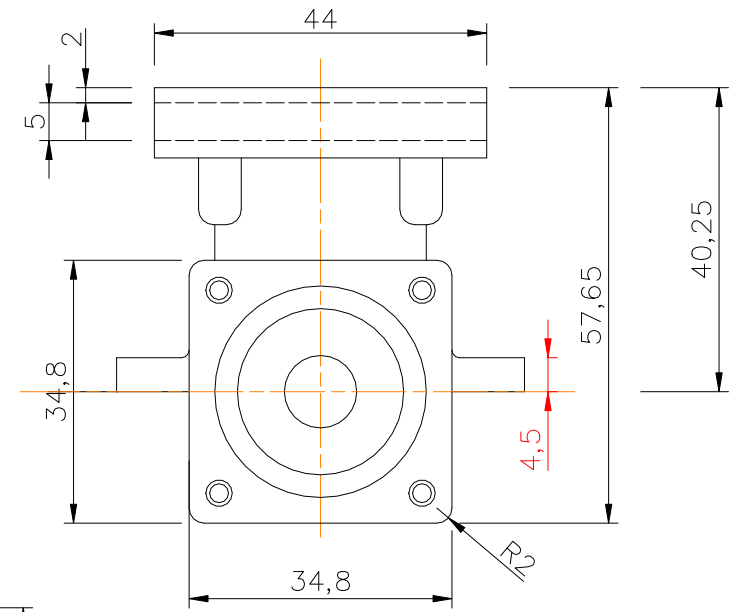
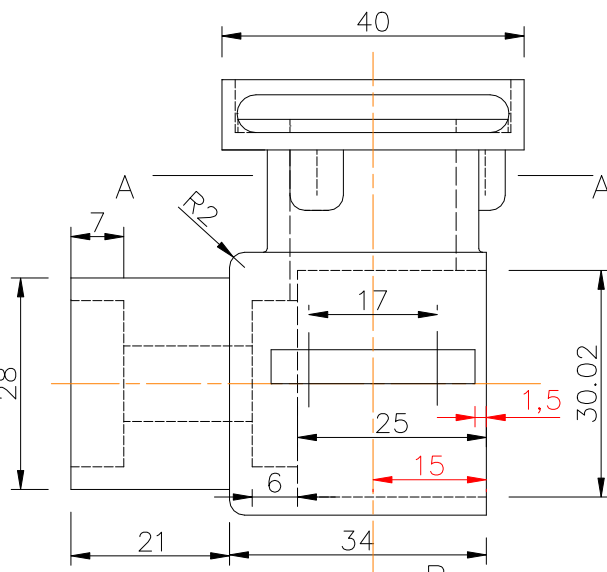
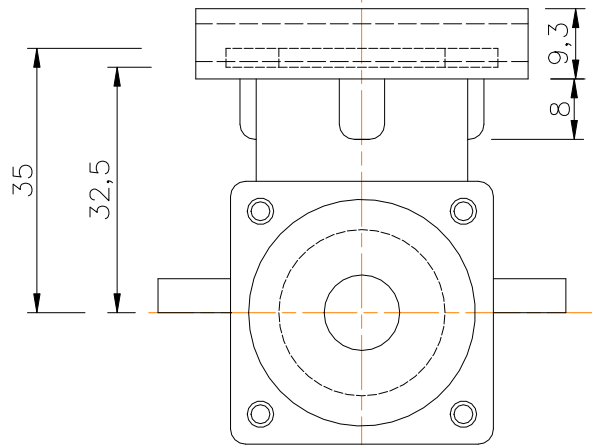
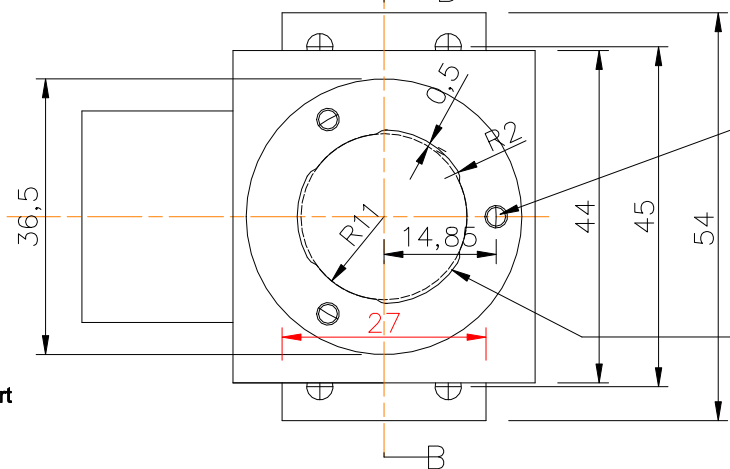
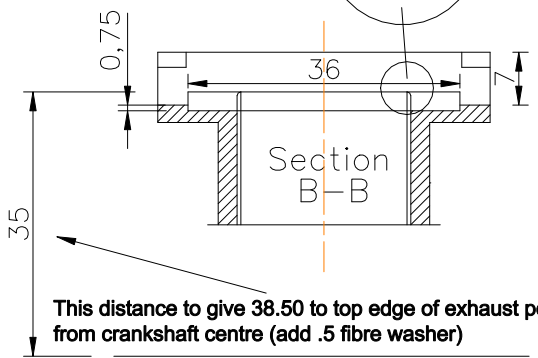
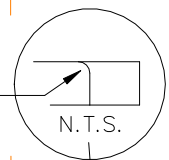


Main Bearing is open 22 x 10 x 6 - 61900  
 Front Bearing is single shield 22 x 8 x 7 - 608ZR  
 Bore housings to -.005,-.008 on diameter



Use ball nose cutter to give flare into transfer ports. Leave 0.1 land. Assemble cylinder on .5mm fibre washer



Drill and tap 5BA 10 dp on 29.7 PCD

Transfer ports cut with 4mm dia cutter. Depth to break through into crankcase main bore

Subject	<b>X2 - Racer 5cc Diesel</b>	Part	<b>Crankcase</b>	Material	<b>HE 30 Aluminium</b>
				Drawn	<b>Ramon Wilson</b>

