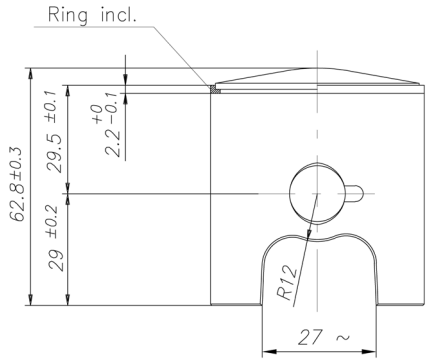
X30 125cc RL USA TaG

FEATURES	
Cylinder volume	123.67 cm³
Bore	54 mm
Max. bore	54.35 mm
Stroke	54 mm max.
Cooling system	Water
Inlet system	Reed valve

Carburettor	Tillotson HW-27A Ø27 mm	Cylinder / crankcase transfers n°	3
Number of piston rings	1	Inlet / exhaust ports number	3
Big end conr. bearing diam.	20x26x15	Combustion chamber shape	Spherical
Crankshaft bearing diam.	30x62x16	Selettra ignition	Digital “S”
Small end conr. bearing diam.	14x18x17.5	RPM limiter	Yes
Distance between conrod centers	102 mm	Centrifugal Dry Clutch	*Yes*
Balancing shaft	*Yes*	Electric starter	*Yes*

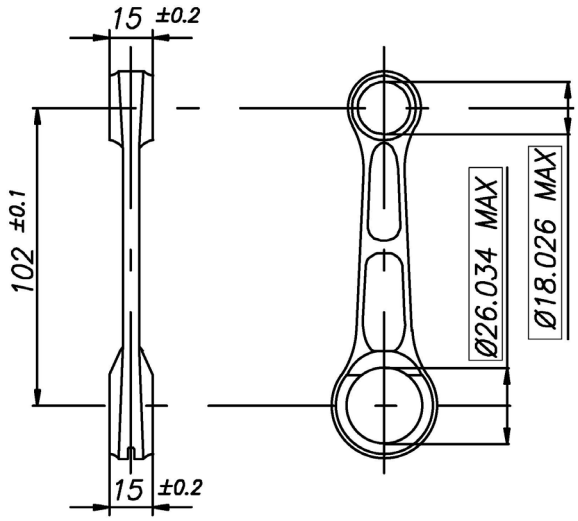
DESCRIPTION OF THE MATERIAL	
Conrod material	Steel
Crankshaft material	Steel
Balancing shaft material	Steel
Gears material	Steel
Starter ring material	Steel
Head material	Aluminium
Cylinder material	Aluminium
Liner material	Cast iron
Crankcase material	Aluminium
Piston material	Aluminium
Piston rings material	Cast iron
Exhaust muffler material	Sheet-steel
Ball-bearings	6206 type

PISTON



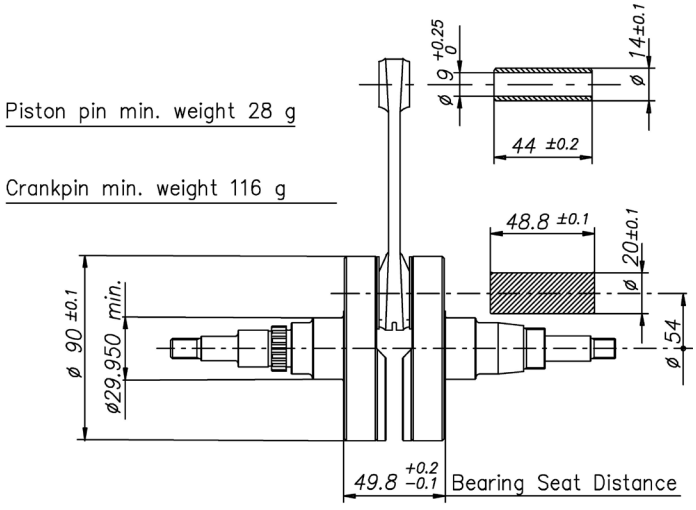
Piston min. weight (ring incl.) 128 g

DISTANCE BETWEEN CONROD CENTERS



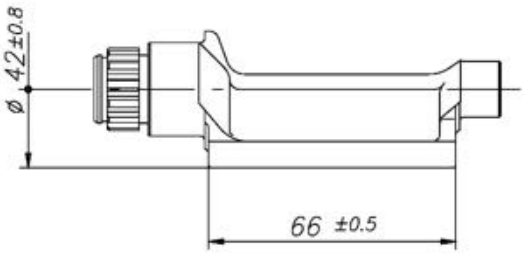
Min. weight 110 g

CRANKSHAFT



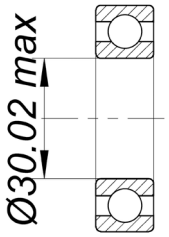
Complete crankshaft min. weight 2150 g

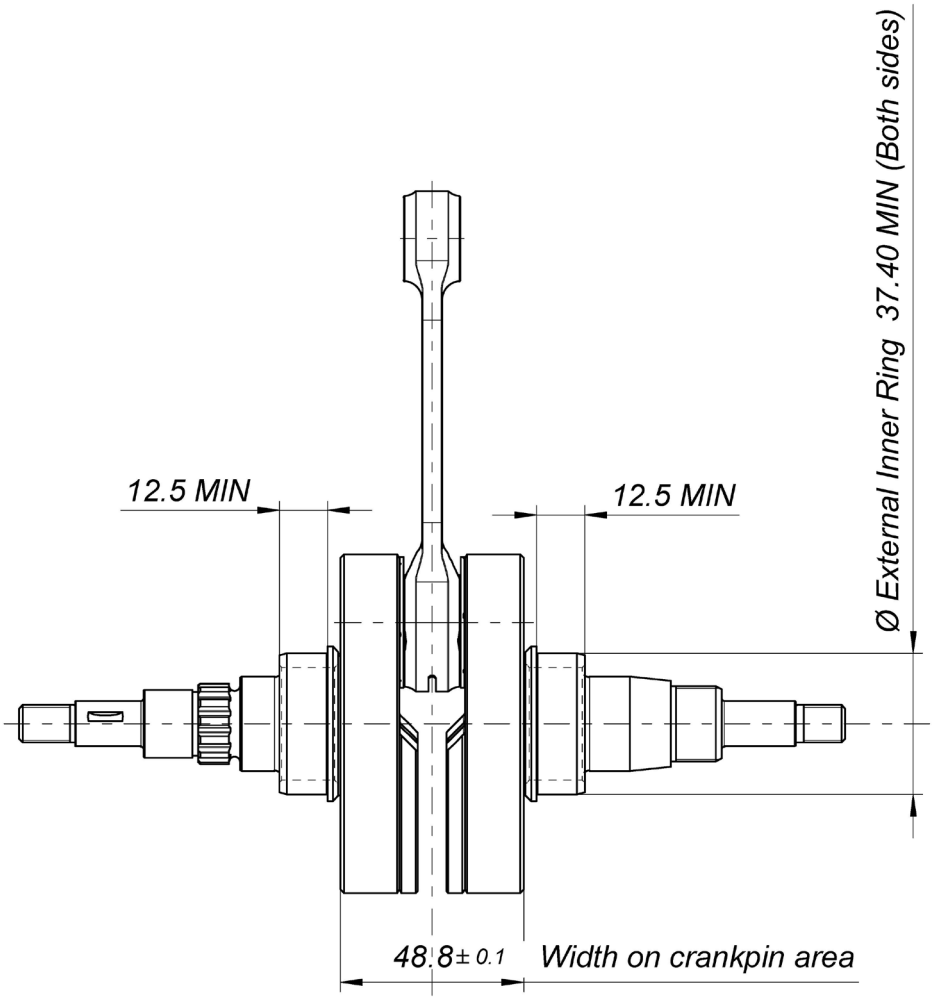
BALANCING SHAFT



Min. weight 315 g

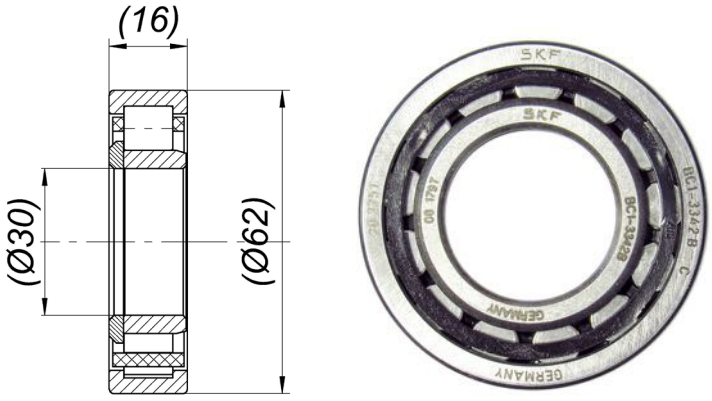
CRANKSHAFT BEARINGS



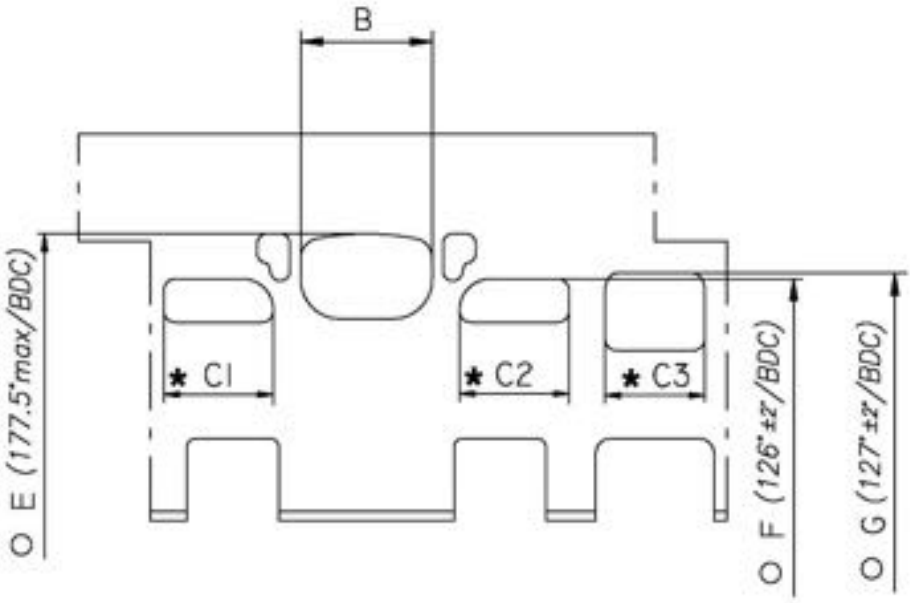


Crankshaft complete min. Weight 2220 g

MAIN ROLLER BEARING



CYLINDER DEVELOPMENT

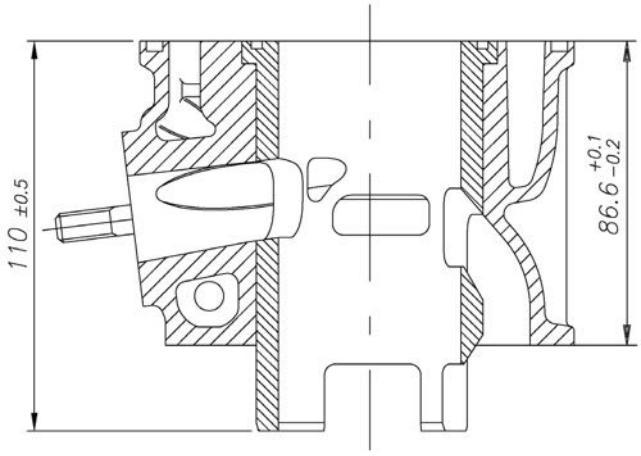


B	≤ 36.5 mm
C1 = C2	≤ 30 mm
C3	≤ 28.5 mm
E	177.5° max
F	126° ± 2°
G	127° ± 2°

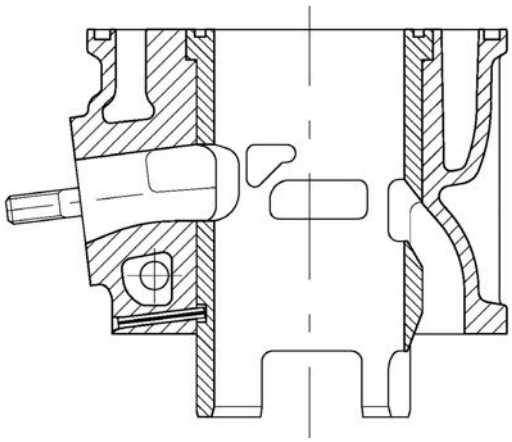
* *CHORDAL READING*

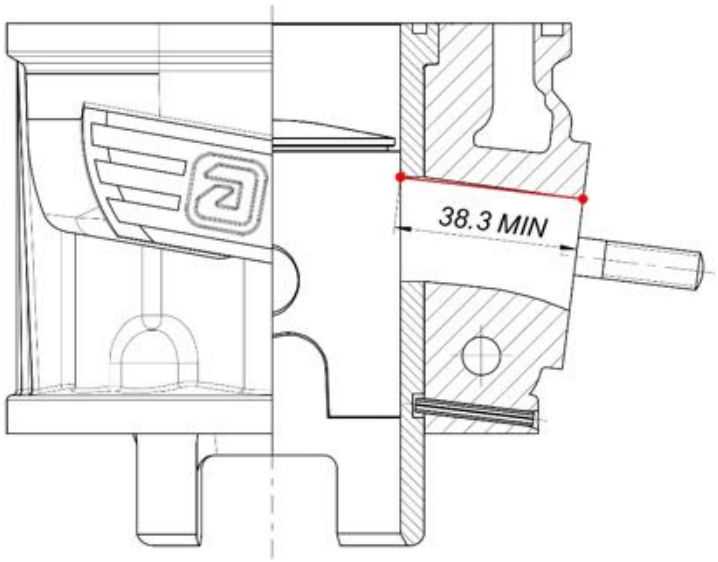
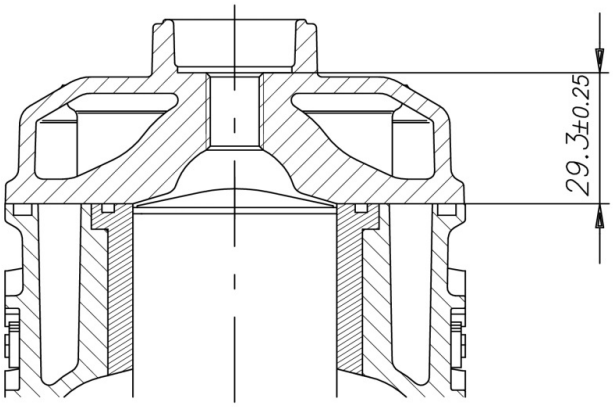
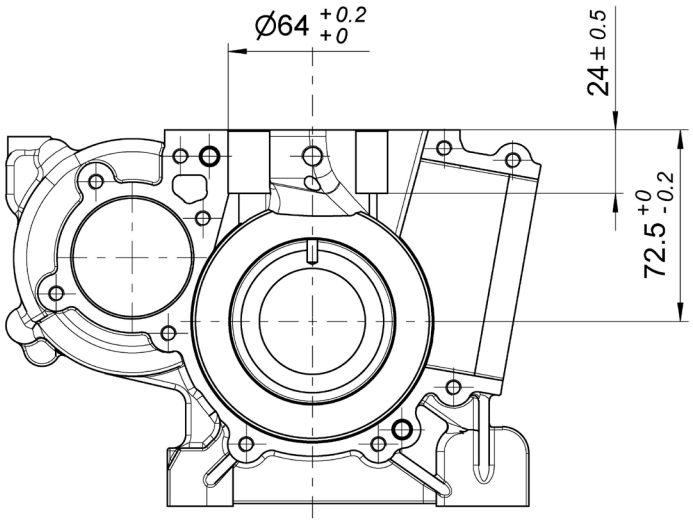
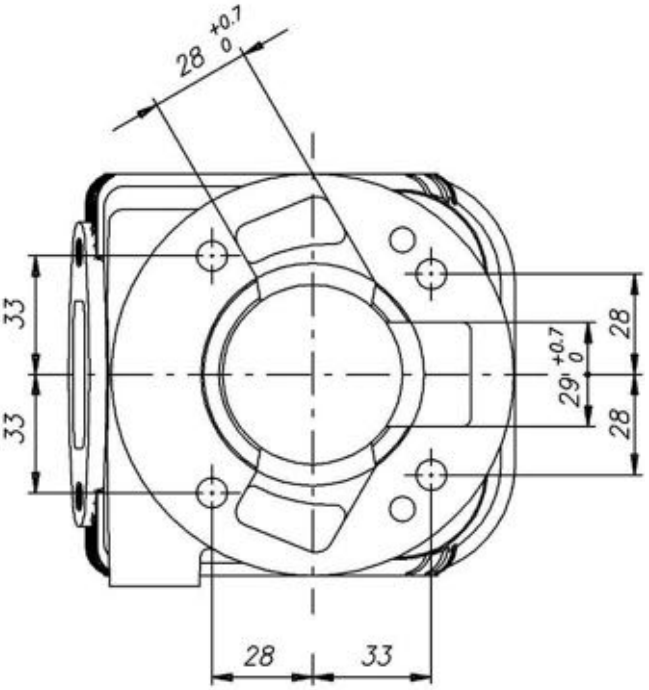
O *ANGULAR READING BY INSERTING A 0.2x5 mm GAUGE*

CYLINDER CROSS SECTION VIEW (without or with pin)

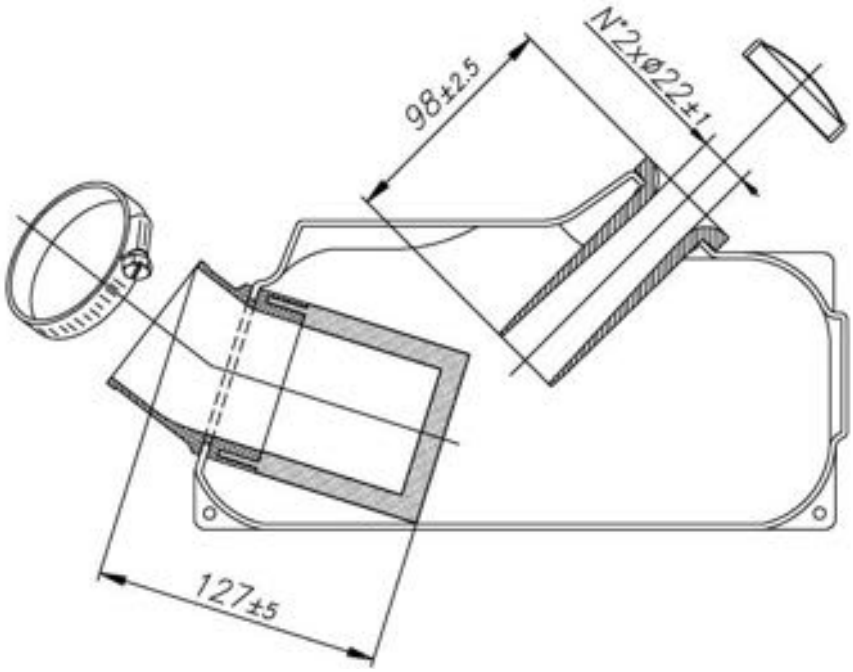


FROM 2014 ON



DISTANCE FROM EXHAUST FLANGE TO PISTON	CYLINDER BASE VIEW
	 ***SQUISH MIN.= 0.0354" (0.9 mm)*** ***(measured with 0.0625" (1/16") / Ø1.6mm solder)***
CRANKCASE INSIDE VIEW	CYLINDER BASE VIEW
	

