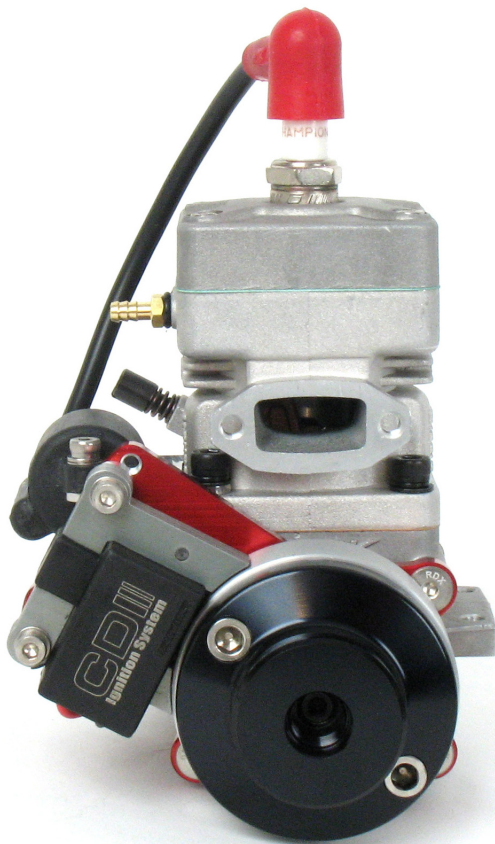




R254

HIGH PERFORMANCE
Model Gas Engine

Engine Features

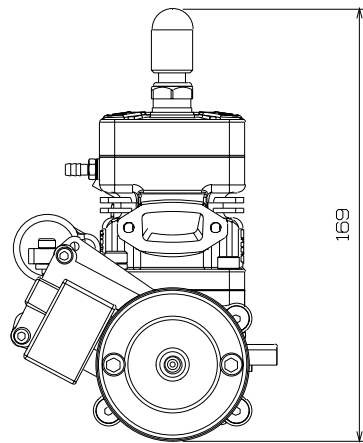
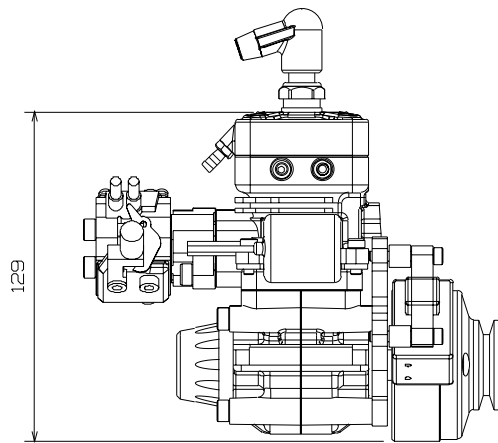
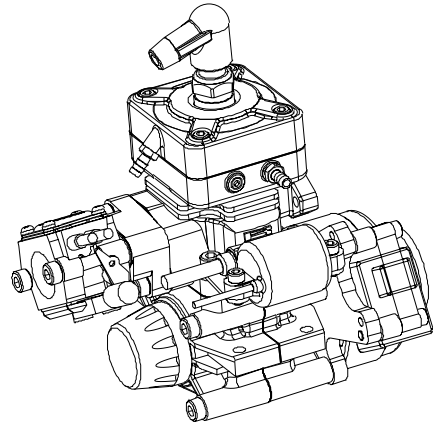
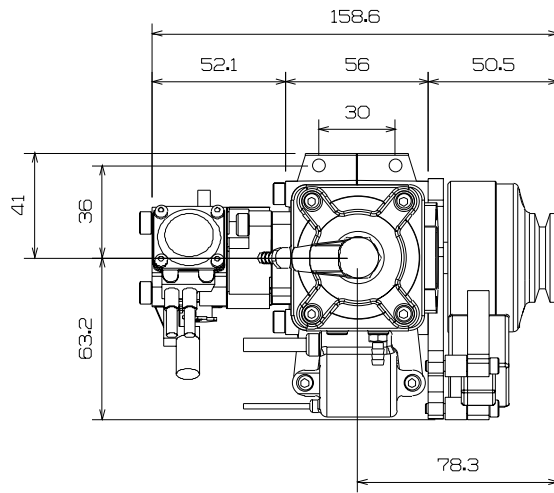
- 4 bearings crank case
- 6001 standard bearing for crankshaft
- Stronger crankshaft and connecting rod
- Walbro WT-257 carburetor
- Modified piston
- Water cooling cylinder
- Start pulley

