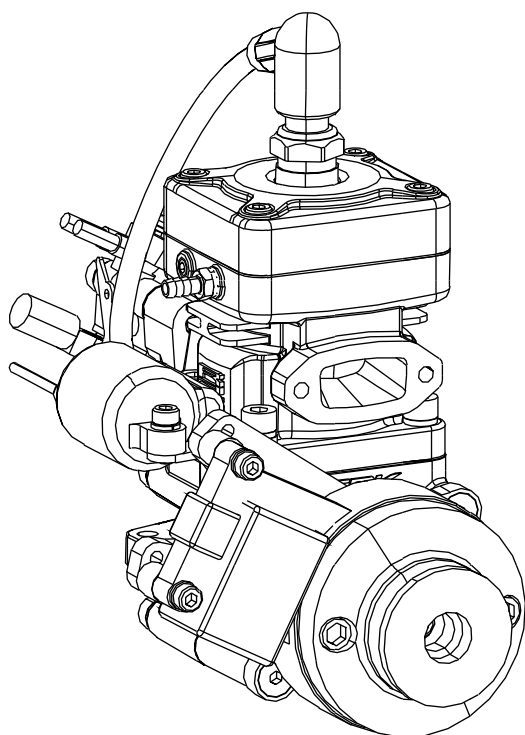




HIGH PERFORMANCE
Model Gas Engine
R254
Evolution Version

Engine Features

- 4 bearings crank case
- 6001 standard bearing for crankshaft
- Stronger crankshaft and connecting rod
- Walbro WT-927 carburetor
- Water cooling cylinder
- Start pulley

WARNING



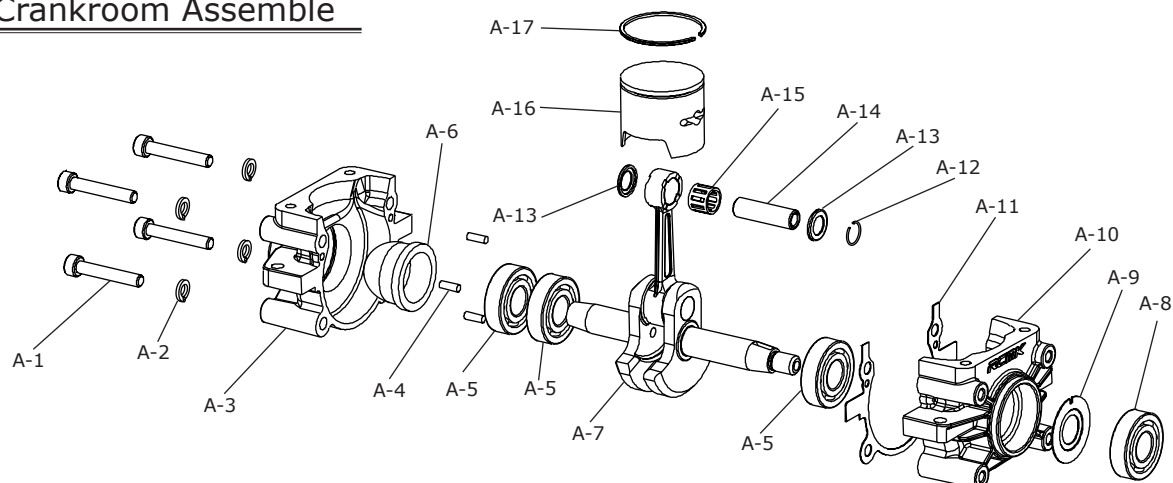
Model Gas Engine **R254**
www.rcmk.com

- 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



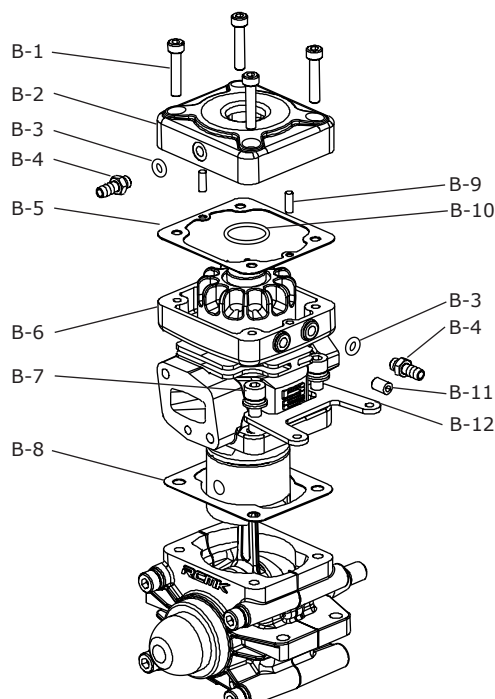
A. Crankroom Assemble



Key	Part Number	Description	Q'TY	Key	Part Number	Description	Q'TY
A-1	-	Bolt M5 x 41	4	A-10	0207000020	R254 Crankcase (Rear)	1
A-2	-	Spring Washer P5	4	A-11	0207000035	R254 Gasket for Crankcase	1
A-3	0207000020	R254 Crankcase (Front)	1	A-12	0207000028	Snap-ring C type	1
A-4	0207000027	Pin 3P x 5	4	A-13	0207000012	Wrist Pin Bearing Spacer	2
A-5	3703000003	Bearing 6001C3	3	A-14	0207000038	Piston Pin for R254	1
A-6	0207000020	R254 Crankcase (Cap)	1	A-15	3704000001	Needle Roller Bearing KT 8 11 10	1
A-7	0207000007	Crank assembly	1	A-16	0207000023	R254 Piston	1
A-8	3703000004	Bearing 6001JRLLU	1	A-17	0207000025	R254 Piston Ring	1
A-9	0207000071	Brass oil plate	1				