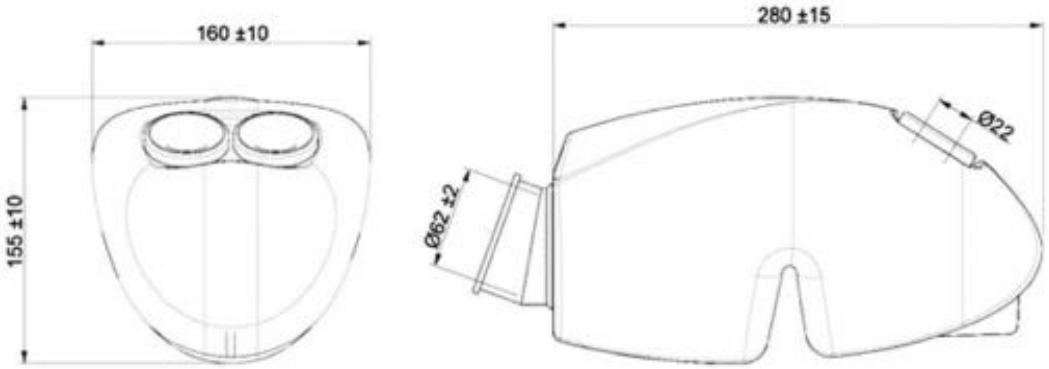
INLET SILENCER – DRAWING



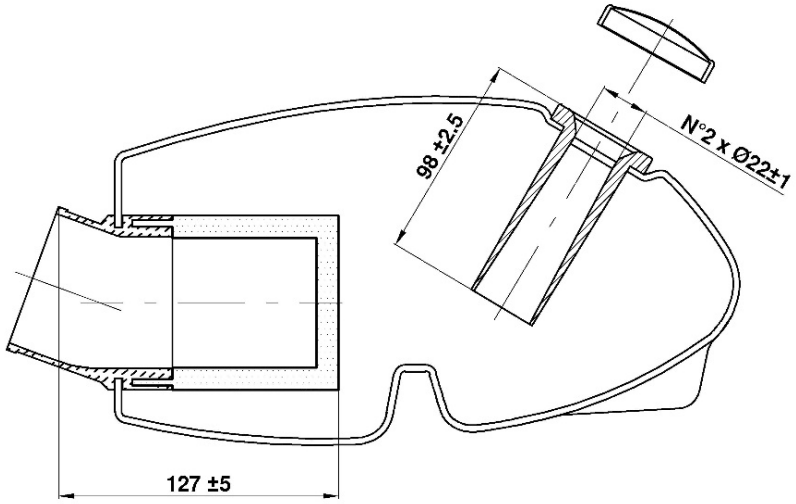
WITH MANIFOLD SPONGE OF AIR FILTER

INLET SILENCER - PHOTO

ALTERNATIVE INLET SILENCER – DRAWING

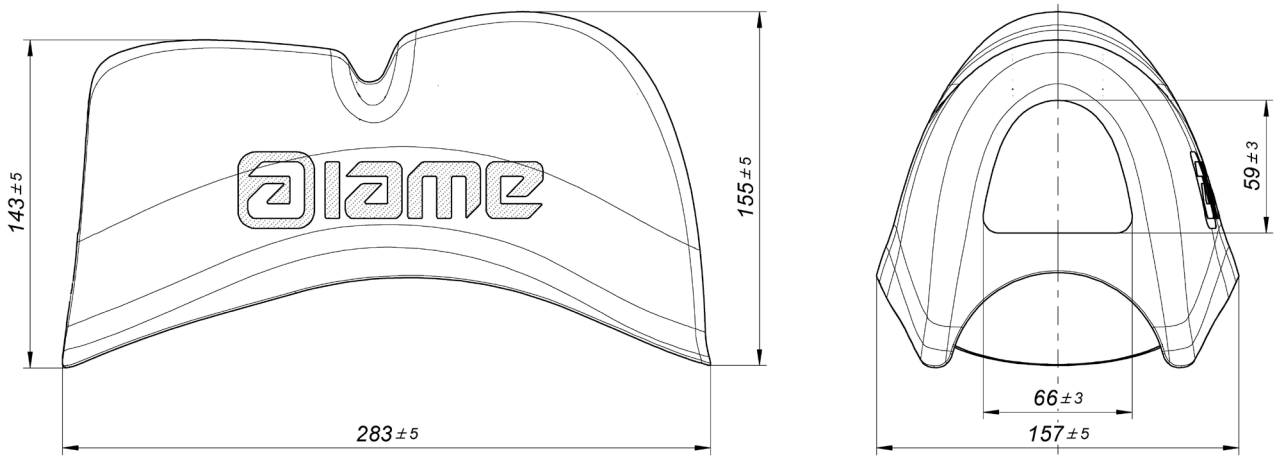


WITH MANIFOLD SPONGE OF AIR FILTER



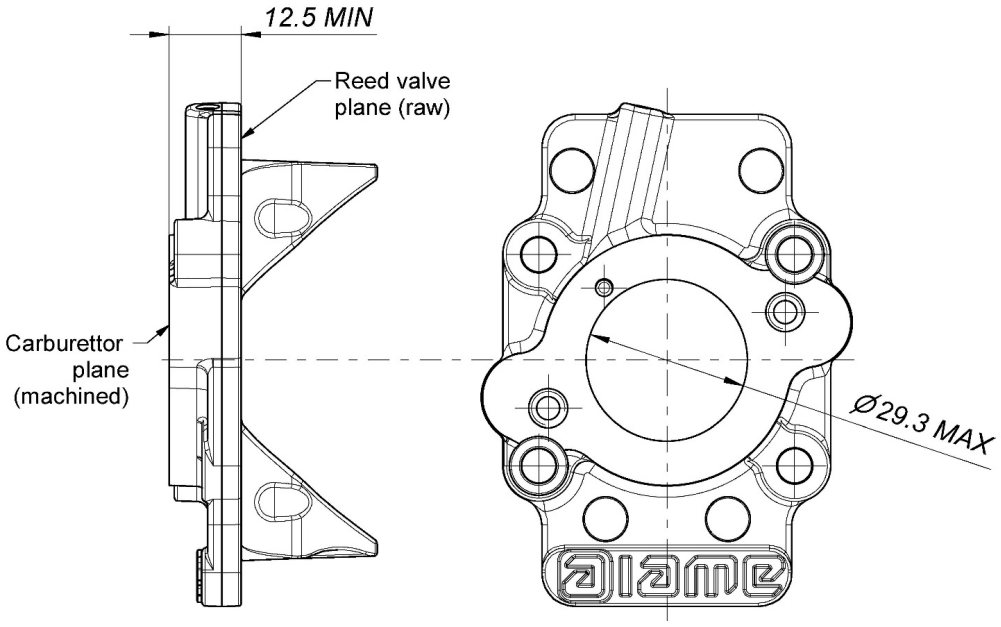
ALTERNATIVE INLET SILENCER - PHOTO

RAIN COVER FOR ALTERNATIVE INLET SILENCER – DRAWING

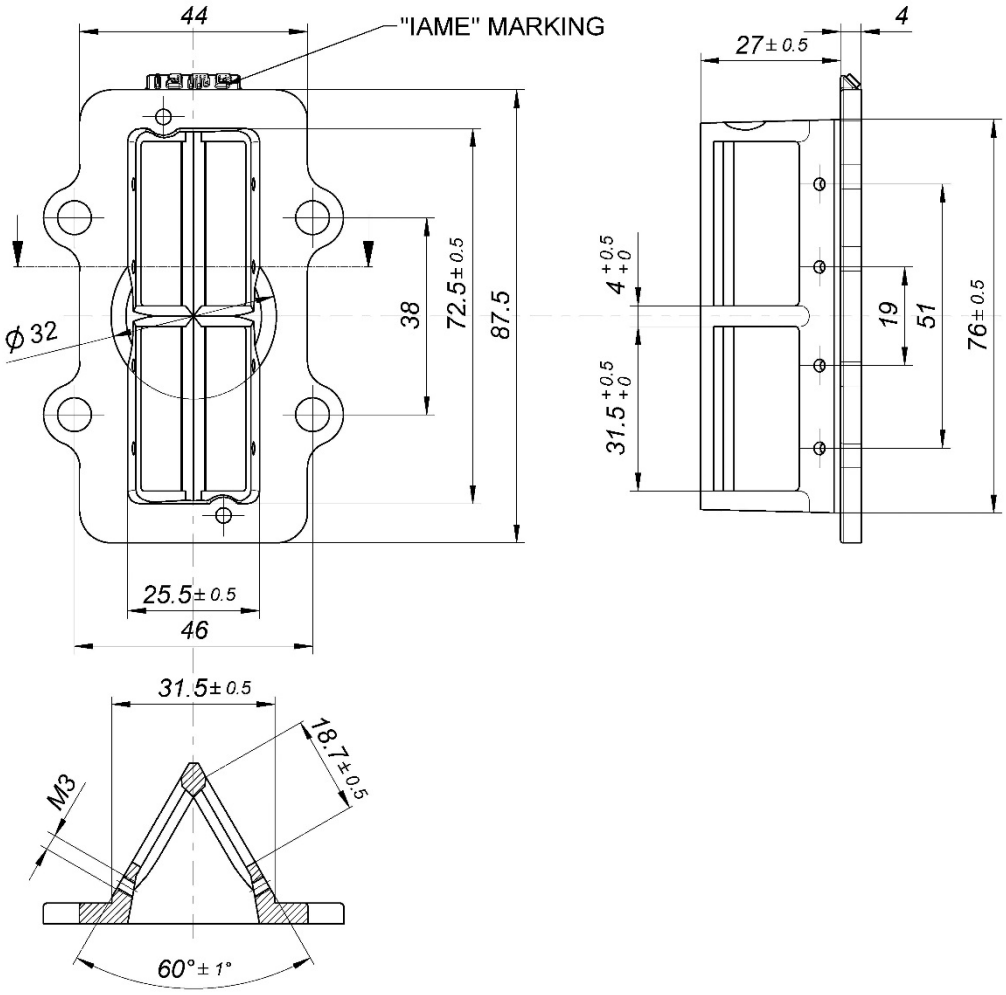


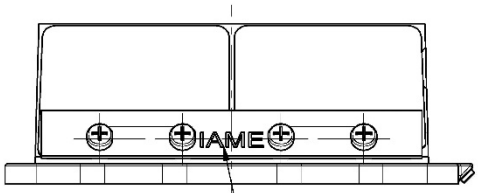
RAIN COVER FOR ALTERNATIVE INLET SILENCER - PHOTO

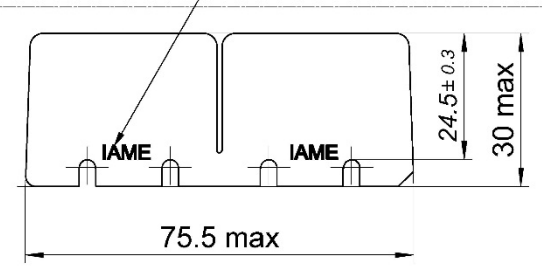
INLET CONVEYOR DIMENSIONS



REED VALVE - DIMENSIONS AND MARKING

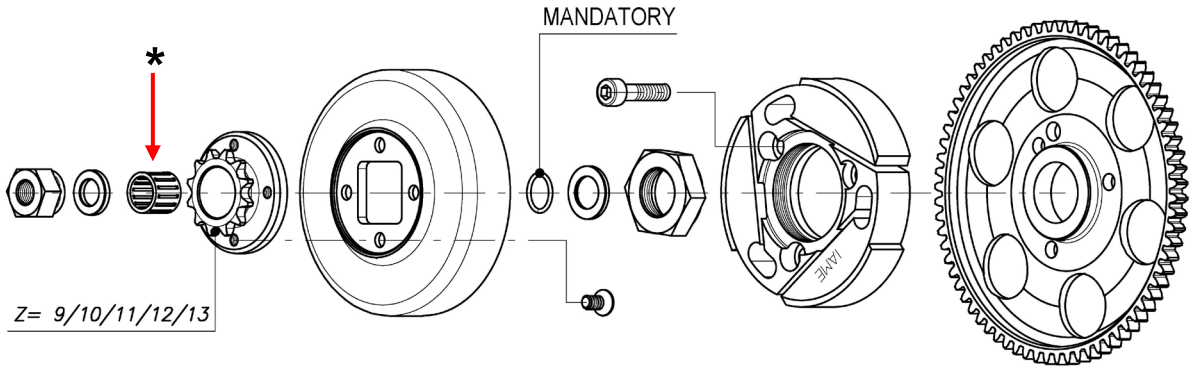




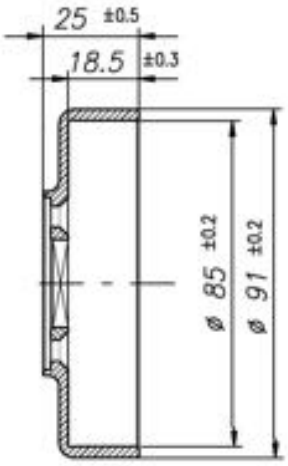


Genuine IAME fiber glass reeds min. thickness 0.30mm

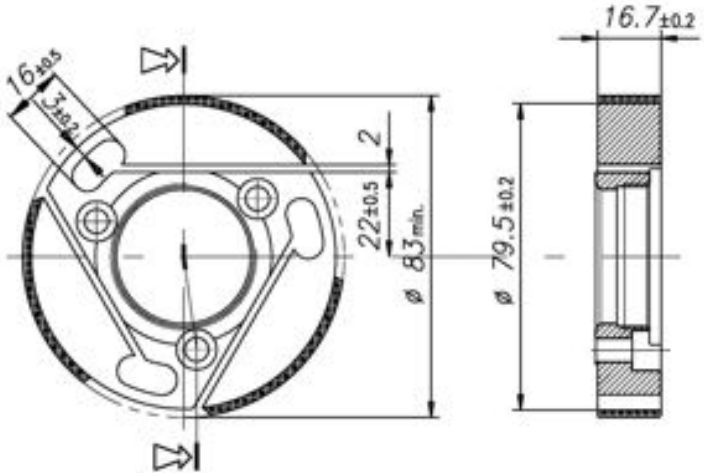
DESCRIPTION OF THE CLUTCH



* When using the Z9, the roller cage is replaced by a bronze bushing, pressed into the sprocket

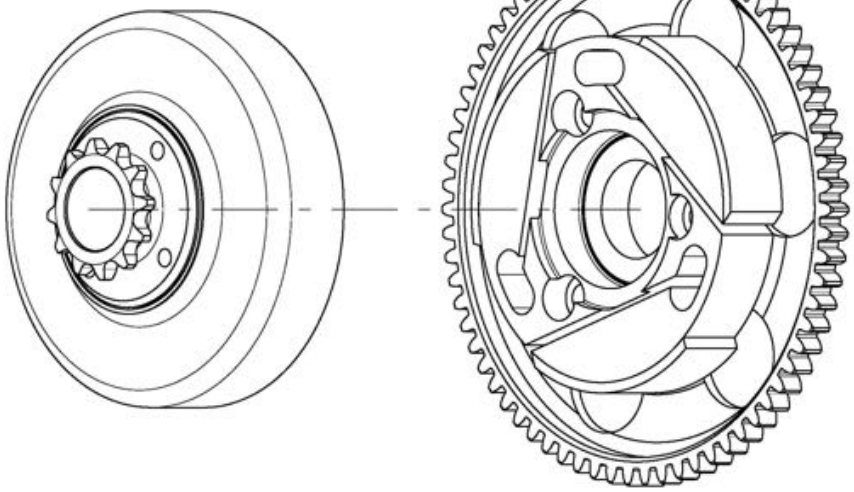


Min. weight 225 g



Min. weight 375 g

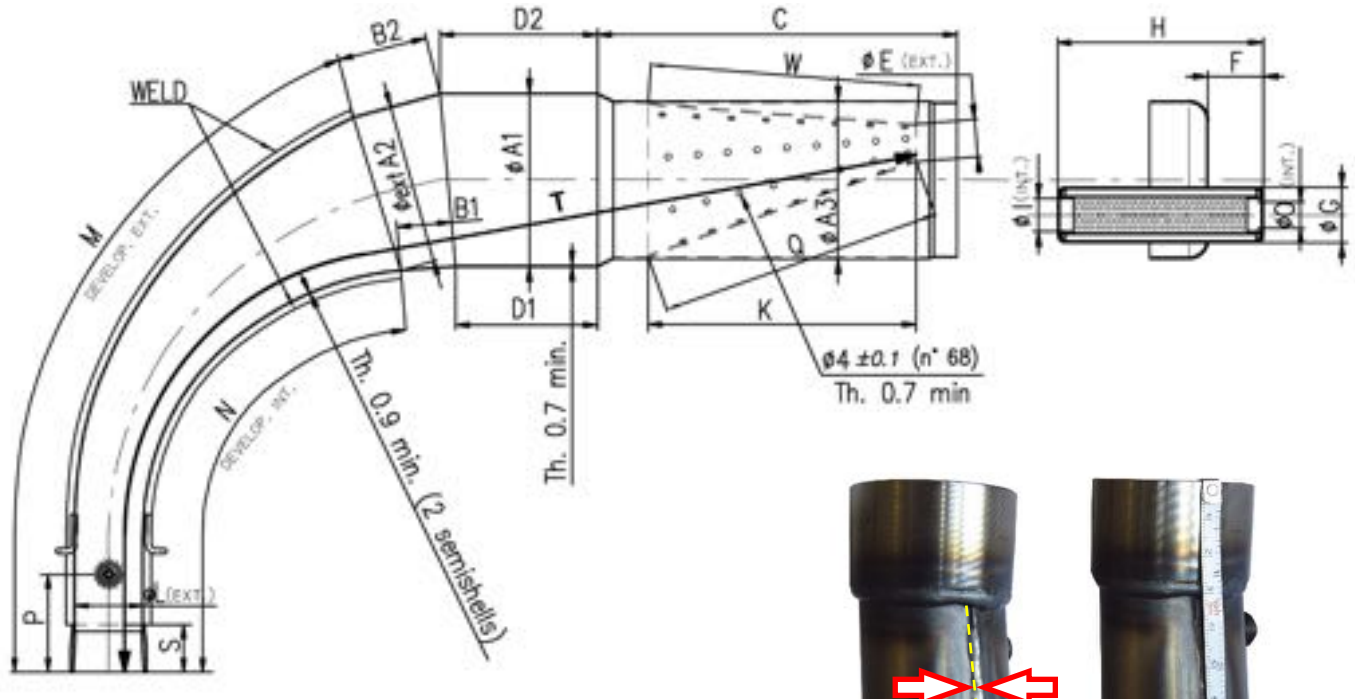
DESCRIPTION OF THE CLUTCH

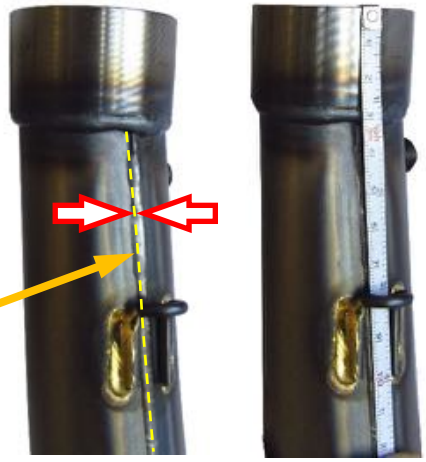


Min. weight 300 g
Poids min. 300 g

Min. weight 680 g
Poids min. 680 g

SENIOR EXHAUST MUFFLER VIEW AND DIMENSIONS





The tape must follow the centerline of the weld at all points

Min. weight 1.780 g

ØA1: 110 ±1.5 Øext.	**B2:** 60 ±3	**ØE:** 23.5 ±2 Øext.	**ØI:** 21 ±1 Øint.	**N:** 341 ±3	**T:** 690 ±3
ØA2: 102 ±1.5 Øext.	**C:** 219 ±3	**F:** 36 ±2	**K:** 170 ±3	**ØO:** 21 ±1 Øint.	**W:** 170 ±3
ØA3: 100 ±1.5 Øext.	**D1:** 90 ±3	**ØG:** 35 ±1 Øext.	**ØL:** 42.5 ±1.5 Øext.	**P:** 50 ±10	**Q:** 182 ±3
B1: 60 ±3	**D2:** 109 ±3	**H:** 132 ±3	**M:** 439 ±3	**S:** 29 ±1.5	

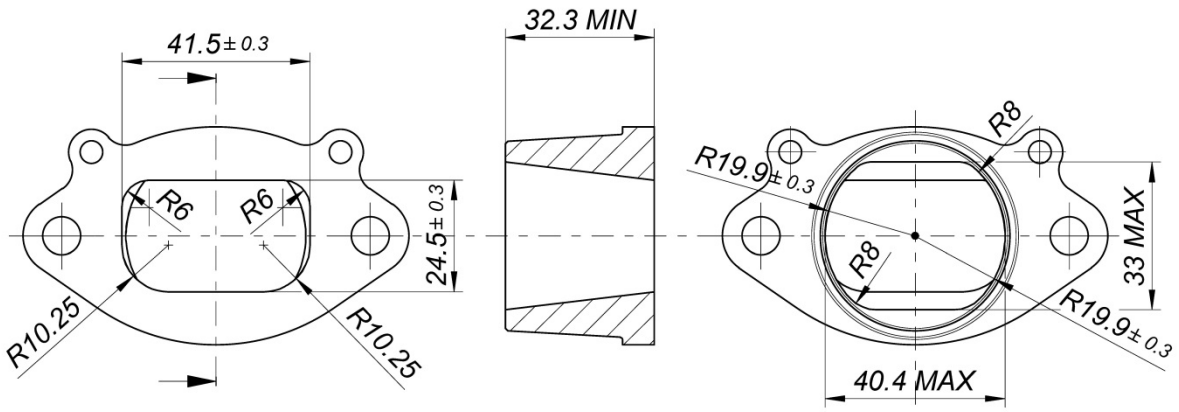
ATTENTION:

The dimensions “**M**”, “**N**” and “**T**” must be taken by steel tape measure 6mm wide.

