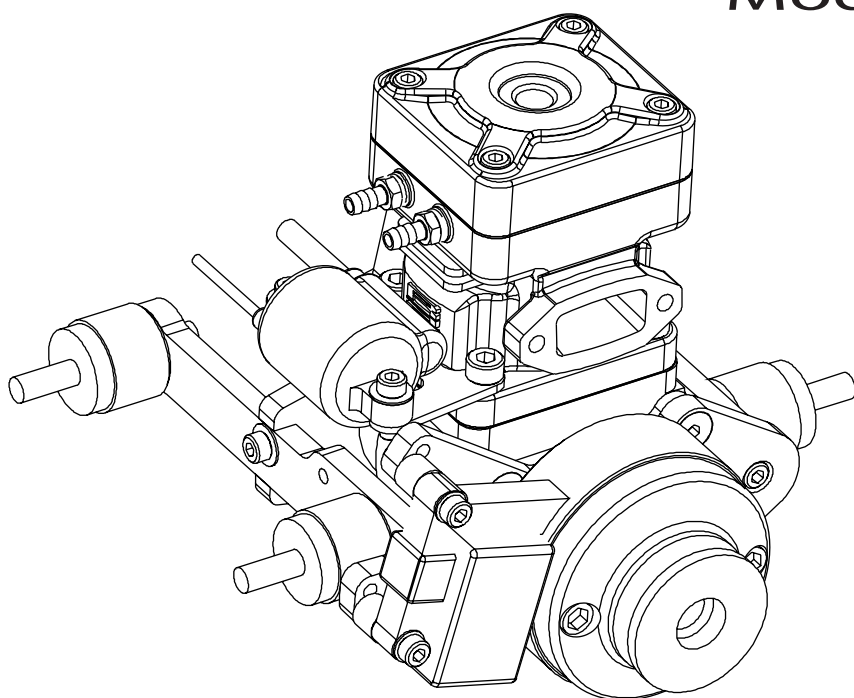


# RX254

HIGH PERFORMANCE  
Model Gas Engine



## Conversion kit include

- bearing case with 4 bearings
- crank gasket
- Head Water jacket
- Crank case water jacket
- Engine mount
- Rotor
- Pulley(for starter)
- Ignition plate
- Piston

## WARNING



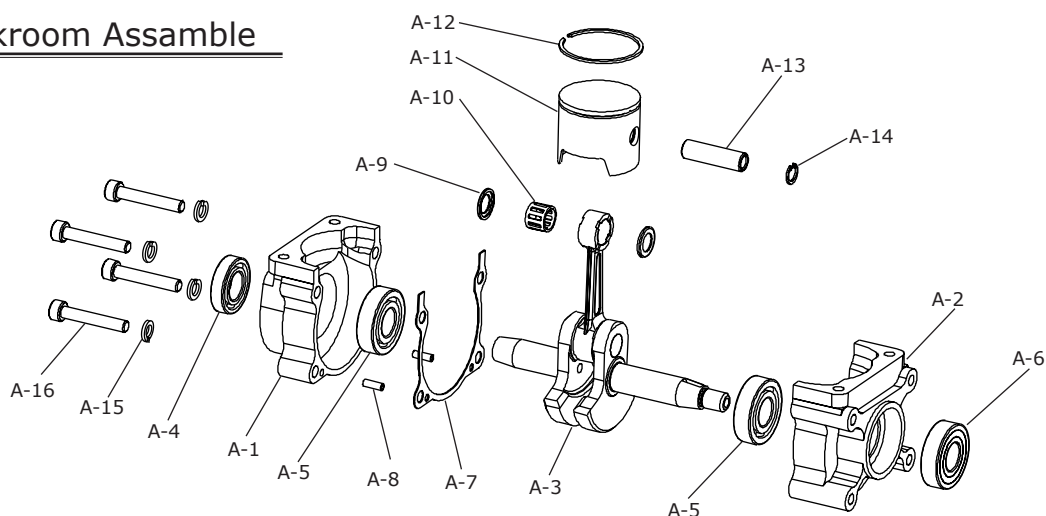
Model Gas Engine **RX254**  
[www.rcmk.com](http://www.rcmk.com)

- 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.

