



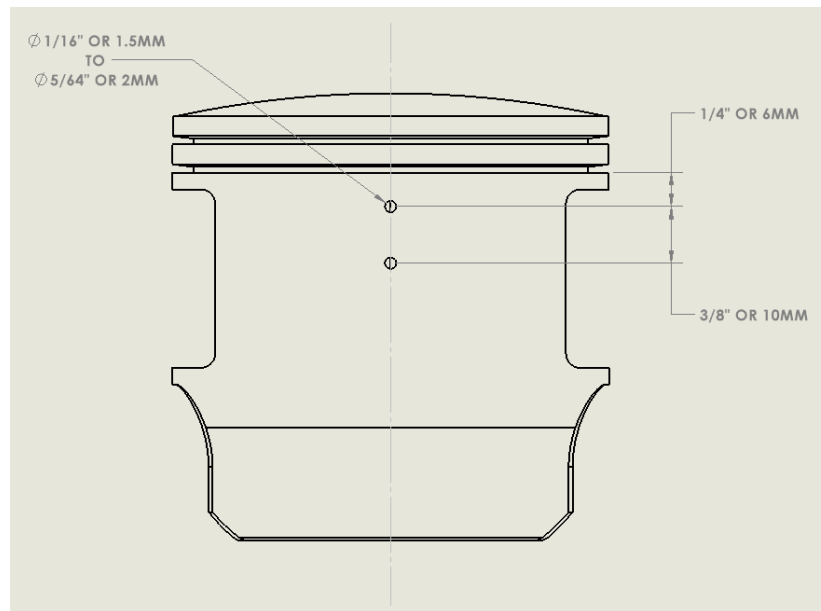
NOTE: Some two stroke engines will benefit from having exhaust oil holes added to enhance lubrication to the exhaust bridge. These instructions are a general guideline intended to illustrate the best methods to do this. Adding exhaust oil holes requires advanced skill, refer to a qualified engine builder if you are not able to perform this modification

Step 1: Slide the piston (without the piston rings installed) into the cylinder and align with the exhaust side facing the exhaust port. The piston will be marked on the crown indicating the exhaust direction. Raise the piston to the top of the cylinder. The exhaust side of the piston skirt should be visible through the exhaust port

Step 2. Using a pencil or marker, trace a line on the piston skirt for each side of the exhaust bridge

Step 3. Once the lines are traced and visible, remove the piston from the cylinder

Step 4. Next, mark the exhaust oil hole locations between the exhaust bridge traced lines. The first mark should be .250" (6mm) below the lowest ring groove. The second mark should be .375" (10mm) below the first mark. Make sure the points are centered vertically between the two trace lines (see picture)



Step 5. Drill lubrication holes 1/16" (1.5mm) to 5/64" (2mm) diameter on the marked points. Drill one hole for each mark

Step 6. The exhaust oil holes should be carefully deburred, and the inside of the piston should be free of any burrs or sharp edges. Use 400-600 grit sandpaper to deburr the inside of the piston. The piston should be thoroughly cleaned prior to final installation

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