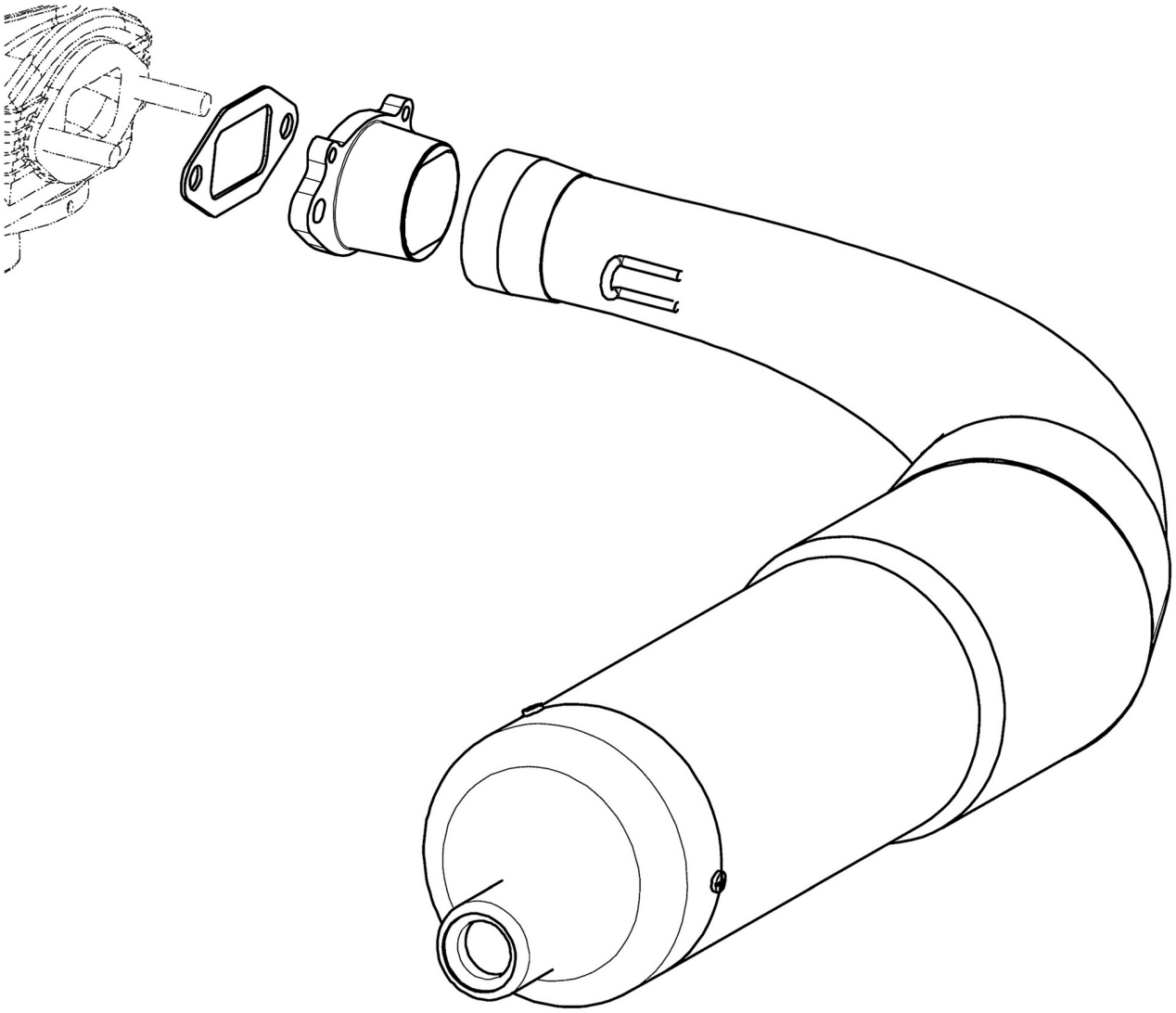
The dimensions “**M**” and “**N**” must be taken on the weld centerline.

The dimensions “**Q**” and “**W**” must be taken by steel tape measure 12mm wide.

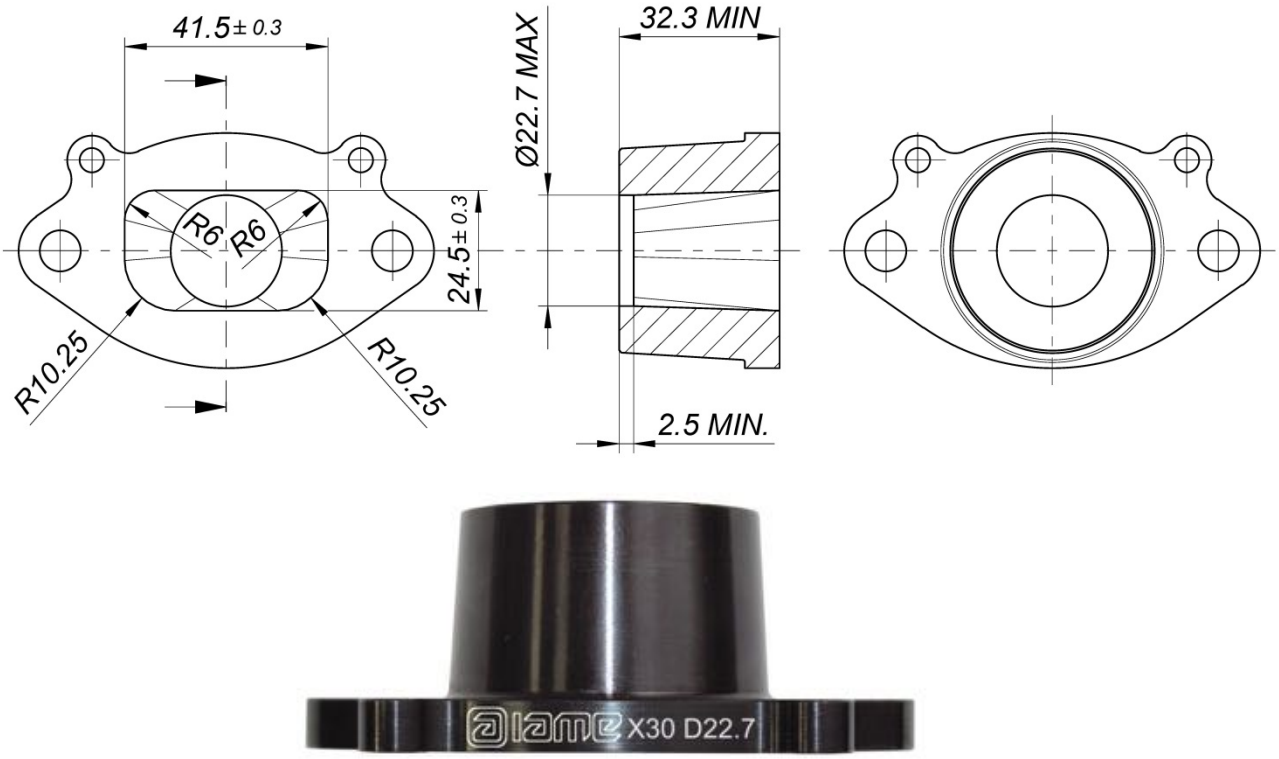
SENIOR EXHAUST FITTING



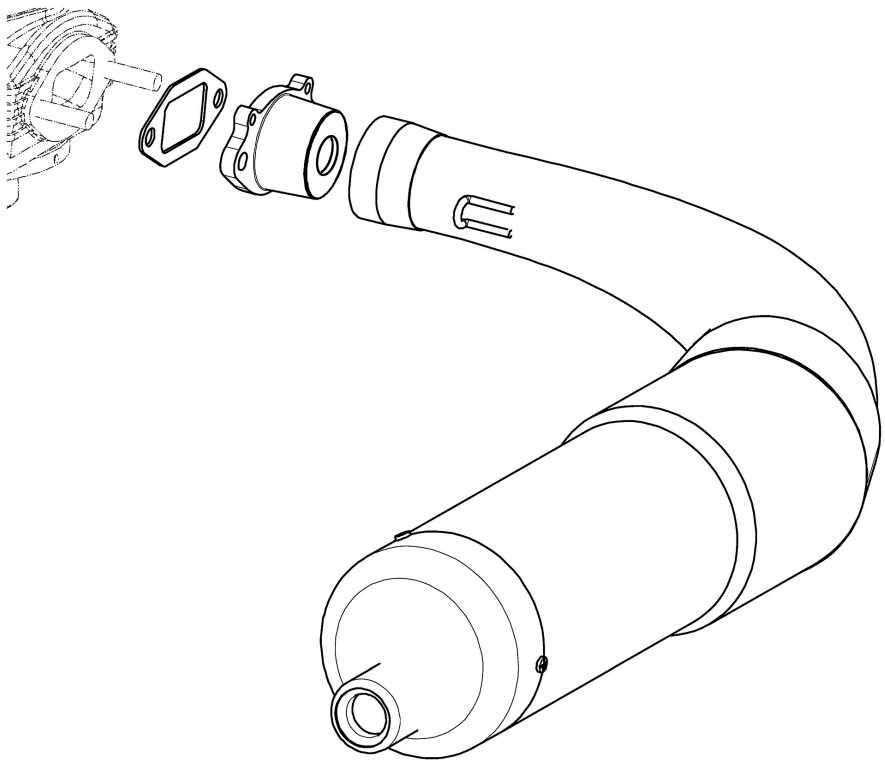
SENIOR MUFFLER INSTALLATION



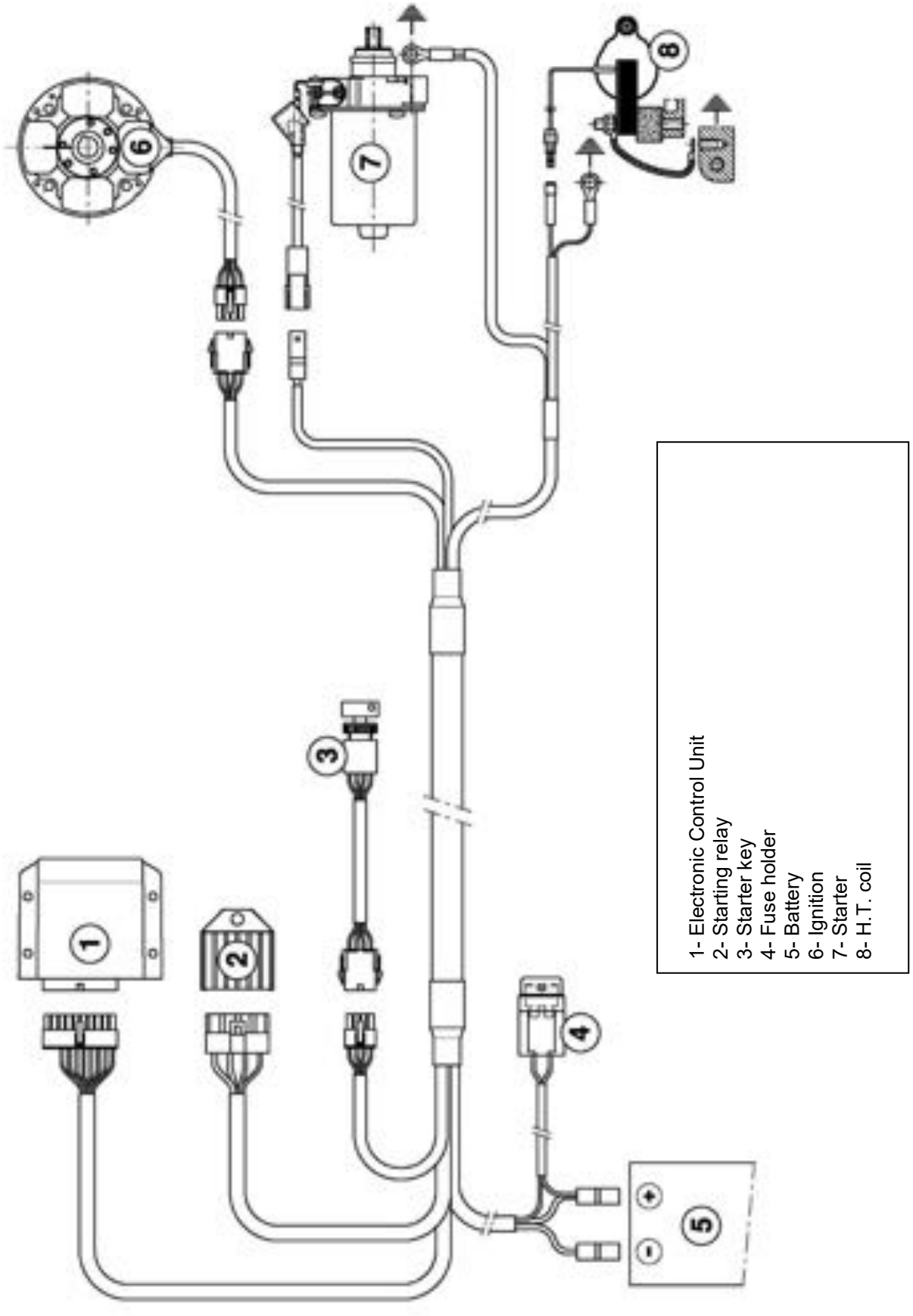
JUNIOR EXHAUST FITTING



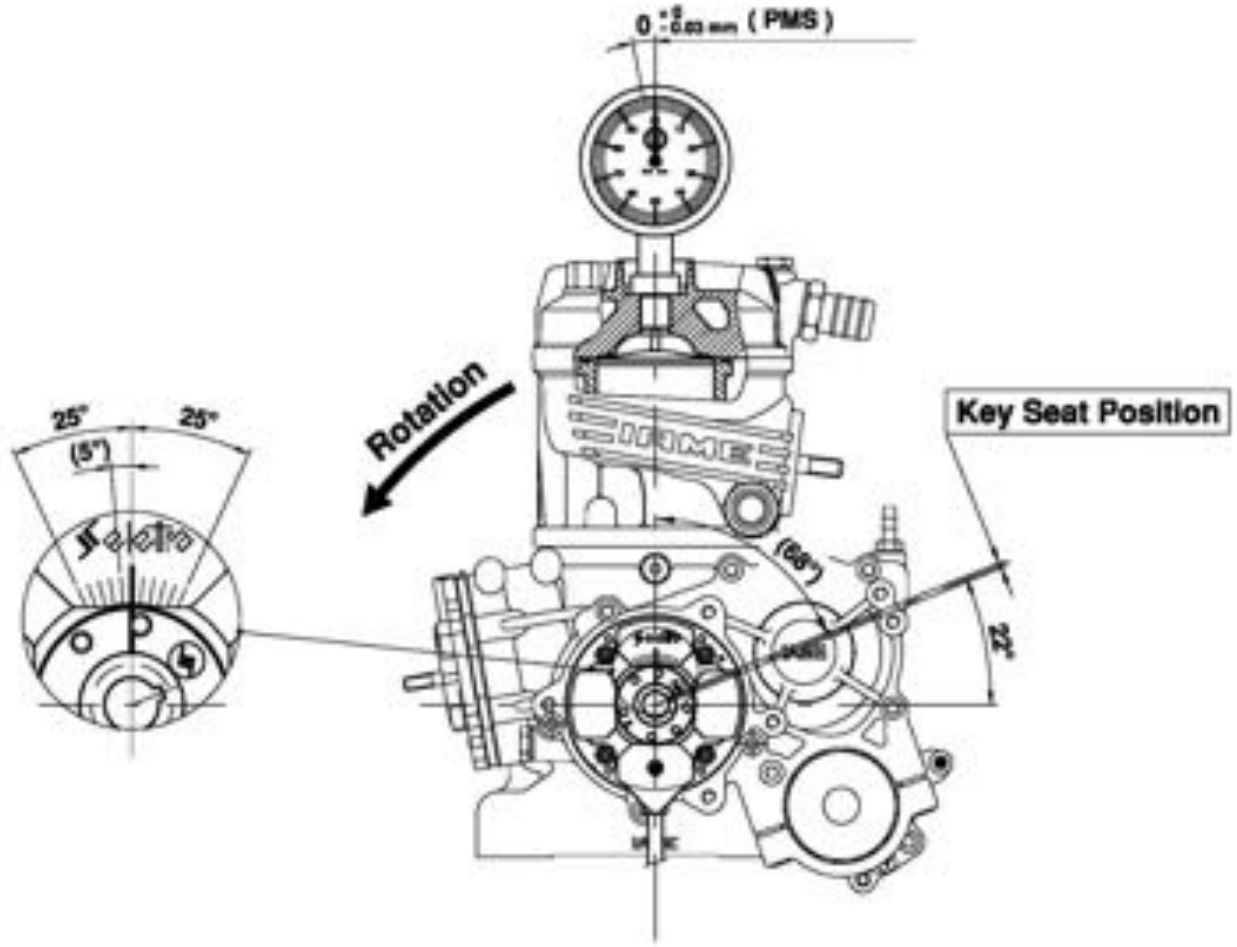
JUNIOR MUFFLER INSTALLATION



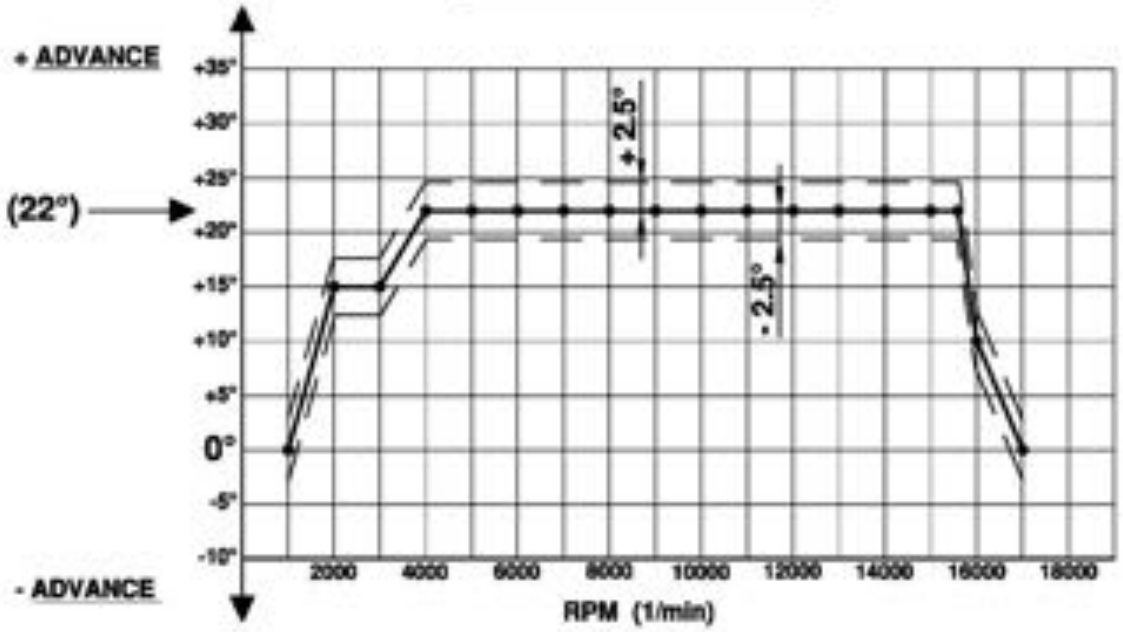
WIRING DIAGRAM (SELETTRA DIGITAL ''K'' IGNITION)