WARNING



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

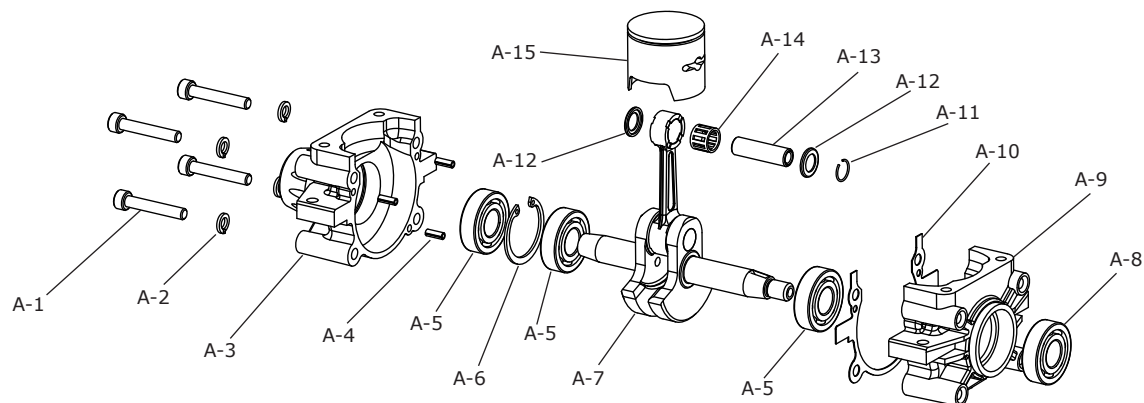
- Before use engine, read description necessarily.
- This engine is designed and made for use on model boat. So we recommend to use on model boat
- Use genuine parts for replacement.
- Check the bolts fixation condition of engine every time. If the bolts are loosed, fix the loosed bolt, and after check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



Assembly Method



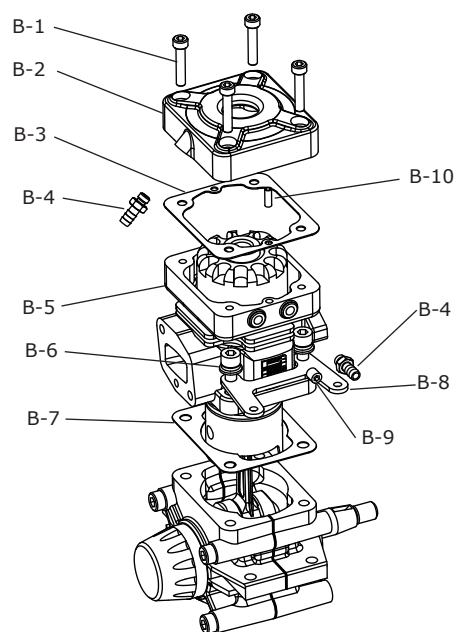
A. Crankroom Assamble



Key	Part Number	Description	Q'TY	Key	Part Number	Description	Q'TY
A-1	-	Bolt M5 x 40	1	A-9	0207000020	R254 Crank case Rear	2
A-2	-	Spring Washer P5	1	A-10	0207000035	R254 Gasket, Crank Case	1
A-3	0207000020	R254 Crank case Front	1	A-11	0207000028	C-ring	1
A-4	0207000027	Crankcase Pin	1	A-12	-	Piston Spacer	1
A-5	-	Bearing	2	A-13	0207000038	Piston Pin for R254	1
A-6	-	Snap-ring R-28	1	A-14	-	Needle Roller Bearing KT 8 11 10	1
A-7	0207000007	Crank assembly	1	A-15	0207000023	R254 Piston	4
A-8	-	Bearing	2				