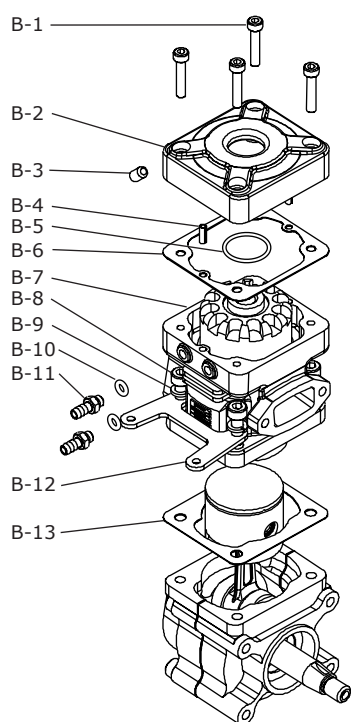
## Assembly Method



### A. Crankroom Assamble



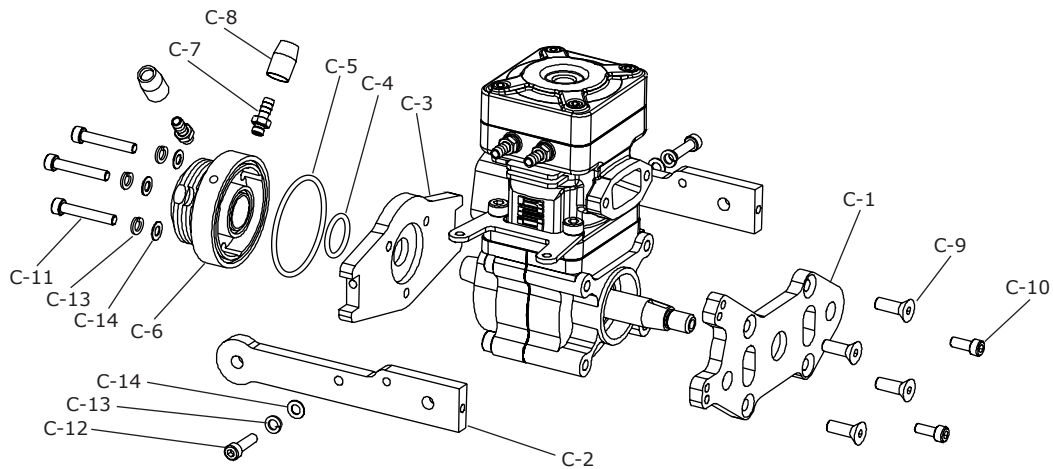
| Key | Part Number | Description             | Q'TY | Key  | Part Number | Description                      | Q'TY |
|-----|-------------|-------------------------|------|------|-------------|----------------------------------|------|
| A-1 | 0207000001  | RX Crankcase Front      | 1    | A-9  | 0207000012  | Wrist Pin Bearing Spacer         | 2    |
| A-2 | 0207000001  | RX Crankcase Rear       | 1    | A-10 | 3704000001  | Needle Roller Bearing KT 8 11 10 | 1    |
| A-3 | 0207000007  | Crank assembly          | 1    | A-11 | 0207000005  | RX Piston                        | 1    |
| A-4 | -           | Bearing 6901DD          | 1    | A-12 | 0207000025  | R254 Piston Ring                 | 1    |
| A-5 | -           | Bearing 6001ZZ          | 2    | A-13 | 0207000006  | Piston Pin                       | 1    |
| A-6 | -           | Bearing 6001DD          | 1    | A-14 | 0207000028  | Snap-ring C type                 | 1    |
| A-7 | 0207000002  | RX Gasket for crankcase | 1    | A-15 | -           | Washer P5                        | 4    |
| A-8 | -           | Pin 3 X 8               | 2    | A-16 | -           | Bolt M5 X 30                     | 4    |