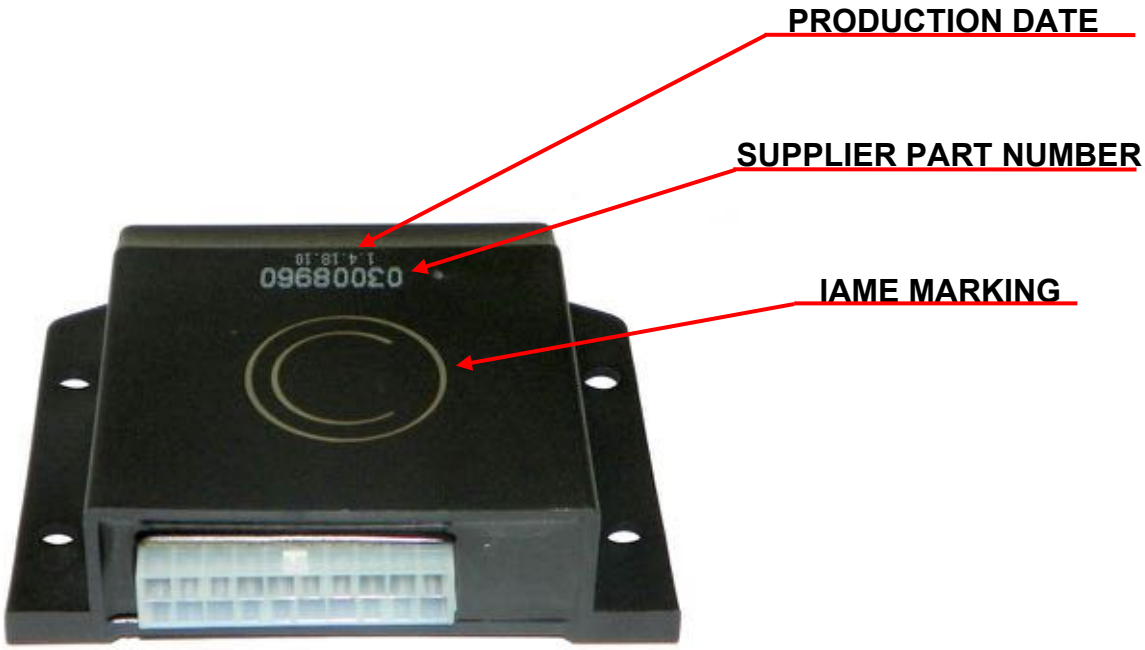
SCHEME FOR ADVANCE CONTROL SELETTRA DIGITAL ''K'' IGNITION



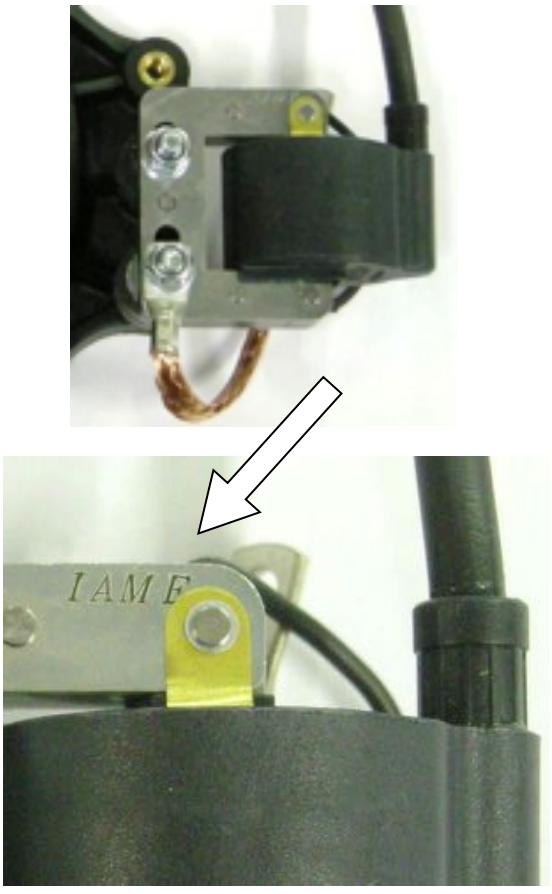
ADVANCE CURVE GRAPHS



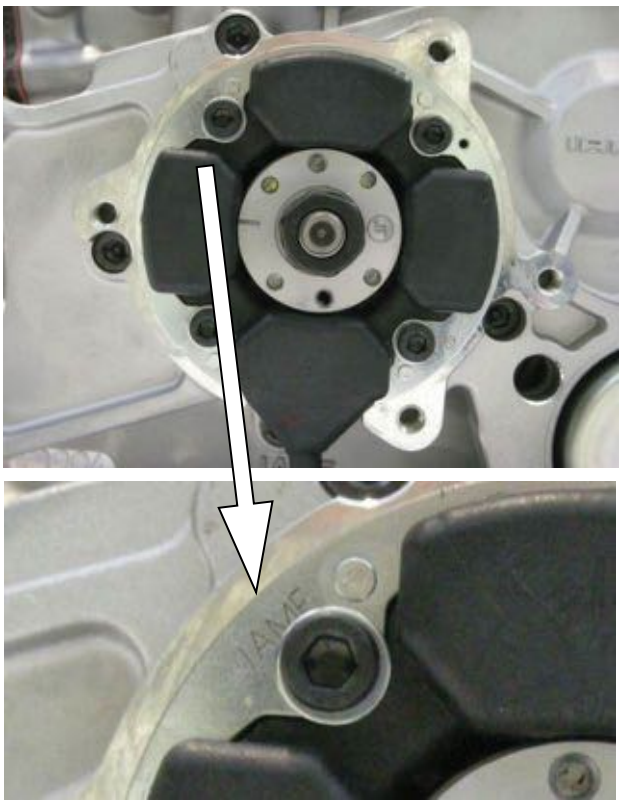
ELECTRONIC BOX MARKING



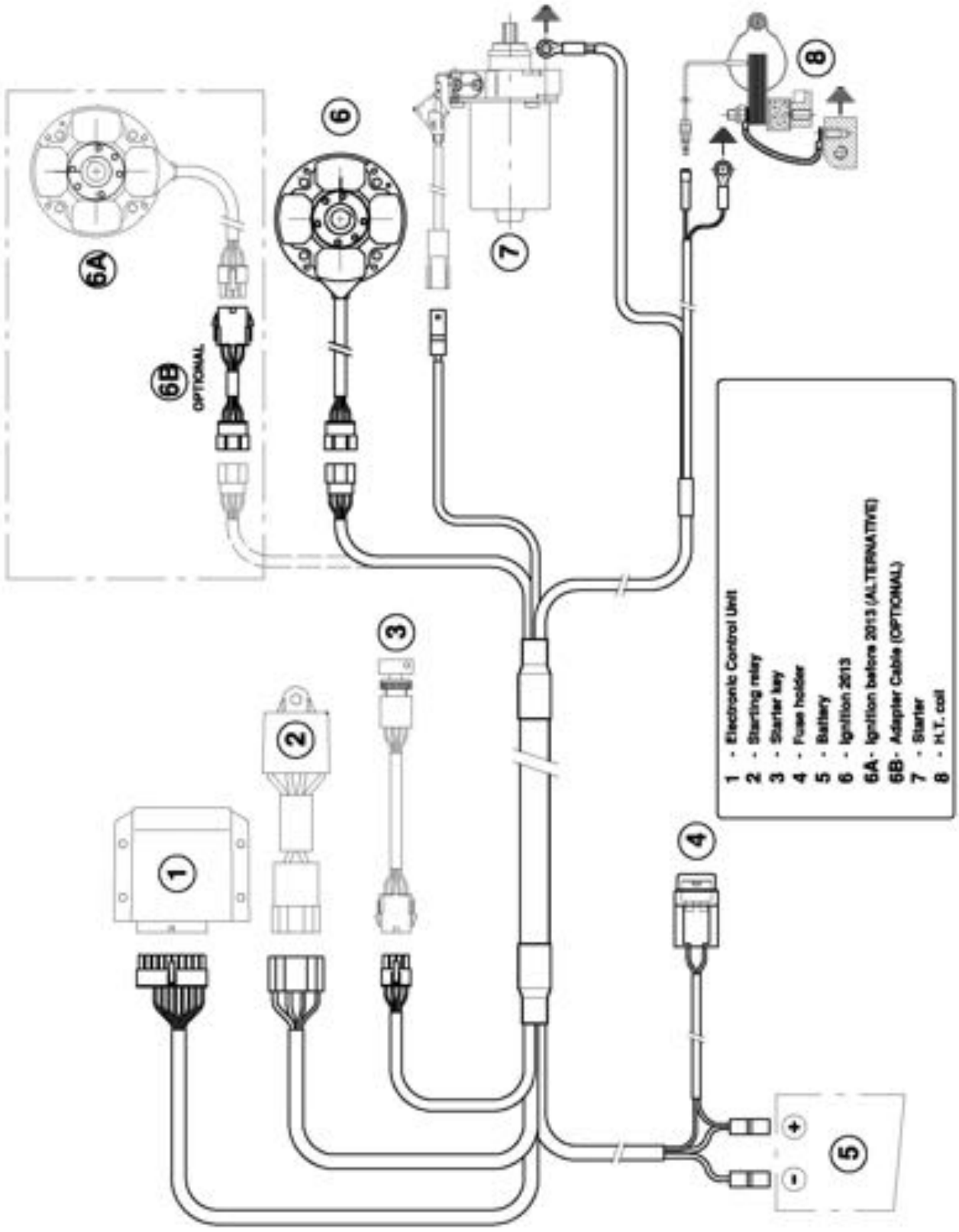
H.T. COIL IDENTIFICATION MARKING



STATOR IDENTIFICATION MARKING

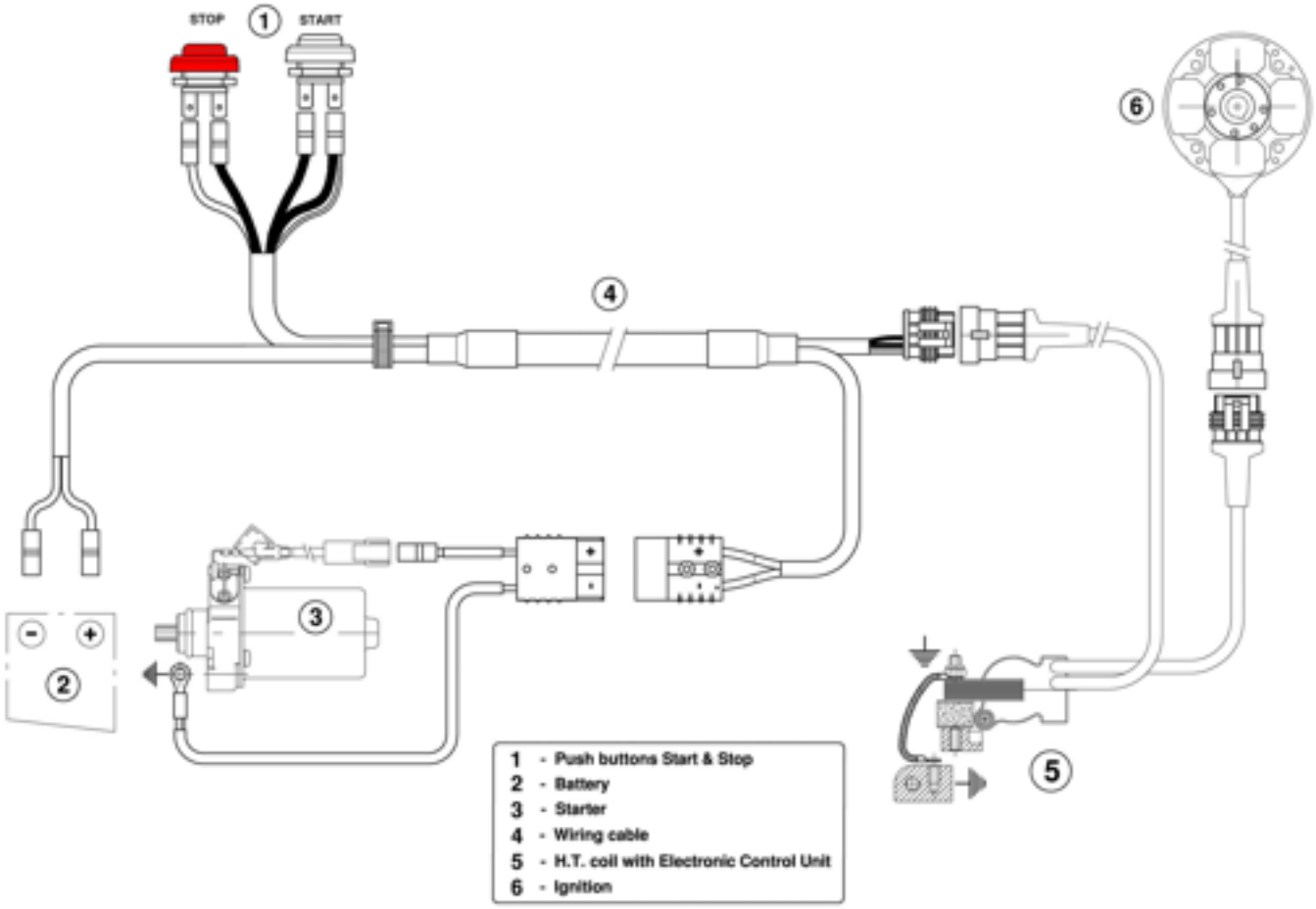


WIRING DIAGRAM (SELETTRA DIGITAL ''K'' IGNITION 2013)



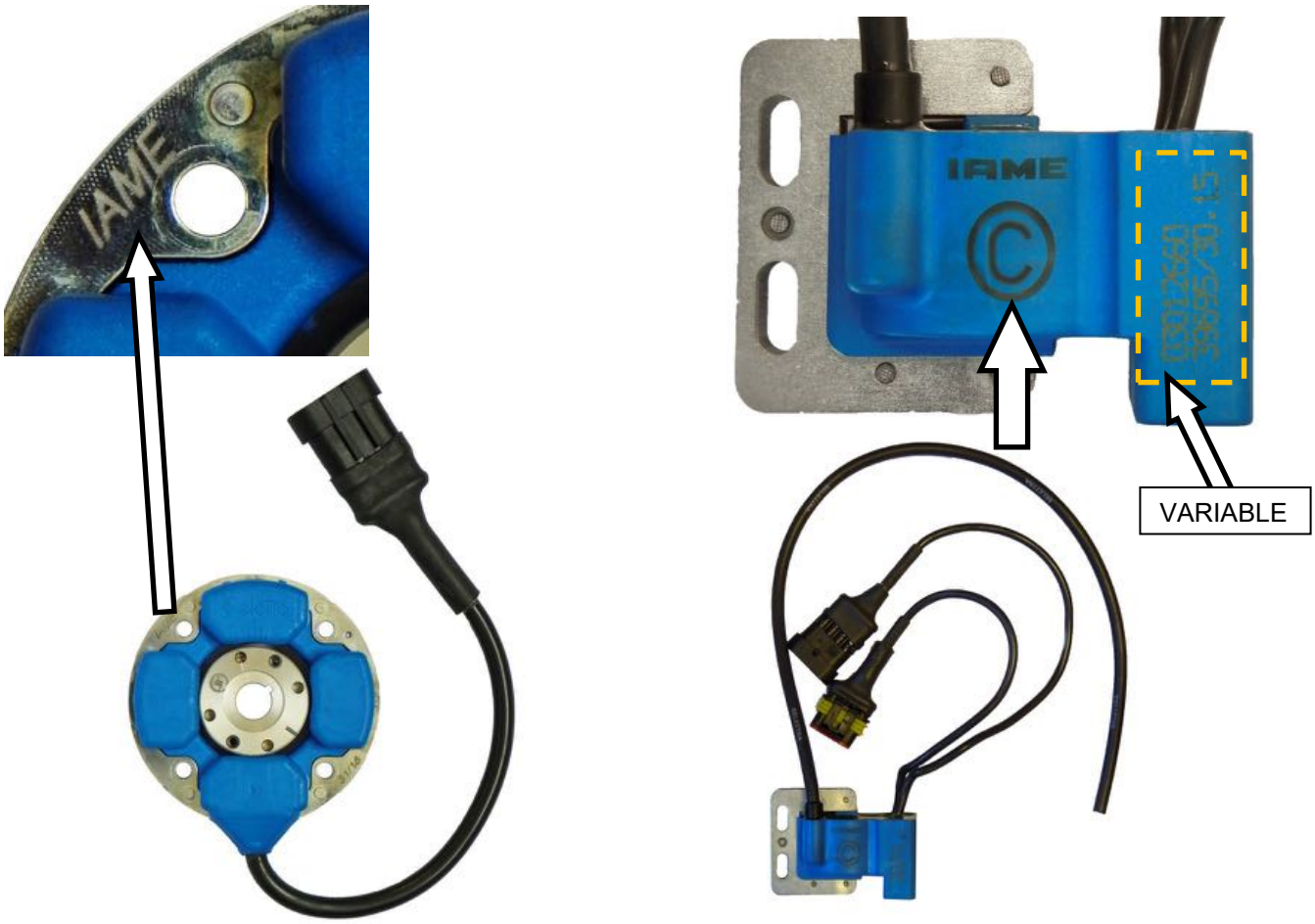
INGNITION STATOR FASTENING COMPONENTS MAIN DIMENSIONS

ALTERNATIVE WIRING LOOM DIAGRAM - SELETTRA DIGITAL “S”

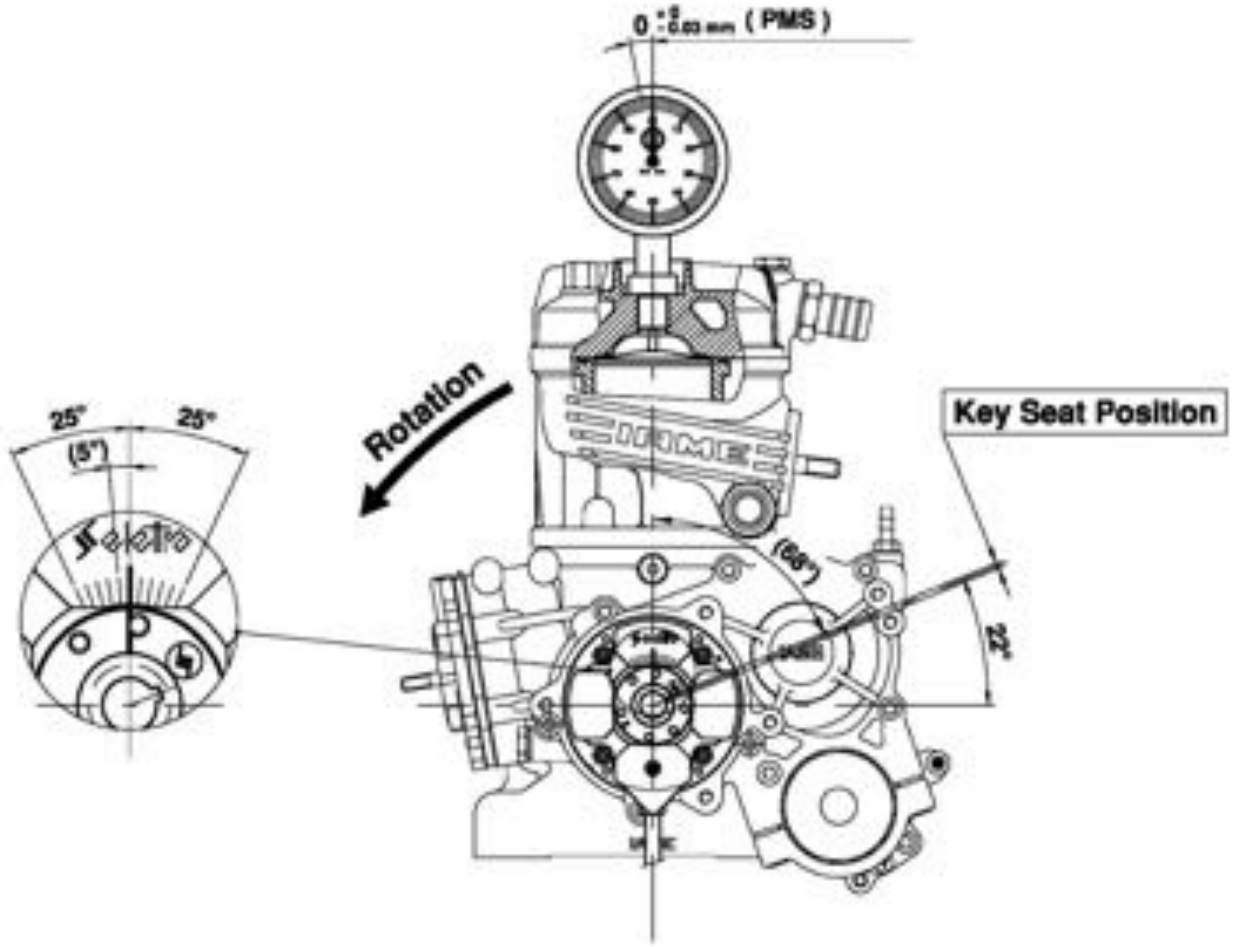


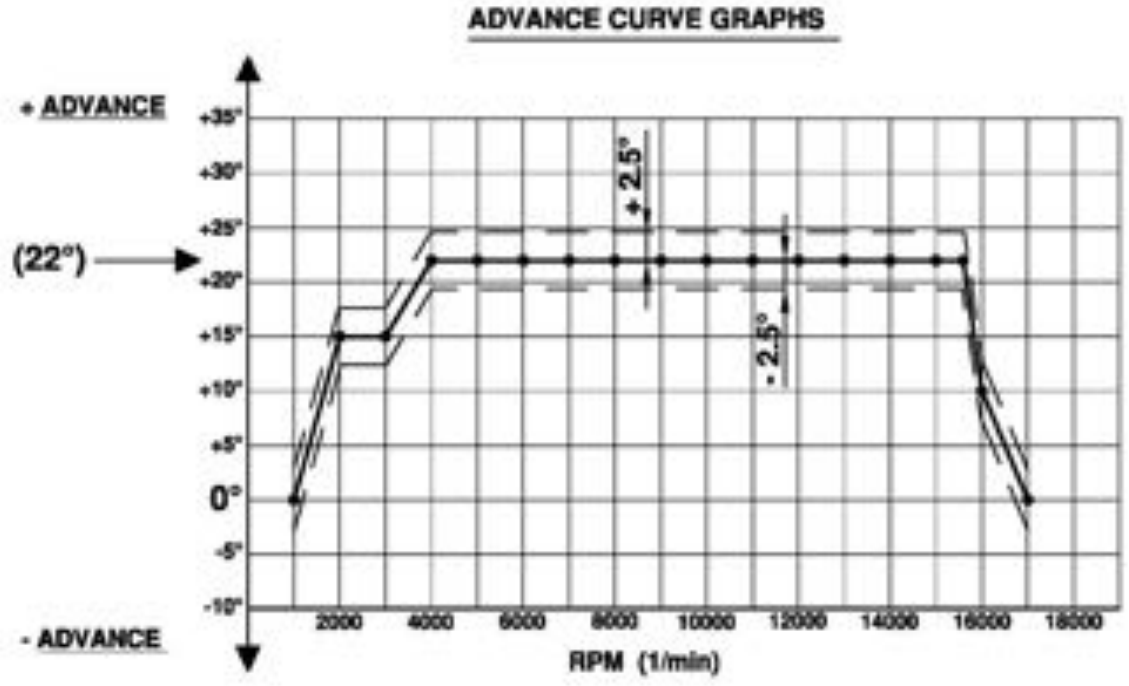
ALTERNATIVE WIRING LOOM - SELETTRA DIGITAL “S”