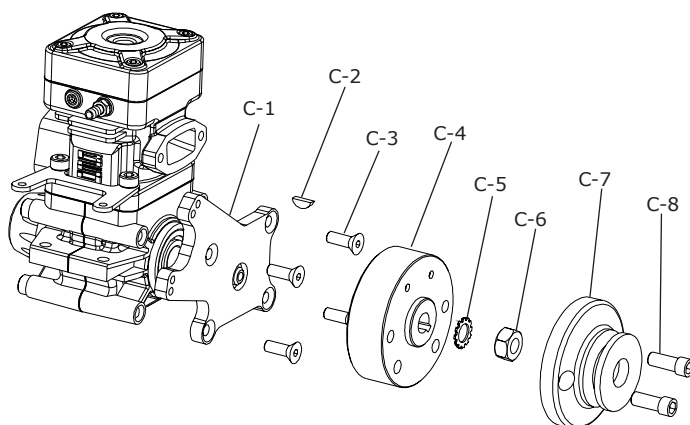
B. Cylinder Assamble

Key	Part Number	Description	Q'TY
B-1	-	Bolt M4 x 20	4
B-2	0207000018	R254 Cylinder Cap	1
B-3	0207000008	R254 Gasket, Cylinder Head	1
B-4	0403000001	Fitting M5	2
B-5	0207000019	R254 Cylinder	1
B-6	-	Bolt M5 X 15	4
B-7	0207000031	R254 Gasket, Cylinder	1
B-8	0207000022	R254 Ignition Coil Mount	1
B-9	-	Set screw M4	1
B-10	0207000027	Pin	2



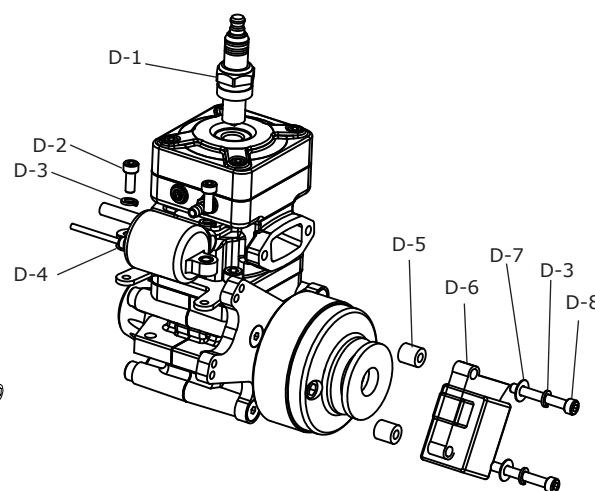
C. Rotor Assamble

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 20	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

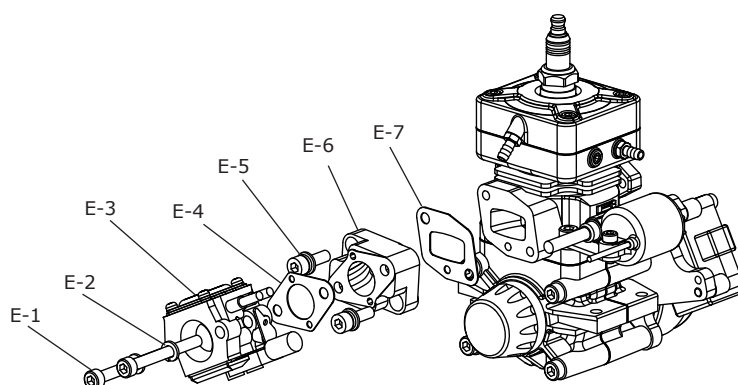


D. Coil Assamble

Key	Part Number	Description	Q'TY
D-1	4801000001	Spark Plug - CMR7H	1
D-2	0207000003	Bolt M4 x 10	2
D-3	-	Spring Washer P4	4
D-4	0207000011	R254 Ignition Coil	1
D-5		Spacer 8.5 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 M4 X 16	2
E-2	-	Spring Washer P5	2	E-6	0207000016	R254 Insulator block	1
E-3	4001000001	Carburetor WT-257	1	E-7	0207000034	R254 Gasket, Insulator	1
E-4	0207000030	R254 Gasket, Carburetor	1				