### B. Cylinder Assamble

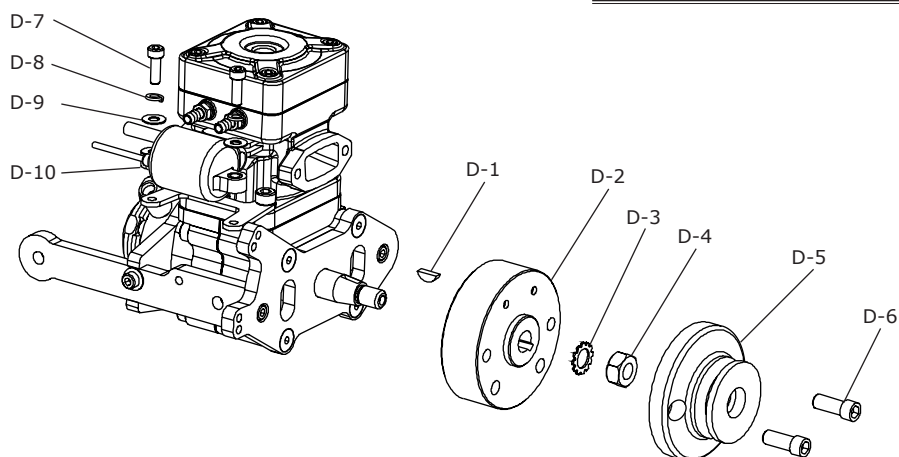
| Key  | Part Number | Description                   | Q'TY |
|------|-------------|-------------------------------|------|
| B-1  | -           | Bolt M4 X 20                  | 4    |
| B-2  | 0207000018  | R254 Cylinder Cap             | 1    |
| B-3  | -           | Set Screw M5 X 8              | 1    |
| B-4  | -           | Pin 3 X 8                     | 2    |
| B-5  | -           | O-ring S16                    | 1    |
| B-6  | 0207000032  | R254 Gasket for Cylinder Head | 1    |
| B-7  | 0207000019  | R254 Cylinder                 | 1    |
| B-8  | -           | Bolt M5 X 15                  | 4    |
| B-9  | -           | Spring Washer P5              | 1    |
| B-10 | -           | O-ring P4                     | 1    |
| B-11 | 0403000002  | Fitting M5                    | 2    |
| B-12 | 0207000022  | R254 Ignition Coil Mount      | 1    |
| B-13 | 0207000031  | R254 Gasket for Cylinder      | 1    |

### C. Crankroom Mount Assamble



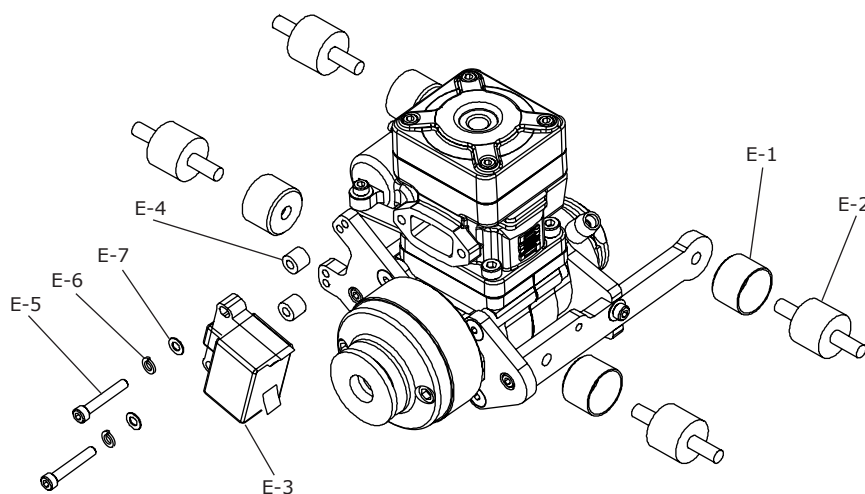
| Key | Part Number | Description     | Q'TY | Key  | Part Number | Description      | Q'TY |
|-----|-------------|-----------------|------|------|-------------|------------------|------|
| C-1 | 0201000013  | SX Mount Rear   | 1    | C-8  | 0403000008  | Fitting Cap 5    | 2    |
| C-2 | 0201000013  | SX Mount Side   | 2    | C-9  | -           | Bolt M5 X 15     | 4    |
| C-3 | 0201000013  | SX Mount Front  | 1    | C-10 | -           | Bolt M4 X 10     | 2    |
| C-4 | -           | O-ring 16x2     | 1    | C-11 | -           | Bolt M4 X 25     | 3    |
| C-5 | -           | O-ring S42      | 1    | C-12 | -           | Bolt M4 X 15     | 2    |
| C-6 | 0207000009  | RX Crank Cooler | 1    | C-13 | -           | Spring Washer P4 | 5    |
| C-7 | 0403000002  | Fitting M5      | 2    | C-14 | -           | Washer P4        | 5    |