ALTERNATIVE INGNITION COMPONENTS AND STATOR FASTENING
SELETTRA DIGITAL “S”

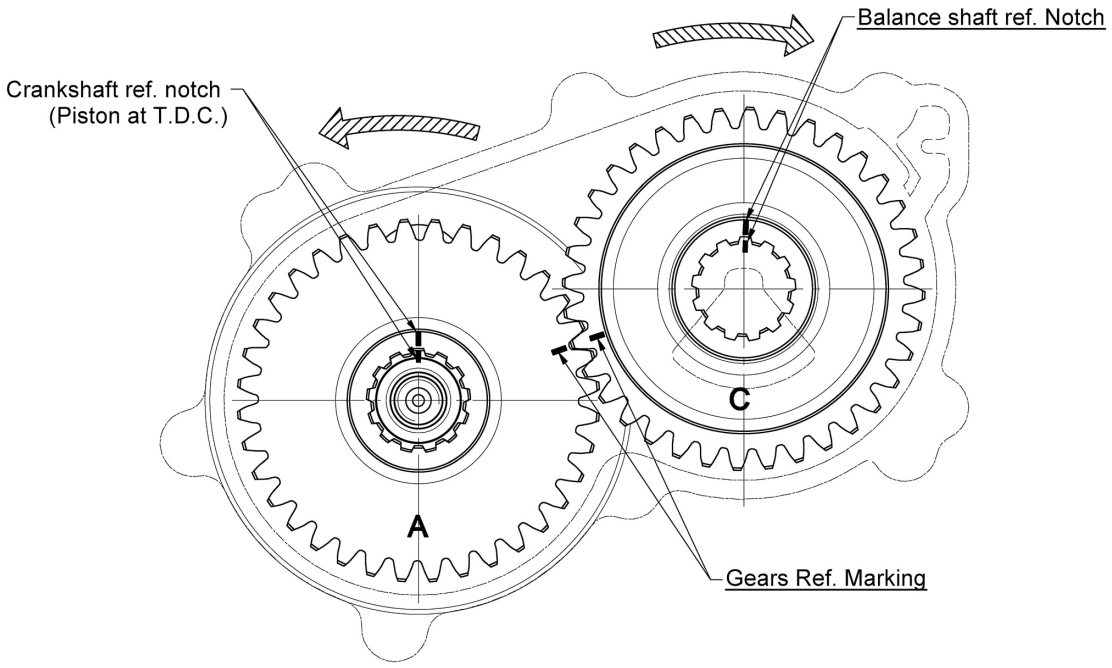


SCHEME FOR ADVANCE CONTROL SELETTRA DIGITAL “S”

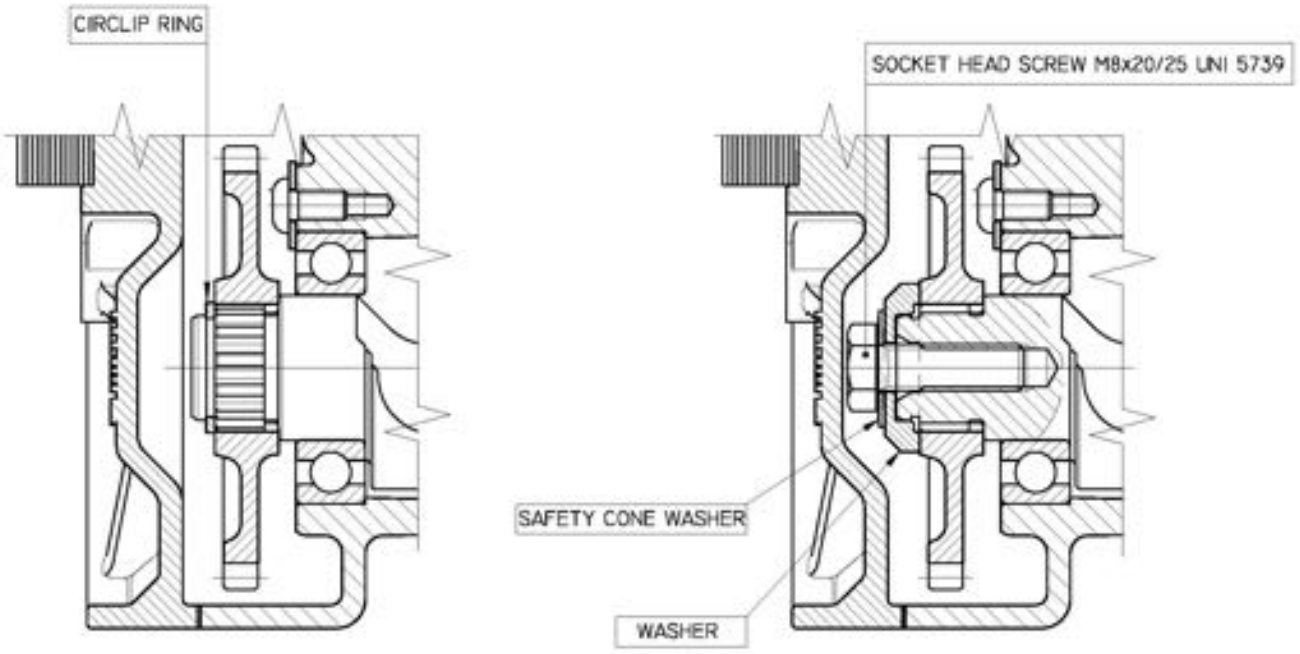




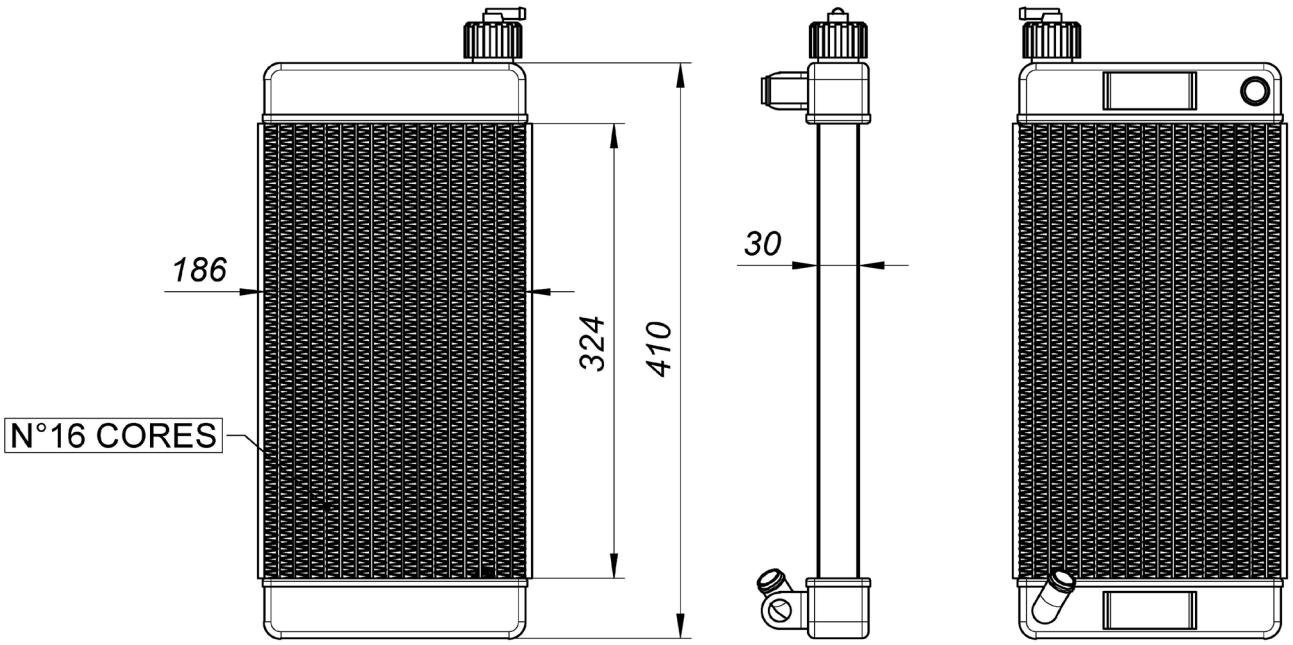
BALANCER SHAFT GEAR TIMING SCHEME



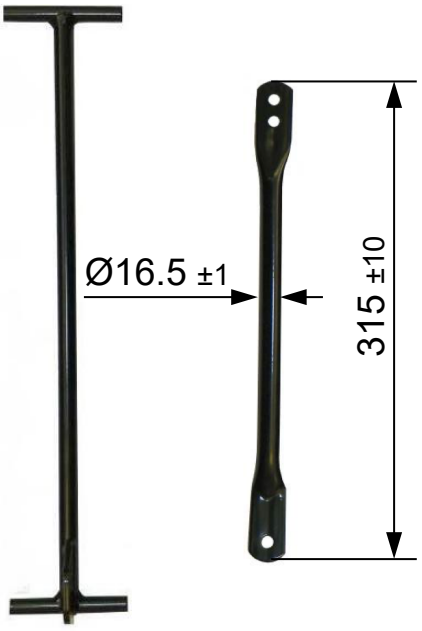
GEAR ALTERNATIVE FIXING



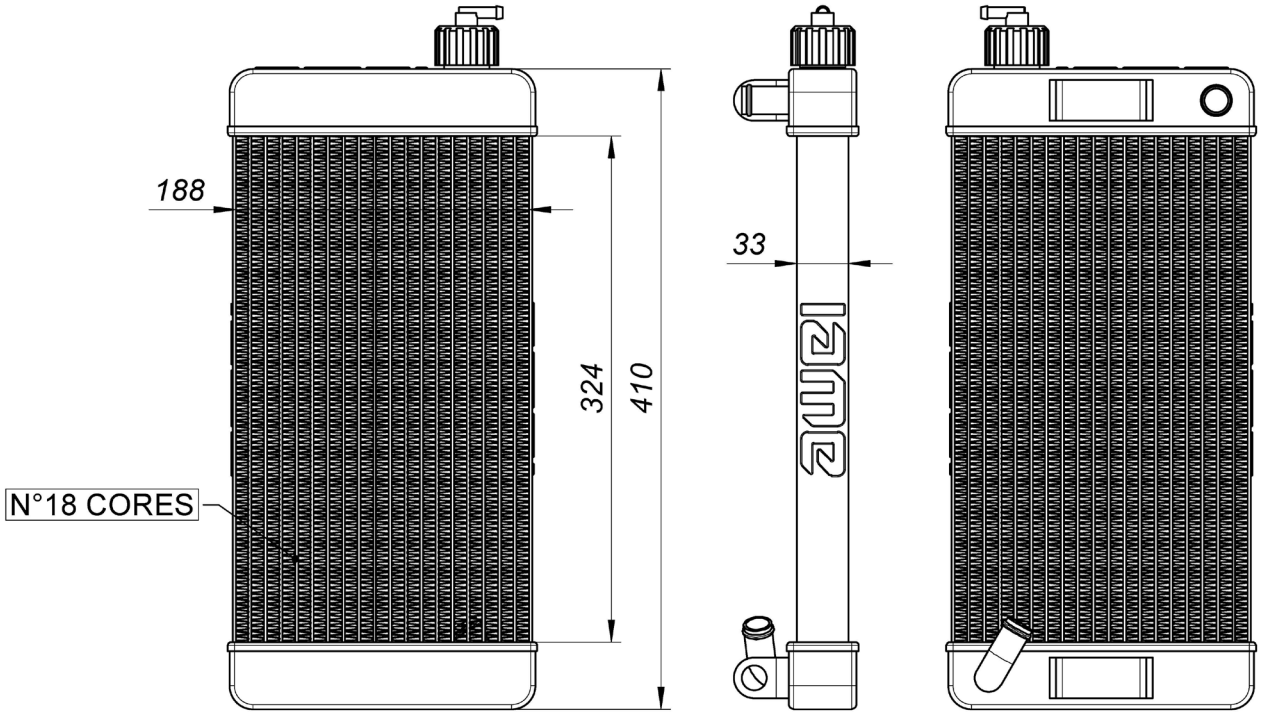
RADIATOR DESCRIPTION AND SKETCH OF PARTS



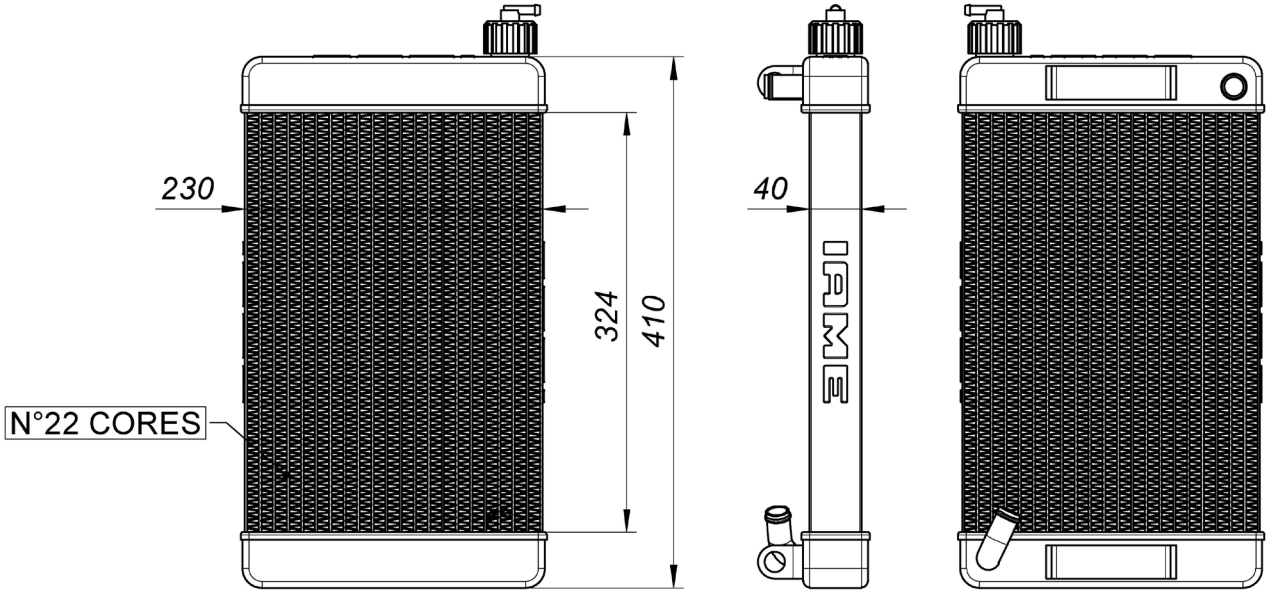
PAINTED AND NOT PAINTED



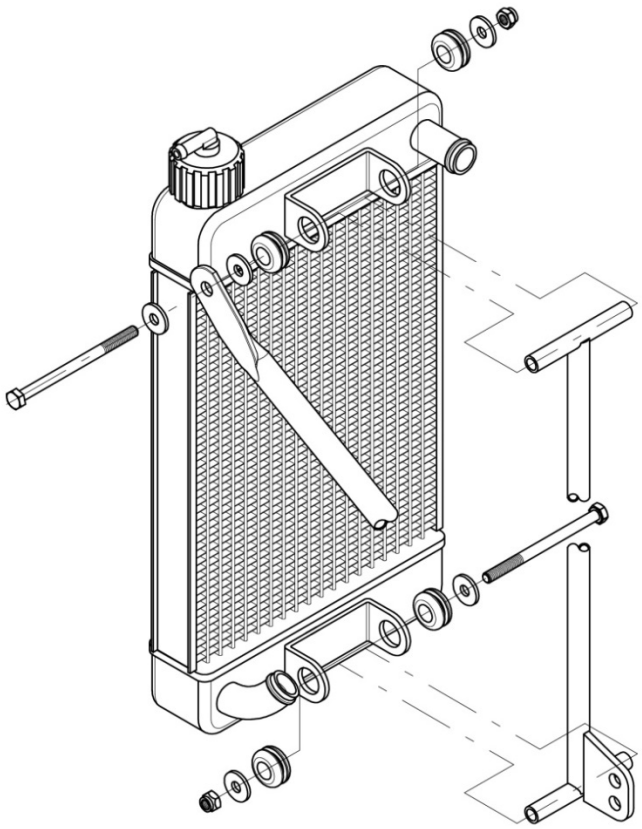
RADIATOR ALTERNATIVE DESCRIPTION AND SKETCH



