



GX25 Engine Assembly Information

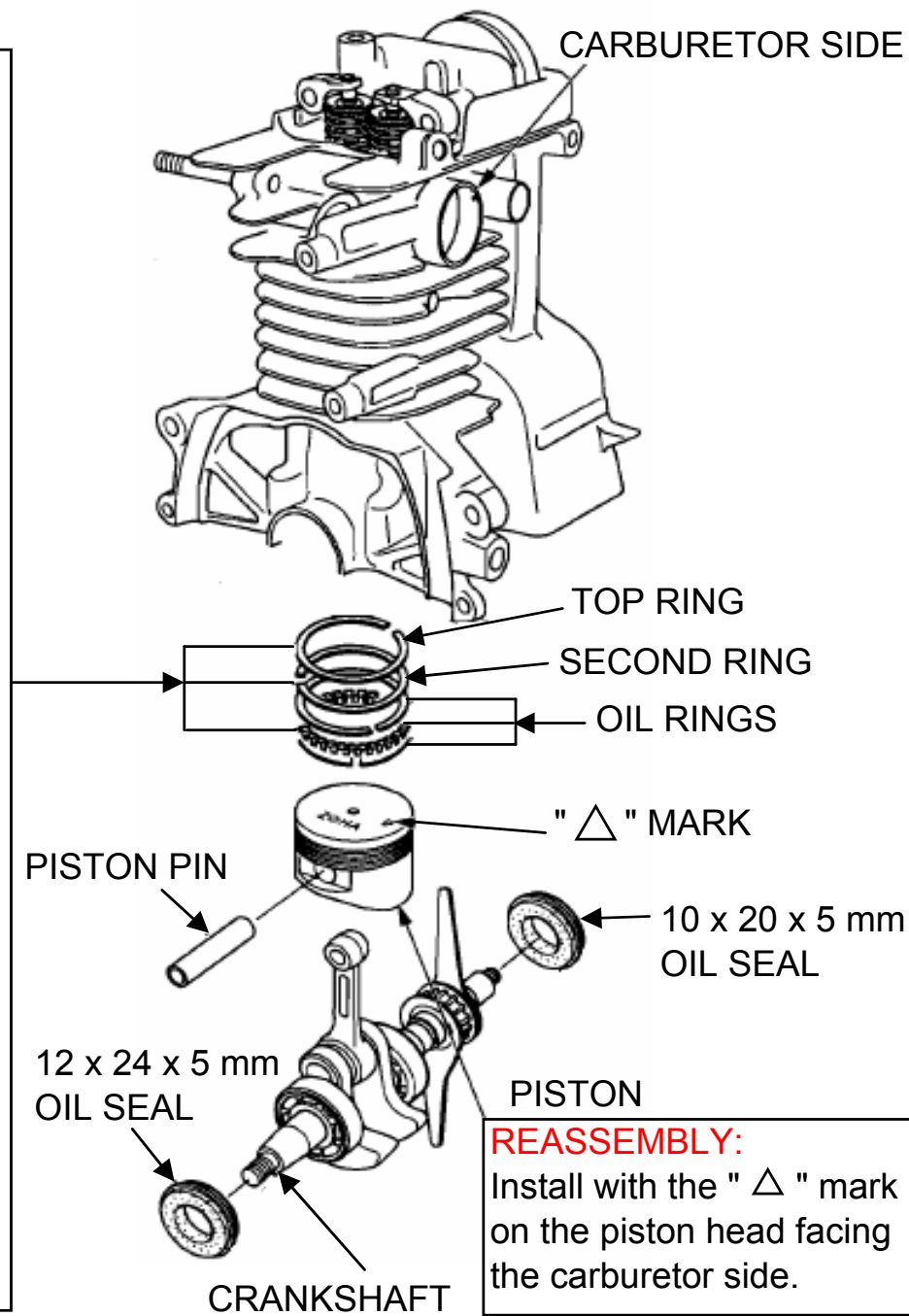
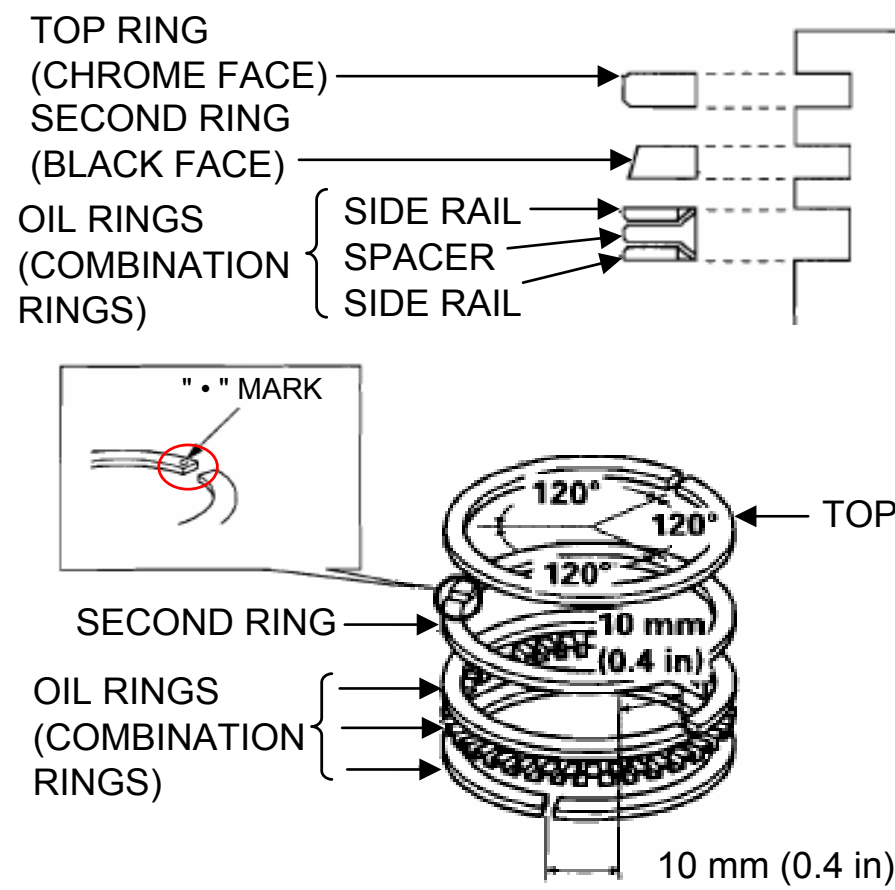
HONDA