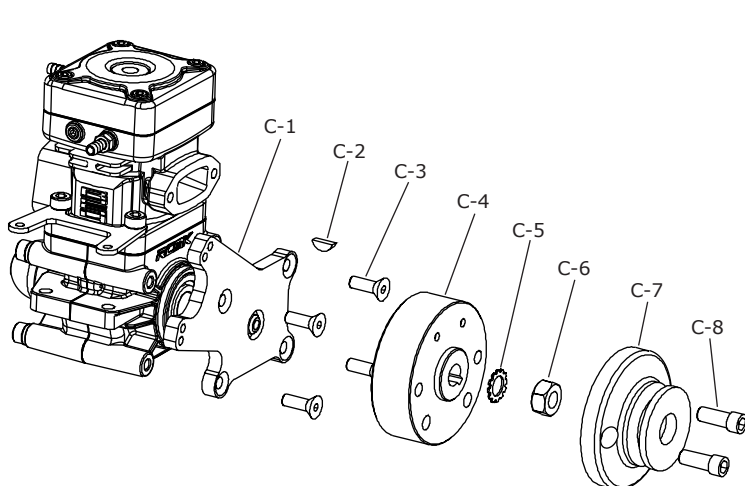
B. Cylinder Assemble

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	-	Bolt M5 x 17	4
B-8	0207000031	R254 Gasket for Cylinder	1
B-9	0207000027	Pin 3P x 5	2
B-10	4602000003	O-ring S16	1
B-11	-	Set screw M5 x 8	1
B-12	0207000022	R254 Ignition Coil Mount	1



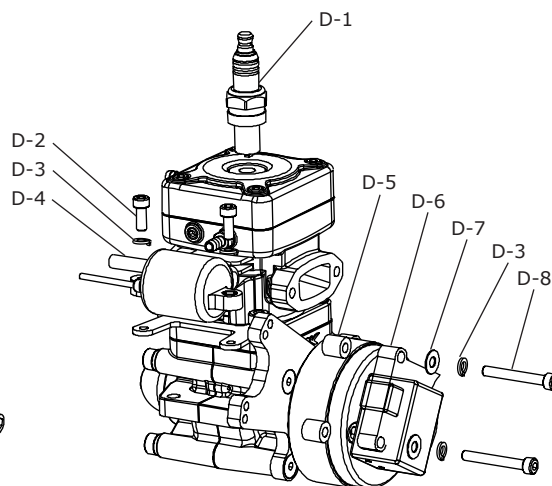
C. Rotor Assemble

Key	Part Number	Description	Q'TY
C-1	0207000029	R254 Source Coil Mount	1
C-2	0207000024	Woodruff Key	1
C-3	-	Bolt M5 x 15	4
C-4	0207000040	R254 Rotor	1
C-5	-	Rock Washer	1
C-6	-	Nut M8 x P1.0	1
C-7	0207000004	Pulley for Rear Exhaust - Type A	1
C-8	-	Special Bolt M6 x 15	2

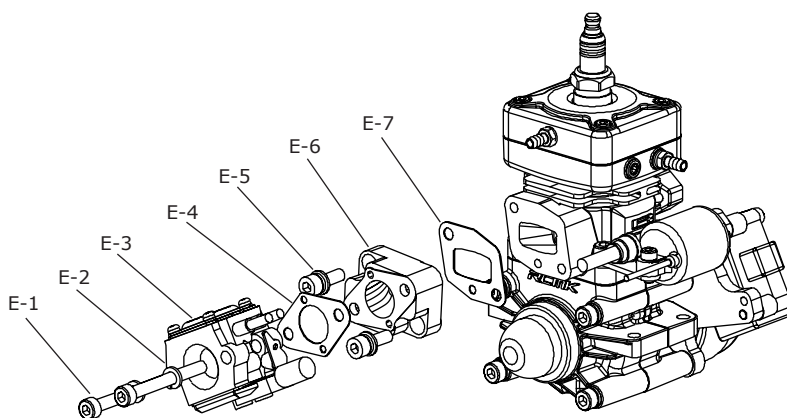


D. Coil Assemble

Key	Part Number	Description	Q'TY
D-1	4801000001	Spark Plug - CMR7H	1
D-2	-	Bolt M4 x 10	2
D-3	-	Spring Washer P4	4
D-4	0207000011	R254 Ignition Coil	1
D-5	-	Spacer 9 mm	2
D-6	0207000010	R254 Source Coil	1
D-7	-	Washer P4	2
D-8	-	Bolt M4 x 25	2



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 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				