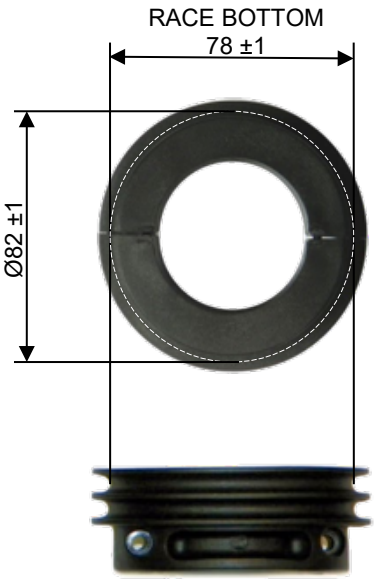
RADIATOR ALTERNATIVE SKETCH AND PHOTOS IDENTIFICATION COMPONENTS

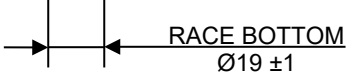


RADIATOR AND ITS SUPPORTS



WATER PUMP GROUP

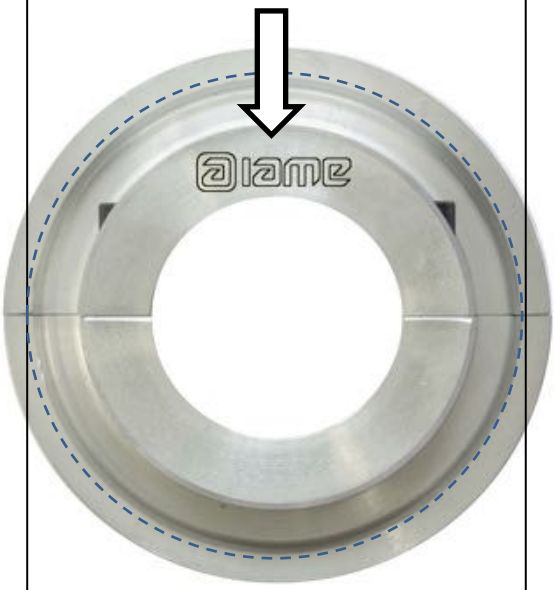


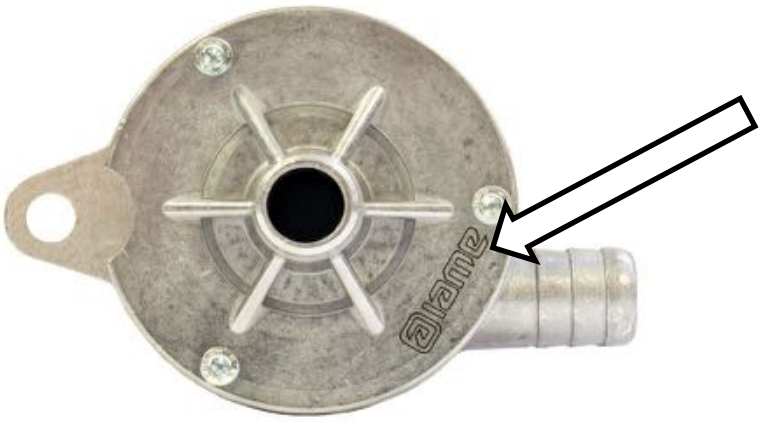


THERMOSTAT

ALTERNATIVE

ALTERNATIVE WATER PUMP & PULLEY





ALTERNATIVE RADIATOR SUPPORT

PISTON IDENTIFICATION MARKING	

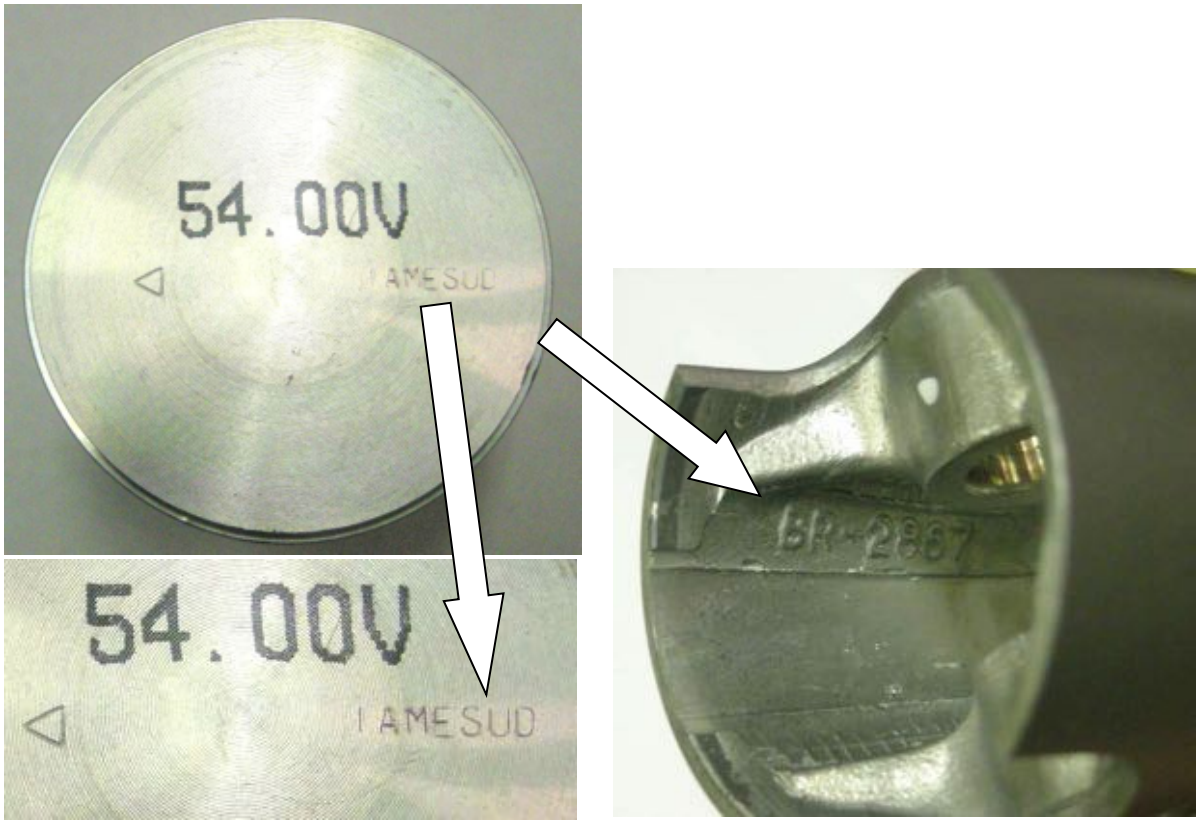
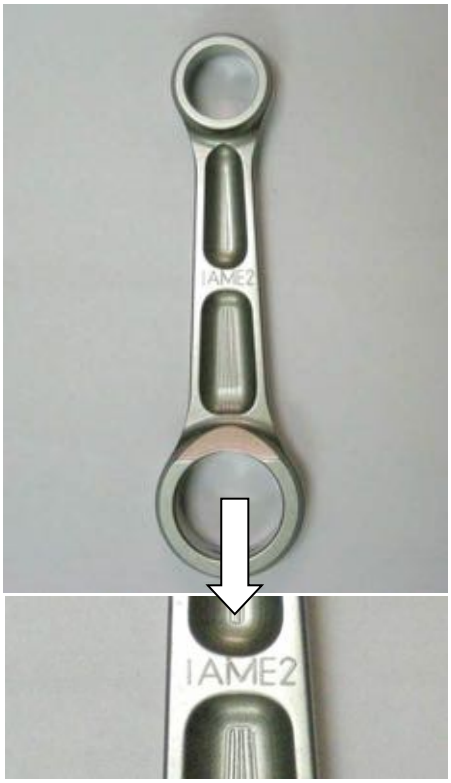
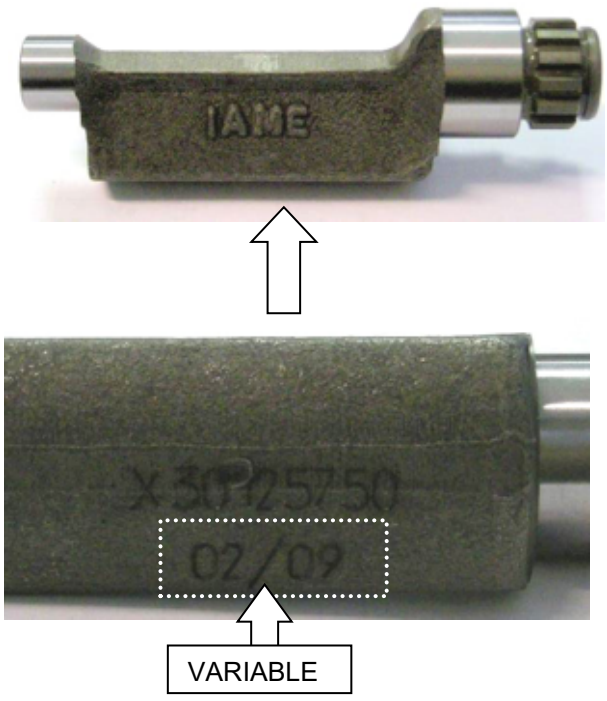
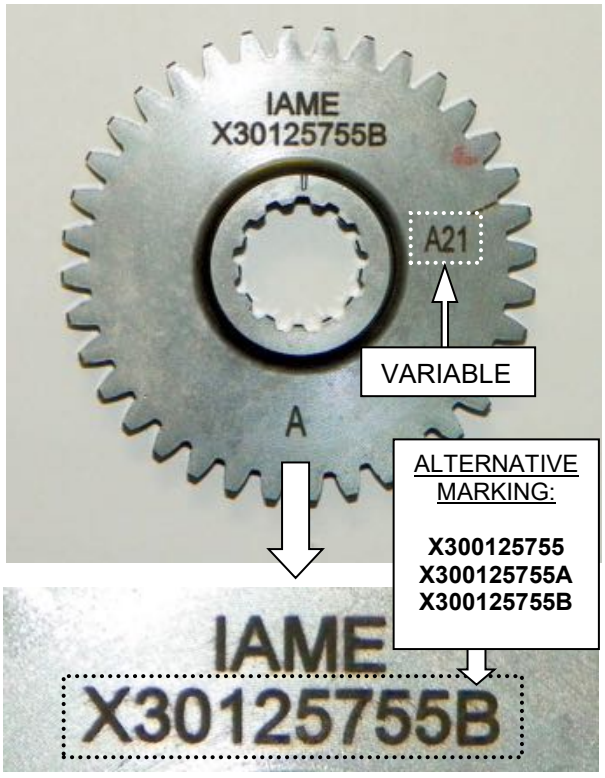



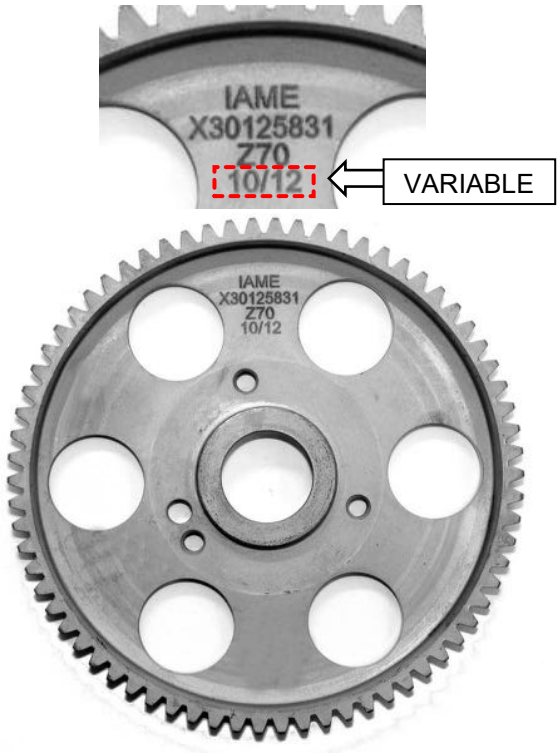
PHOTO IDENTIFICATION CONROD	IDENTIFICATION BALANCING SHAFT MARKING
	

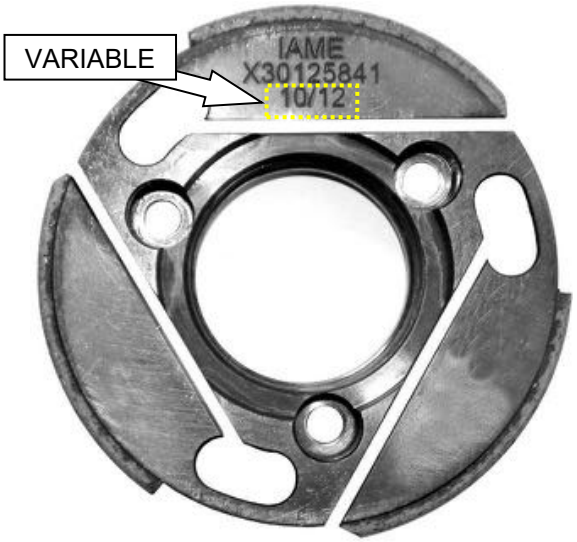
CRANKSHAFT IDENTIFICATION MARKING

GEAR COMMAND BALANCING SHAFT IDENTIFICATION MARKING

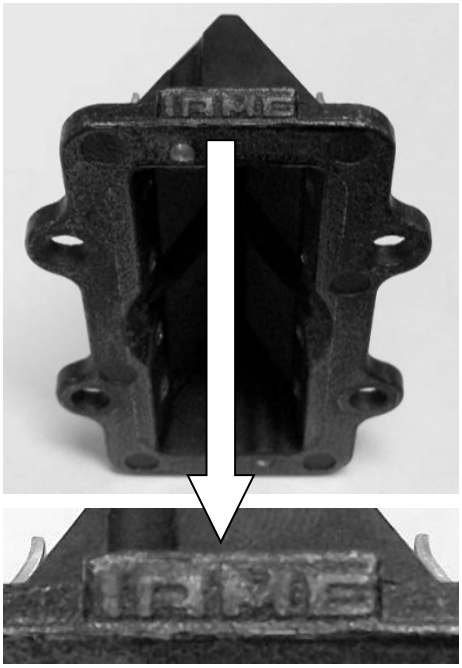


STARTER RING IDENTIFICATION MARKING

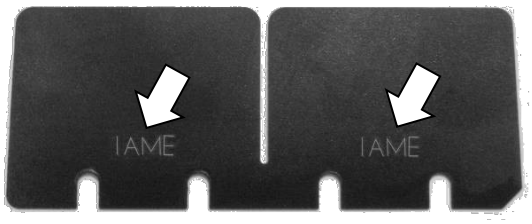


SPROCKET IDENTIFICATION MARKING	CLUTCH DRUM IDENTIFICATION MARKING
CLUTCH BODY IDENTIFICATION MARKING	STARTER IDENTIFICATION MARKING
ALTERNATIVE FRICTION MATERIAL VARIABLE 	

REED GROUP & PETALS IDENTIFICATION MARKING



FIBER GLASS



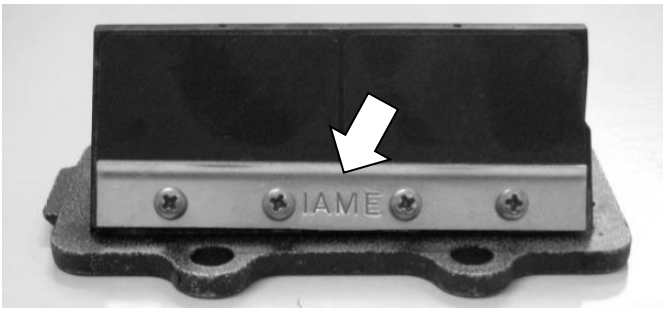
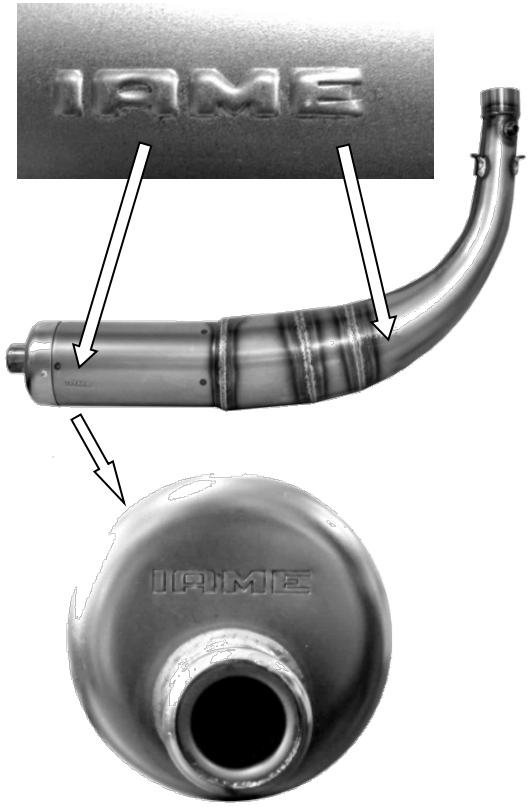