CRANKSHAFT/PISTON

PISTON RING

REASSEMBLY:

- Install the second ring with the "•" mark facing up.
- Do not interchange the top ring and the second ring.
- After assembly, check for smooth movement of the piston rings.
- Stagger the piston ring end gaps 120° apart. Do not align with the piston pin.
- Space the oil ring side rail end gaps at least 10 mm (0.4 in) apart. Coat the oil ring with oil after assembly.



LOWER CRANKCASE

4 x 8 mm SCREW (2)

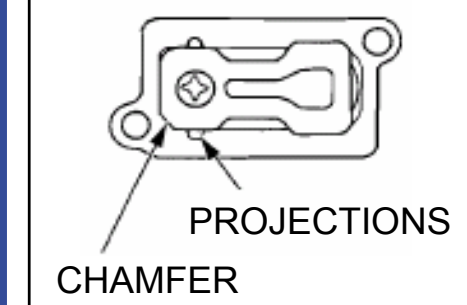
REASSEMBLY:

Clean the threads and apply liquid sealant (Loctite® 648, Hondalock 2 or equivalent) to the threads.

OIL OUTLET VALVE PLATE

INSTALLATION:

Install the oil outlet valve to the oil outlet valve plate by aligning the chamfer and projections.

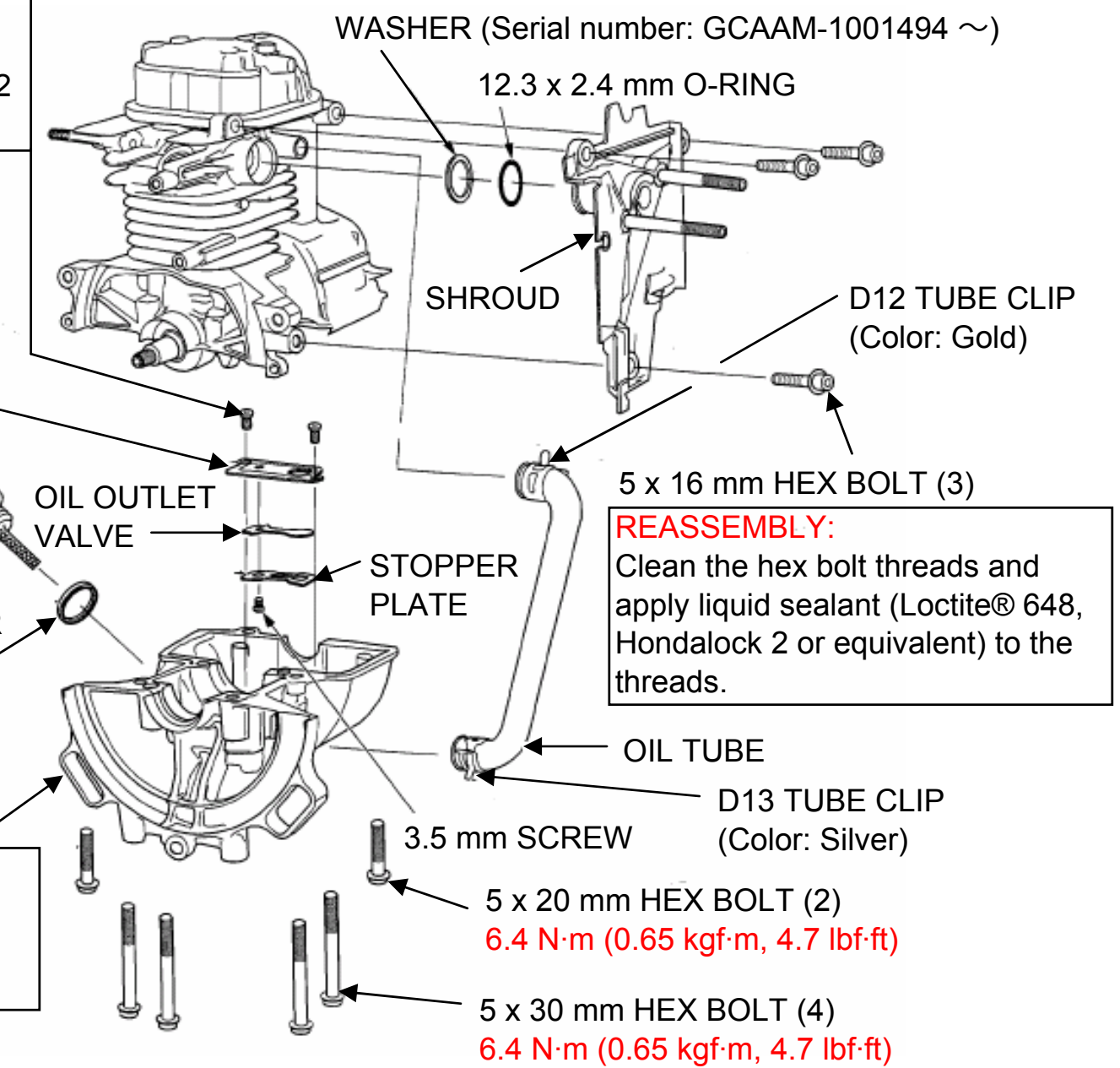


OIL FILLER CAP PACKING

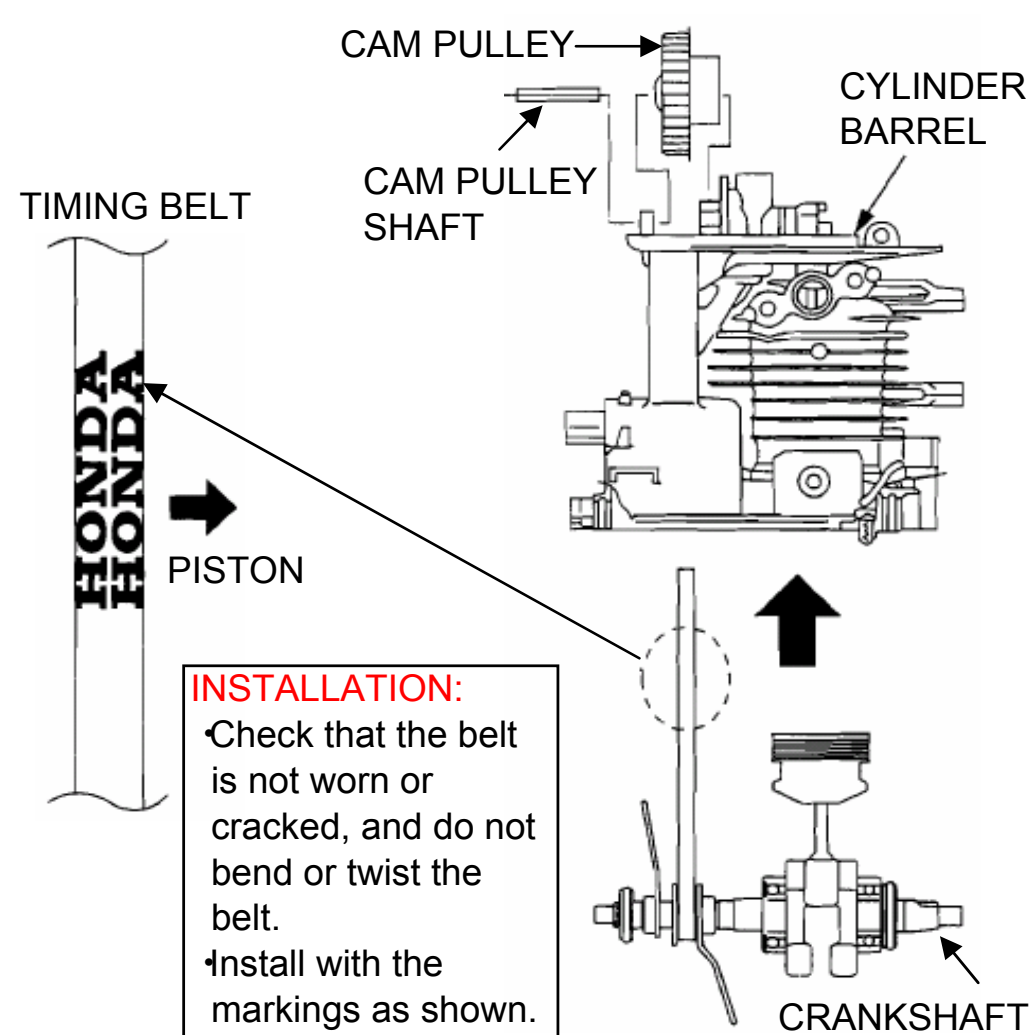
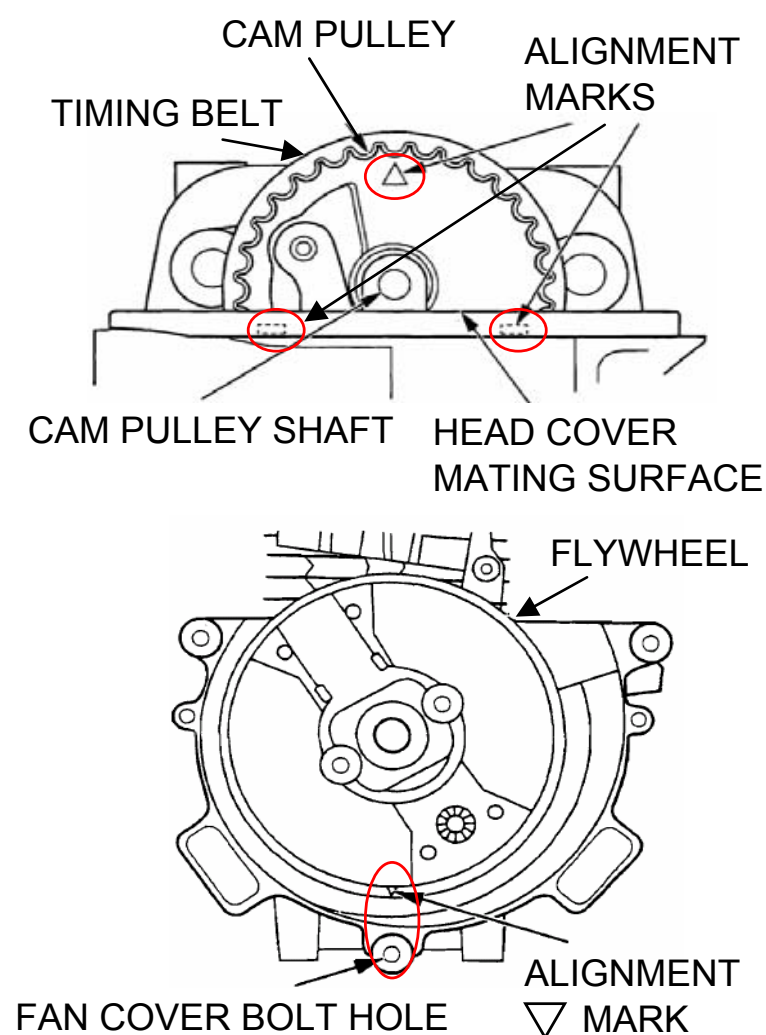
LOWER CRANKCASE

