

• Before assembling, apply clean 2 stroke oil

SPECIFICATIONS 350 78.5 mm mm (in)

ITEM	STANDARD	SERVICE LIMIT
Cylinder head, cylinder warpage	—	0.05 (0.002)
Cylinder bore	78.500—78.515 (3.0905—3.0911)	78.555 (3.0927)
Piston O.D. (20 mm (0.8 in) from piston skirt bottom)	78.425—78.440 (3.0875—3.0882)	78.365 (3.0853)
Cylinder-to-piston clearance	0.06—0.095 (0.0023—0.0037)	0.16 (0.006)
Piston pin bore	18.007—18.013 (0.7089—0.7091)	18.033 (0.7100)
Piston pin O.D.	17.994—18.000 (0.7084—0.7087)	17.979 (0.7078)
Piston-to-piston pin clearance	0.007—0.019 (0.0003—0.0008)	0.03 (0.001)
Piston ring end gap (top/bottom)	0.2—0.4 (0.0008—0.0157)	0.5 (0.02)
Connecting rod small end I.D.	21.997—22.009 (0.8660—0.8665)	22.024 (0.8671)

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SPECIFICATIONS 350 80 mm mm (in)

ITEM	STANDARD	SERVICE LIMIT
Cylinder head, cylinder warpage	—	0.05 (0.002)
Cylinder bore	80.000—80.020 (3.1496—3.1504)	80.060 (3.1520)
Piston O.D. (20 mm (0.8 in) from piston skirt bottom)	79.945—79.965 (3.1474—3.1482)	79.885 (3.1451)
Cylinder-to-piston clearance	0.06—0.095 (0.0023—0.0037)	0.16 (0.006)
Piston pin bore	18.007—18.013 (0.7089—0.7091)	18.033 (0.7100)
Piston pin O.D.	17.994—18.000 (0.7084—0.7087)	17.979 (0.7078)
Piston-to-piston pin clearance	0.007—0.019 (0.0003—0.0008)	0.03 (0.001)
Piston ring end gap (top/bottom)	0.2—0.4 (0.0008—0.0157)	0.5 (0.02)
Connecting rod small end I.D.	21.997—22.009 (0.8660—0.8665)	22.024 (0.8671)

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SPECIFICATIONS FL 400 unit: mm(in)

ITEM	STANDARD	SERVICE LIMIT
Cylinder head, cylinder warpage	—	0.05 (0.002)
Cylinder	bore	A 80.013—80.018 (3.15012—3.15031)
		B 80.007—80.012 (3.14988—3.15008)
		C 80.000—80.006 (3.14961—3.14984)
	out of round	— 0.010 (0.0004)
	taper	— 0.010 (0.0004)
Piston O.D. (at 10 mm/0.4 in from the skirt bottom)	A	79.926—79.931 (3.1467—3.1469)
	B	79.920—79.925 (3.1465—3.1467)
	C	79.914—79.919 (3.1462—3.1464)
Cylinder-to-piston clearance	0.080—0.092 (0.0031—0.0036)	0.150 (0.0059)
Piston pin bore	20.007—20.013 (0.7877—0.7879)	20.033 (0.7887)
Piston pin O.D.	19.994—20.000 (0.7872—0.7874)	19.979 (0.7866)
Piston-to-piston pin clearance	0.007—0.019 (0.0003—0.0007)	0.030 (0.0012)
Piston ring end gap (top/bottom)	0.45—0.60 (0.018—0.024)	0.70 (0.028)
Connecting rod small end I.D.	25.002—25.014 (0.9843—0.9848)	25.029 (0.9854)

OPTIONAL PARTS LIST

ITEM FL 400		
ENGINE		
<ul style="list-style-type: none">● Oversize piston rings● Oversize pistons		0.25 mm (0.01 in) 0.25 mm (0.01 in) The cylinder must be worn or seized. Use
Piston oversize	Piston manufacturing tolerance mm (in)	
0.25 mm (0.01 in)	80.164-80.182 (3.1561-3.1568)	
0.50 mm (0.02 in)	80.414-80.432 (3.1659-3.1666)	
		CAUTION:
		<ul style="list-style-type: none">• <i>Be careful not to</i>
		NOTE:
		<ul style="list-style-type: none">• After reboring, r