PHOTO IDENTIFICATION CARBURETOR INLET CONVEYOR

EXHAUST SILENCER IDENTIFICATION MARKING

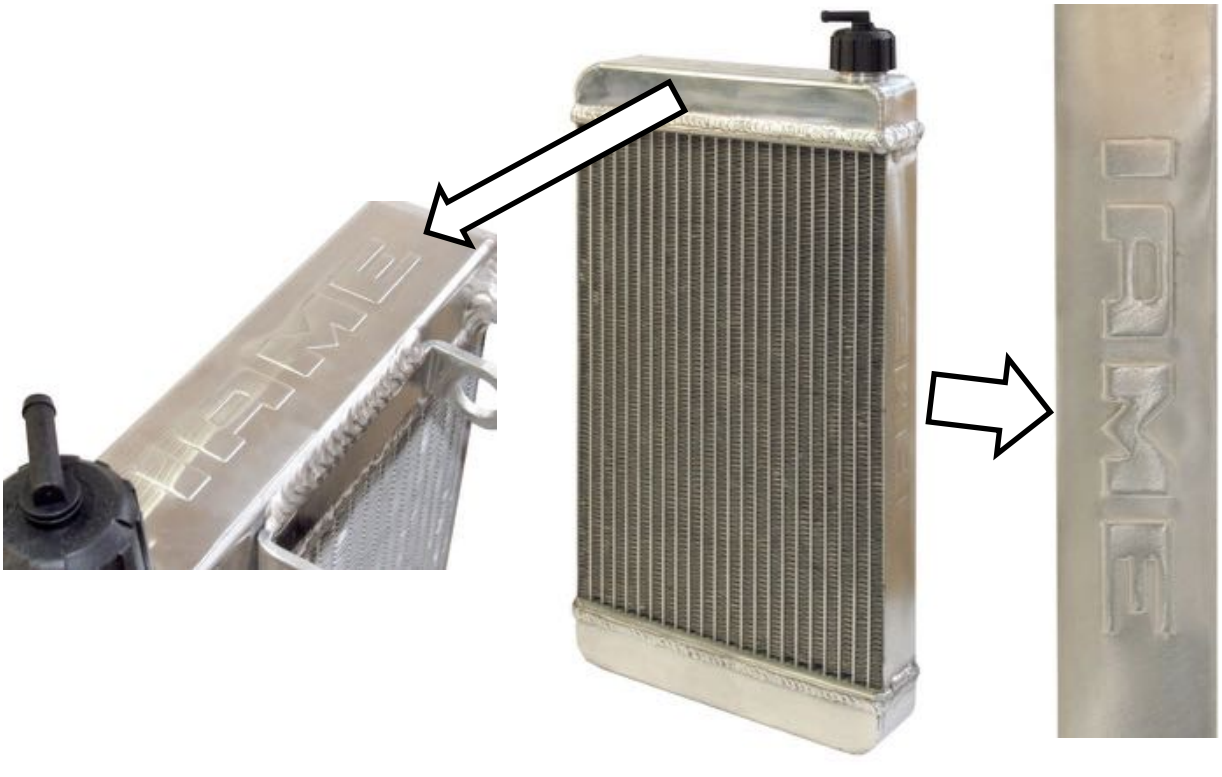


CLUTCH COVER IDENTIFICATION MARKING

BENDIX COVER IDENTIFICATION MARKING

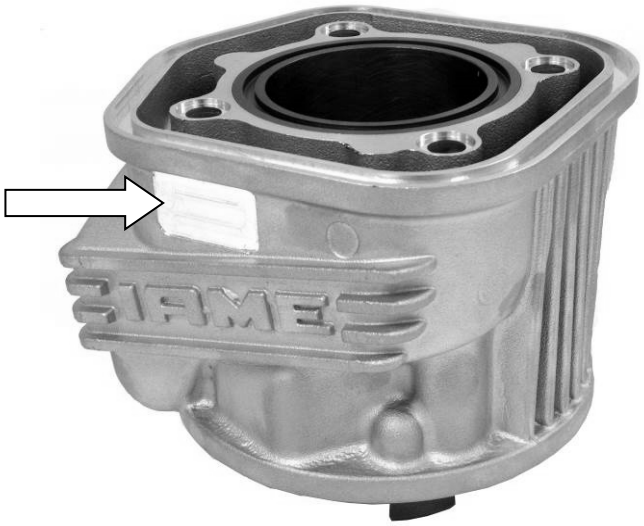
ALTERNATIVE

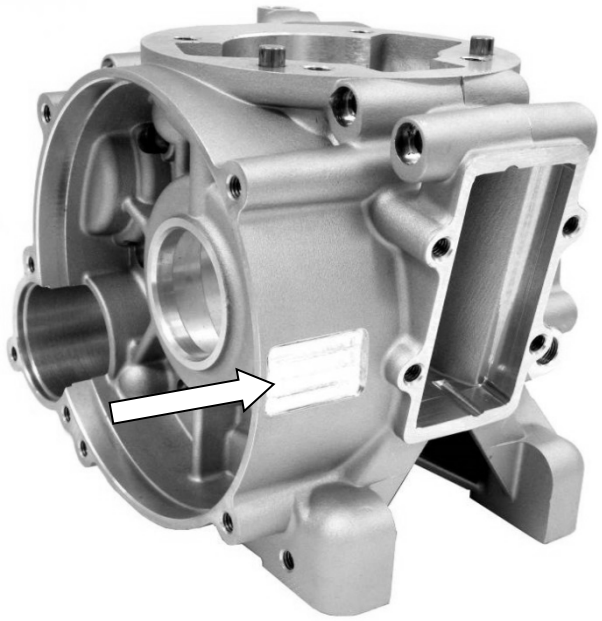
ALTERNATIVE RADIATOR IAME IDENTIFICATION MARKING



FROM 2014 ON

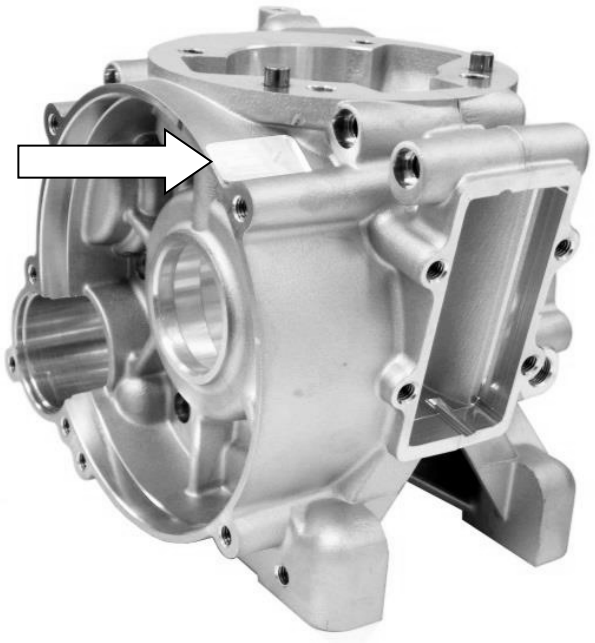
STICKER APPLICATION AREA



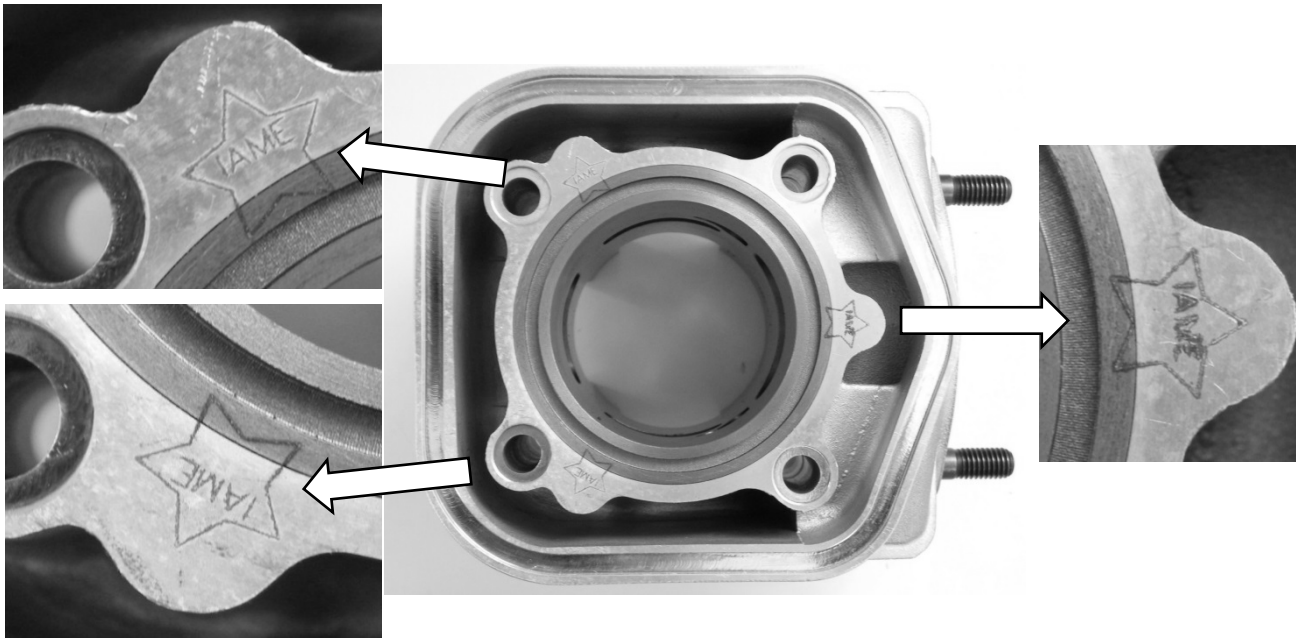


ENGINE STICKER “USA”

ALTERNATIVE AREA



CYLINDER IDENTIFICATION MARKING



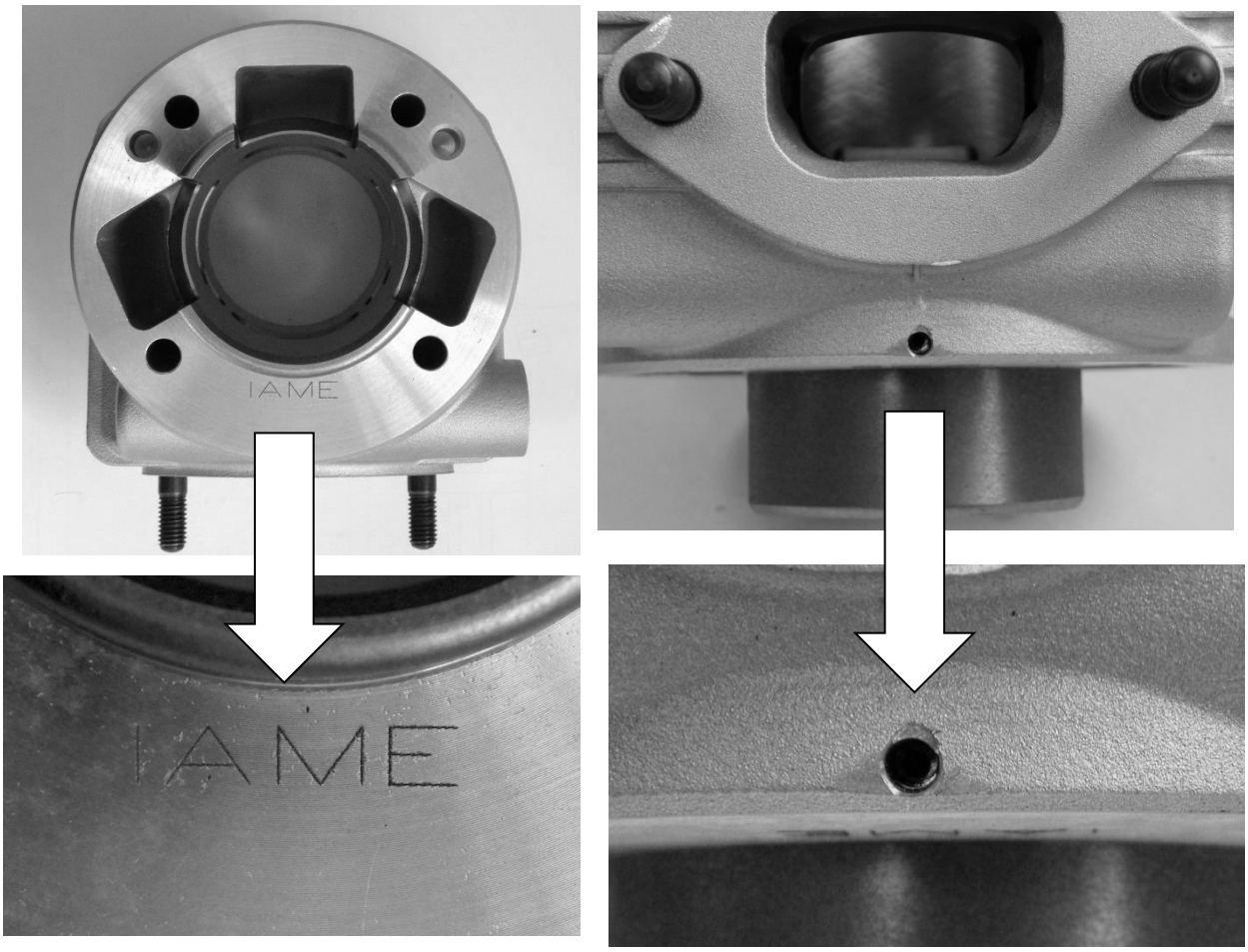
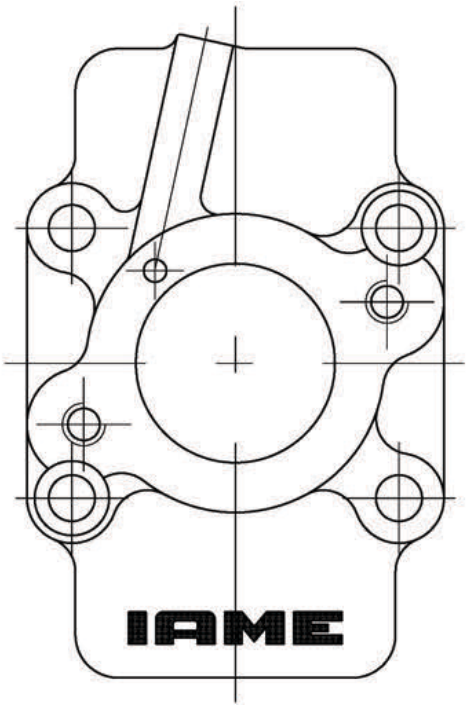


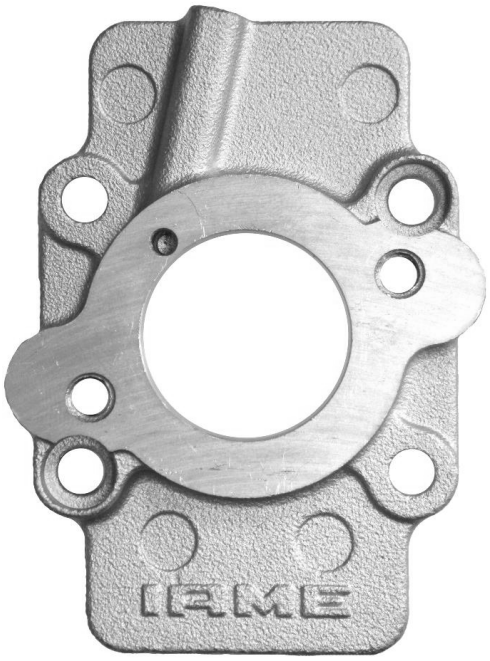
PHOTO IDENTIFICATION CARBURETTOR INLET CONVEYOR

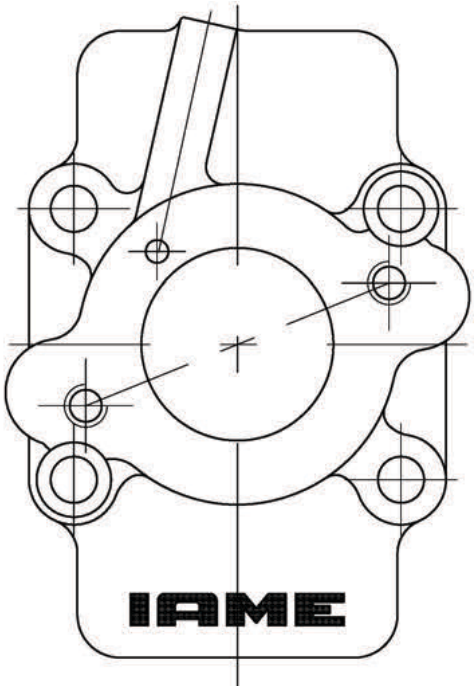
Old version - while stocks last



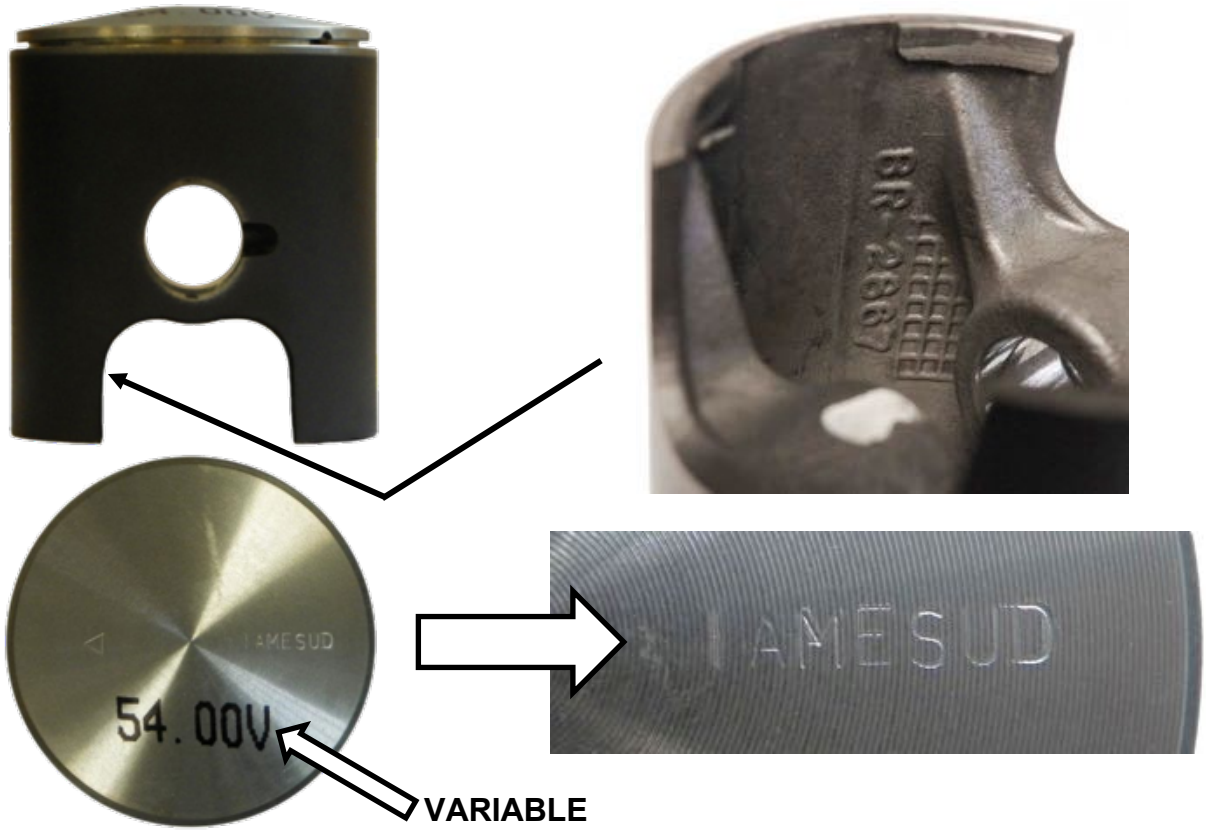
IN ALTERNATIVE

New version





ACTUAL PISTON



ALTERNATIVE PISTON

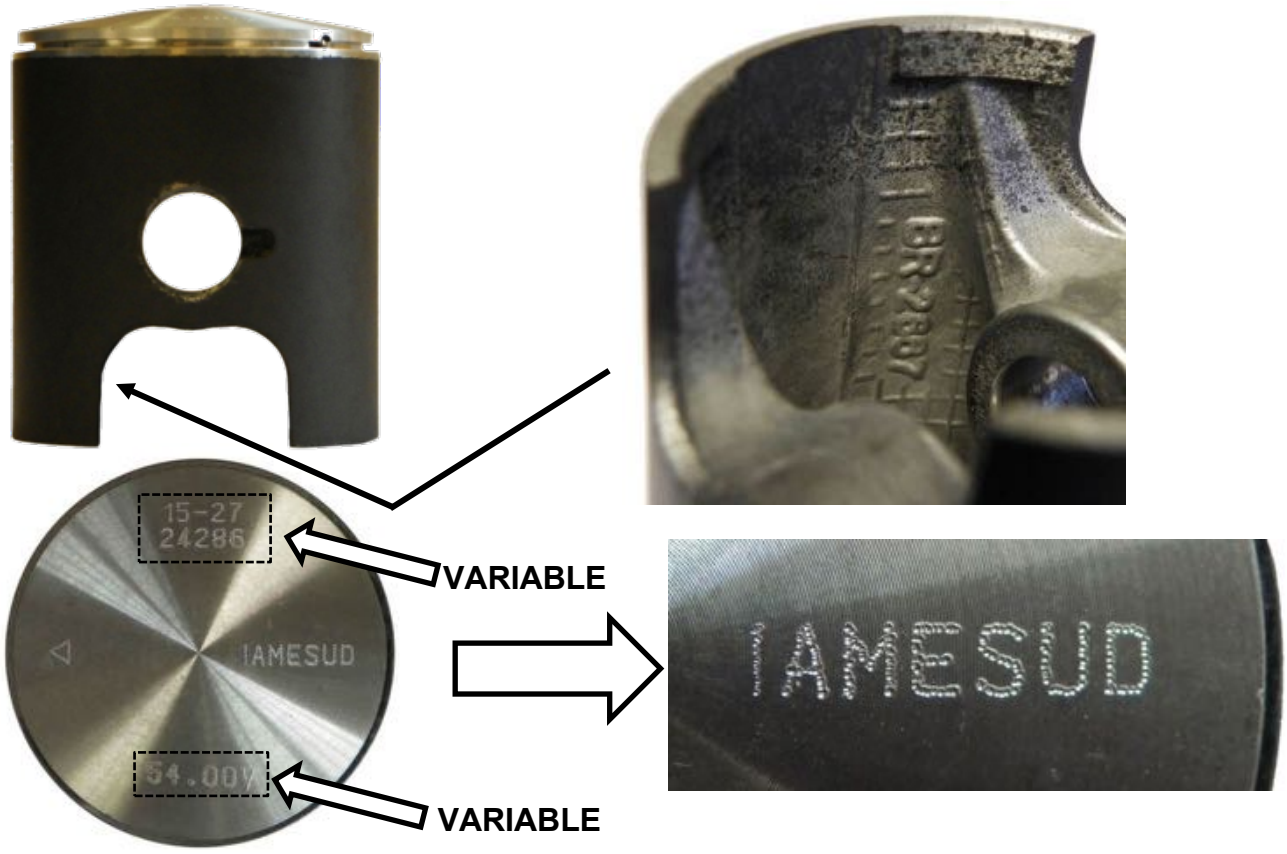
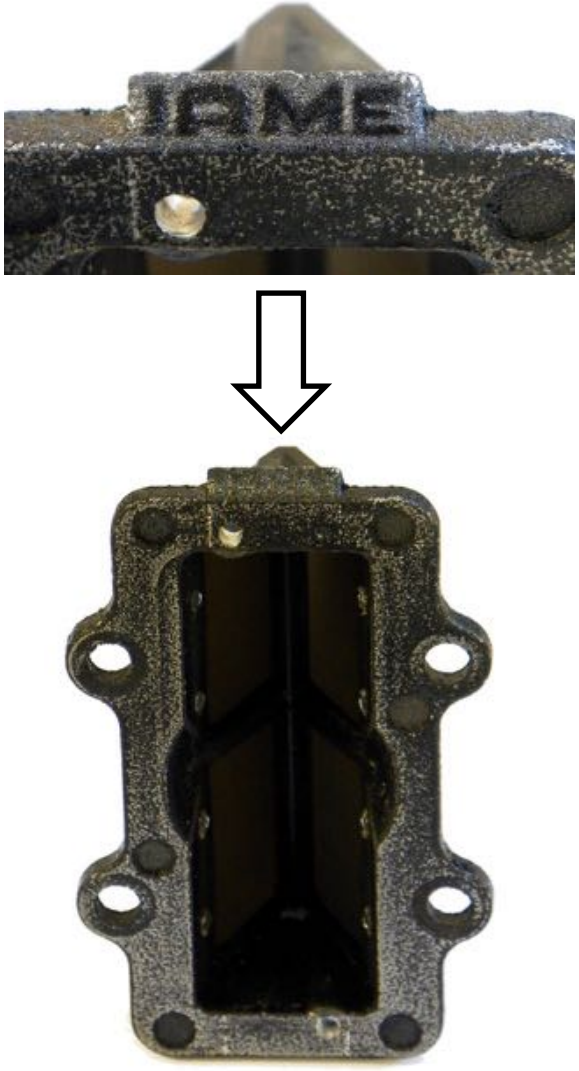
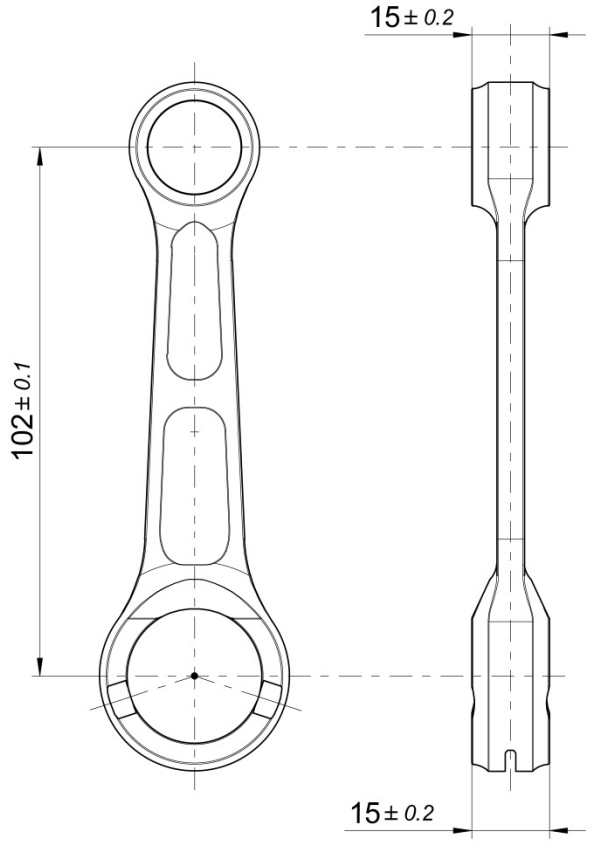