REASSEMBLY:

Clean the inside of the crankcase and remove foreign material before reassembly.



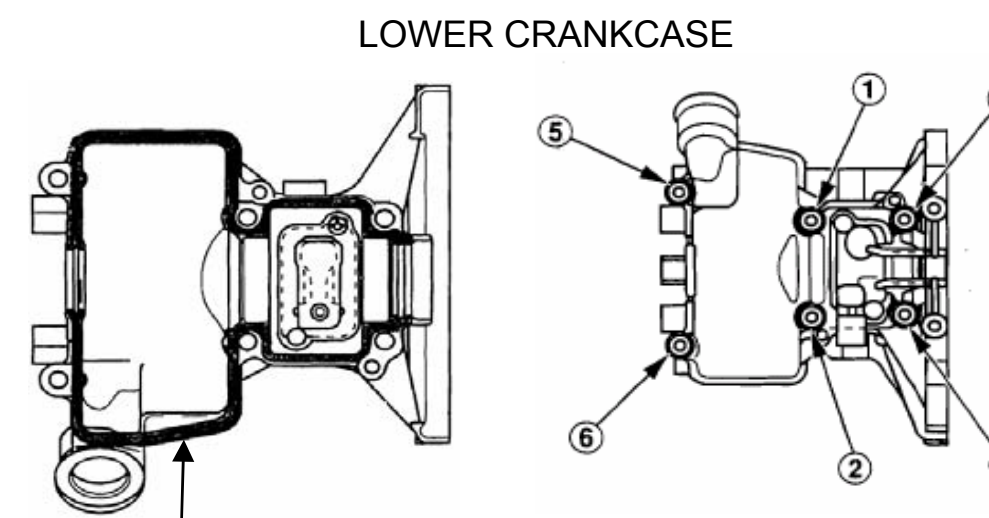
CAM PULLEY/CRANKSHAFT



INSTALLATION:

Check that the belt is not worn or cracked, and do not bend or twist the belt. Install with the markings as shown.