### D. Rotor Assamble



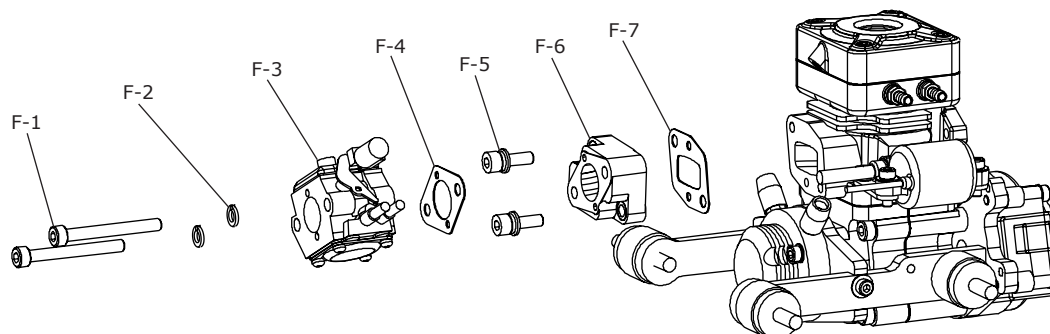
| Key | Part Number | Description                     | Q'TY | Key  | Part Number | Description      | Q'TY |
|-----|-------------|---------------------------------|------|------|-------------|------------------|------|
| D-1 | 0207000024  | Woodruff Key                    | 1    | D-6  | -           | Bolt M6 X 15     | 2    |
| D-2 | 0207000003  | RX Rotor                        | 1    | D-7  | -           | Bolt M4 X 12     | 2    |
| D-3 | -           | Rock Washer P8                  | 1    | D-8  | -           | Spring Washer P4 | 2    |
| D-4 | -           | Nut M8 X P1.0                   | 1    | D-9  | -           | Washer P4        | 2    |
| D-5 | 0207000004  | Pooly for rear exhaust - Type A | 1    | D-10 | 0202000010  | R254 Source Coil | 1    |

## E. Ignition Assamble



| Key | Part Number | Description      | Q'TY | Key | Part Number | Description      | Q'TY |
|-----|-------------|------------------|------|-----|-------------|------------------|------|
| E-1 | 0201000011  | Rubber Mount G1  | 4    | E-5 | -           | Bolt M4 X 25     | 2    |
| E-2 | 0201000017  | Rubber Mount M2  | 4    | E-6 | -           | Spring Washer P4 | 2    |
| E-3 | 0207000010  | R254 Source Coil | 1    | E-7 | -           | Washer P4        | 2    |
| E-4 | -           | Spacer (7.5mm)   | 2    |     |             |                  |      |

## F. Caburator Assamble



| Key | Part Number | Description             | Q'TY | Key | Part Number | Description               | Q'TY |
|-----|-------------|-------------------------|------|-----|-------------|---------------------------|------|
| F-1 | -           | Bolt M5 x 45            | 2    | F-5 | -           | Bolt M5 X 16              | 2    |
| F-2 | -           | Spring Washer P5        | 2    | F-6 | 0207000016  | R254 Insulator block      | 1    |
| F-3 | 4001000002  | Carburetor WT-929       | 1    | F-7 | 0207000034  | R254 Gasket for Insulator | 1    |
| F-4 | 0207000030  | R254 Gasket, Carburetor | 1    |     |             |                           |      |