LOWER CRANKCASE/CYLINDER BARREL/VALVES

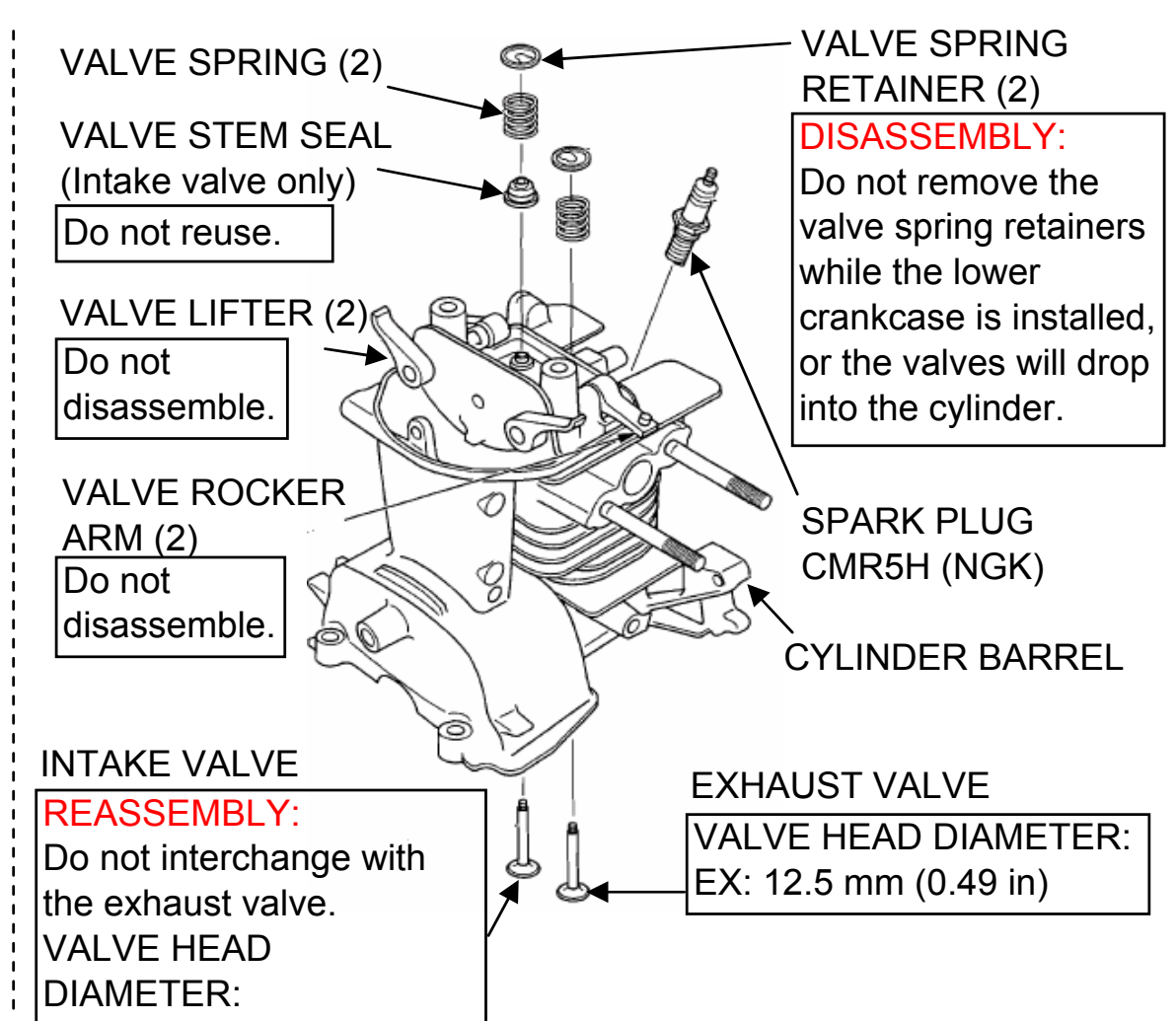


LIQUID GASKET APPLICATION AREA (HondaBond 4, ThreeBond® #1216, 1216E or equivalent)

Assemble **within 3 minutes** after applying the liquid gasket.

Loosely tighten two 5 x 20 mm and four 5 x 30 mm hex bolts, and then tighten to the numbered sequence.

TORQUE: 6.4 N·m (0.65 kgf·m, 4.7 lbf·ft)
Wait for **approximately 60 minutes** after assembly before filling with oil and starting the engine.



DISASSEMBLY:
Do not remove the valve spring retainers while the lower crankcase is installed, or the valves will drop into the cylinder.

REASSEMBLY:
Do not interchange with the exhaust valve.
VALVE HEAD DIAMETER:

EXHAUST VALVE
VALVE HEAD DIAMETER:
EX: 12.5 mm (0.49 in)