PHOTO IDENTIFICATION REED GROUP	
CURRENT VERSION	ALTERNATIVE VERSION
	

ALTERNATIVE CONROD



BOTH TYPES OF CONROD CAN BE USED WITH BOTH TYPES OF WASHERS (IN COUPLE)

PHOTO OF THE CONROD BOTH SIDE – ALTERNATIVE

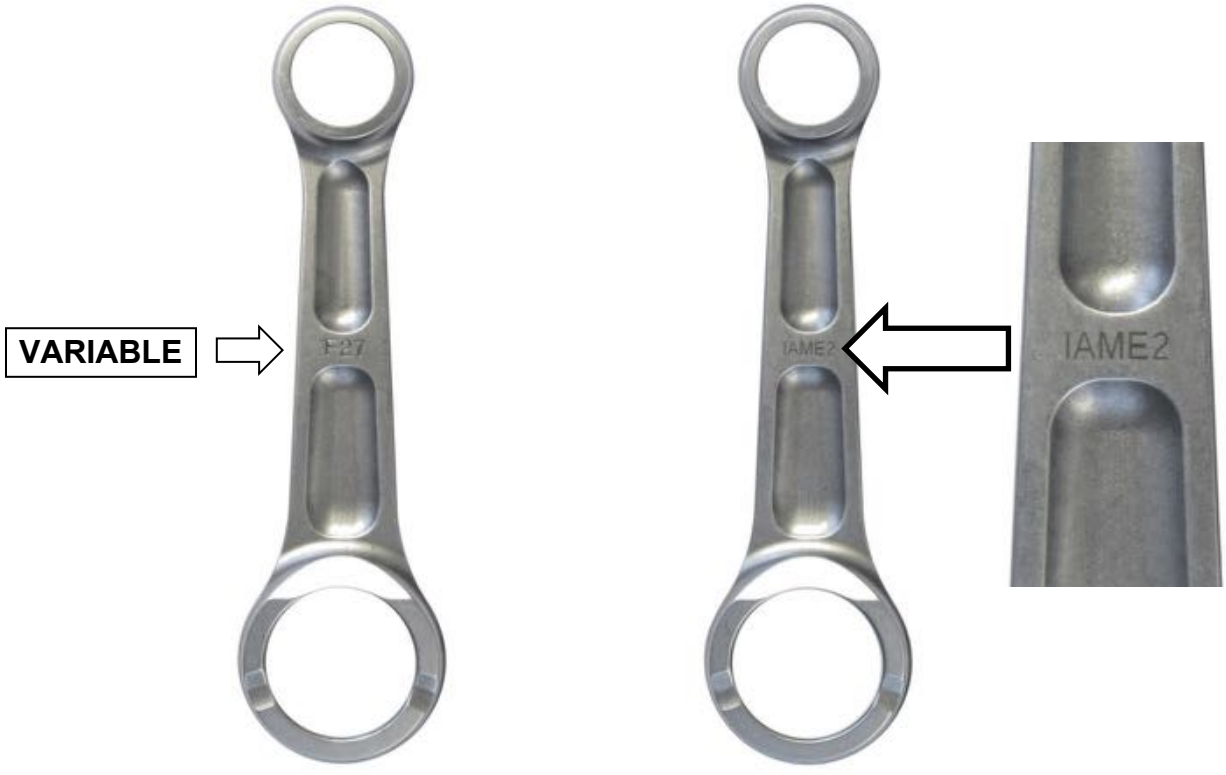


PHOTO IDENTIFICATION OF SMALL END CONROD BEARING – TYPES ALTERNATIVE

TYPE 1

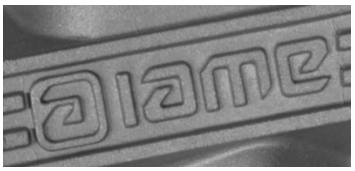
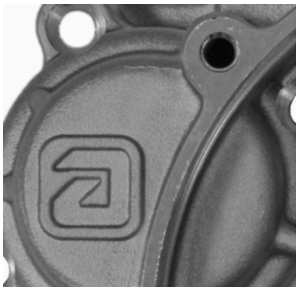
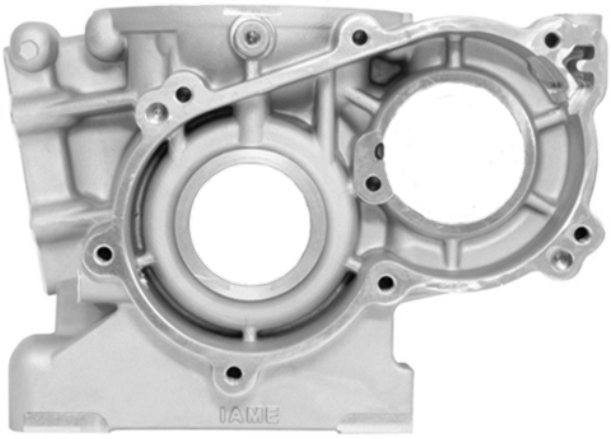
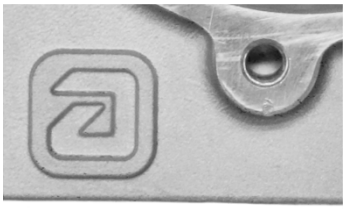
TYPE 2

PHOTO IDENTIFICATION OF SILVER CONROD WASHER – TYPES ALTERNATIVE

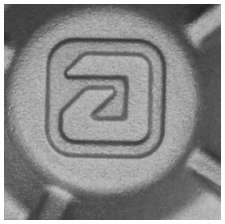
TYPE 1

TYPE 2

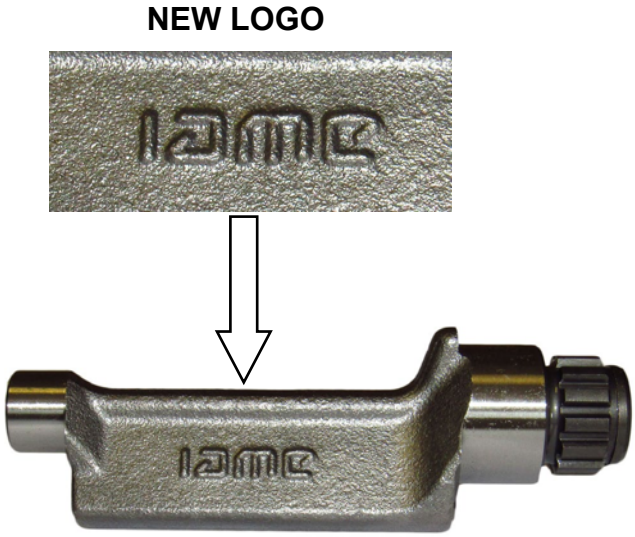
PARTICULARS WITH ALTERNATIVE NEW LOGO “IAME”

CYLINDER HEAD	CYLINDER
NEW LOGO	**NEW LOGO** 
SEMICARTER TRASMISSION SIDE	SEMICARTER IGNITION SIDE
NEW LOGO 	 **NEW LOGO** 

PARTICULARS WITH ALTERNATIVE NEW LOGO “IAME”

IGNITION COVER	CLUTCH COVER
 NEW LOGO 	 **NEW LOGO**
REED GROUP	CARBURETTOR INLET CONVEYOR
 NEW LOGO 	 **NEW LOGO**

PARTICULARS WITH ALTERNATIVE NEW LOGO "IAME"

EXHAUST SILENCER	BALANCING SHAFT
	

RADIATOR

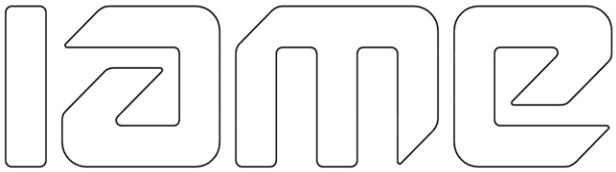
NEW LOGO

THE OTHERS COMPONENTS OF ENGINE THAT ARE MARKED (LASER OR PUNCHING) UNTIL TODAY WITH LOGO OR WRITTEN "IAME"

or

IAME

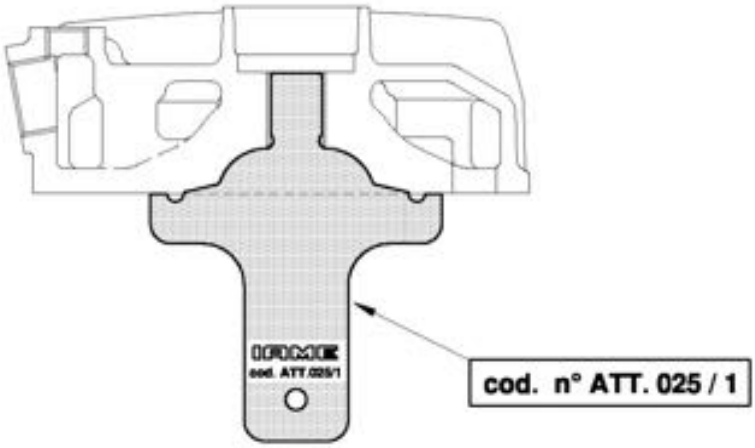
NOW COULD BE MARKED WITH NEW LOGO "IAME"



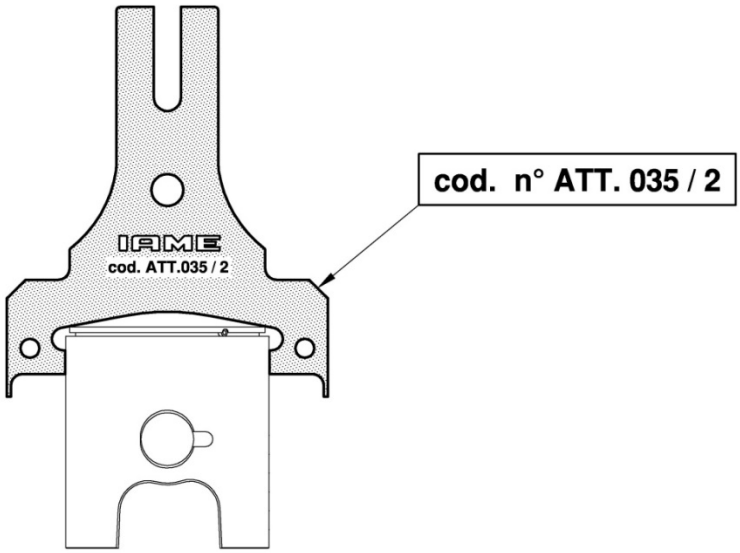
or

or

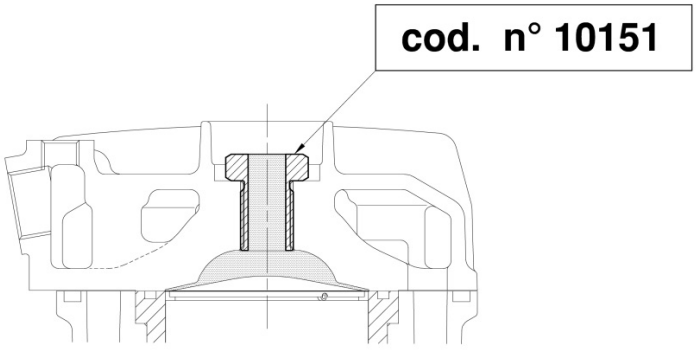
CHECKING THE SHAPE OF THE COMBUSTION CHAMBER



CONTROL OF THE PISTON DOME

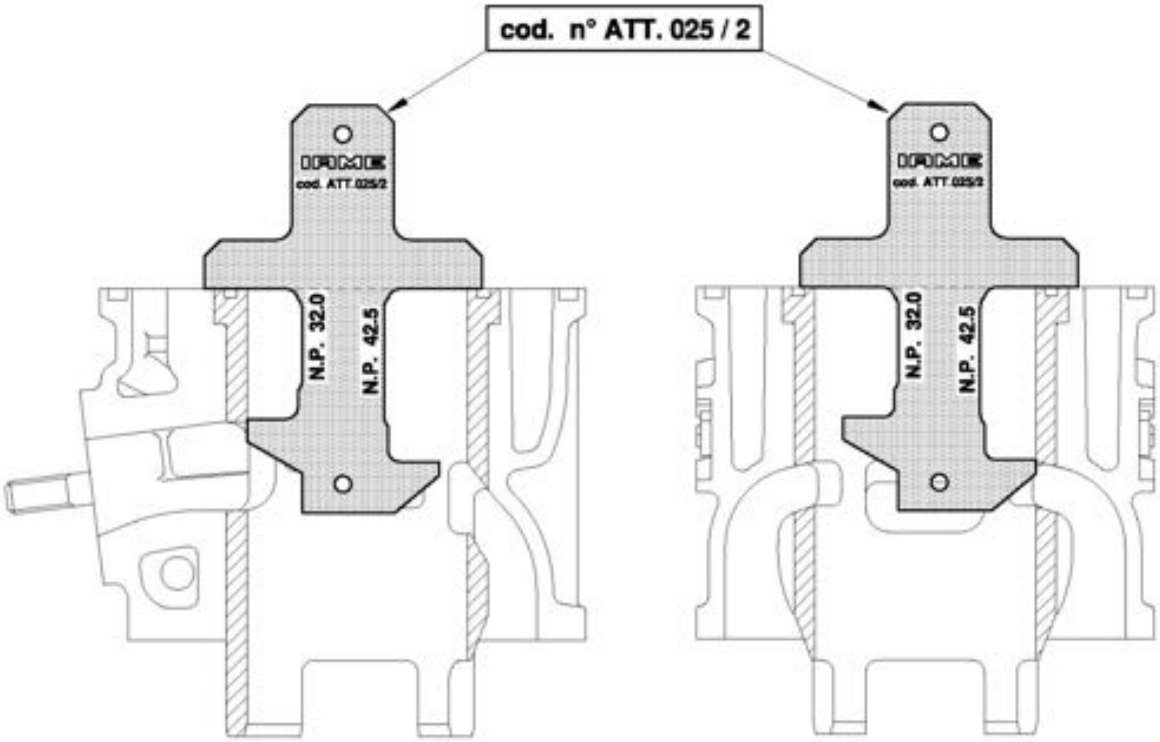


CONTROL OF THE VOLUME OF THE COMBUSTION CHAMBER

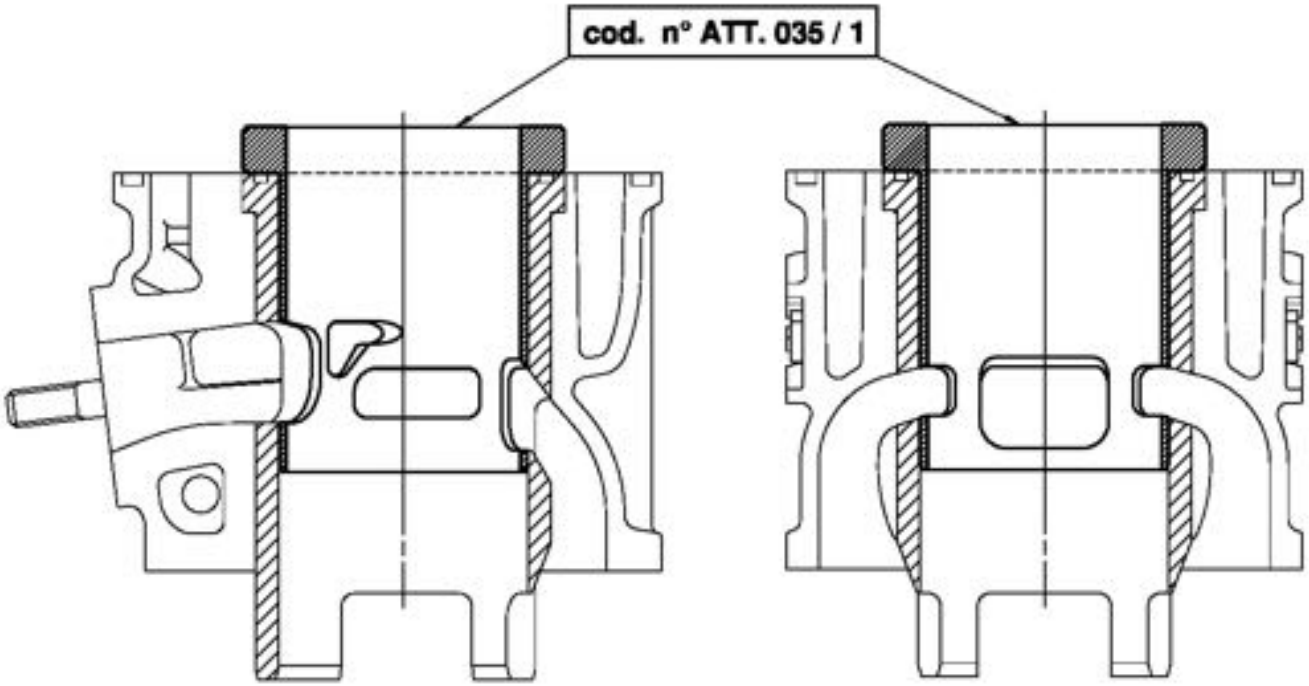


CYLINDER CHECK

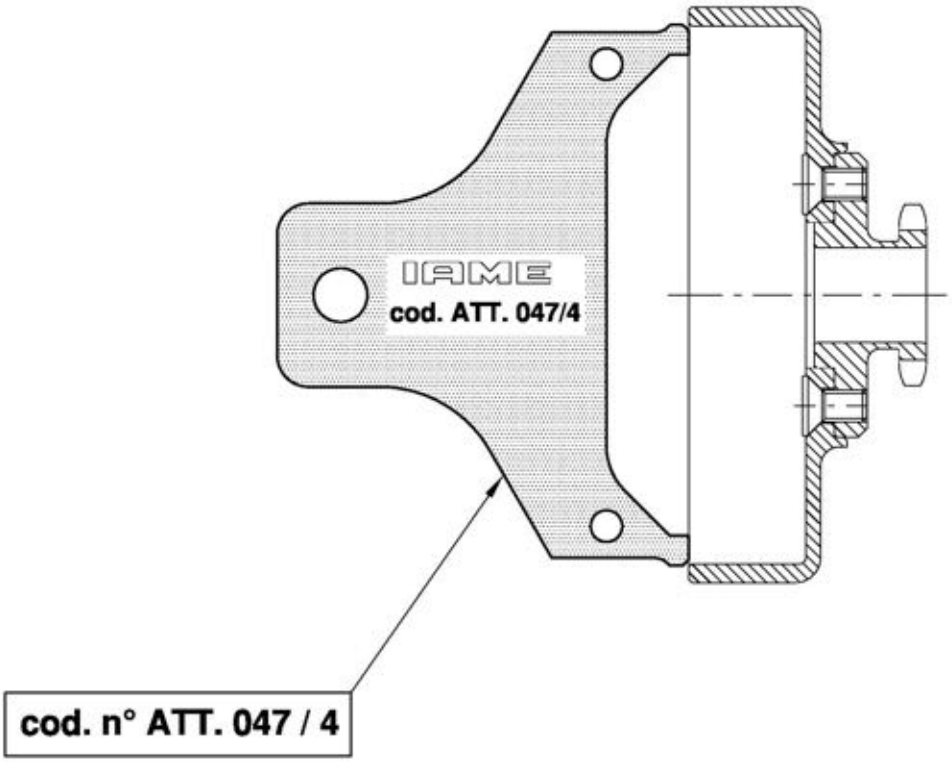
CHECK OF EXHAUST DUCT AND LATERAL TRANSFERS



CYLINDER LINER DUCTS AND TRANSFERS CHECK TOOL

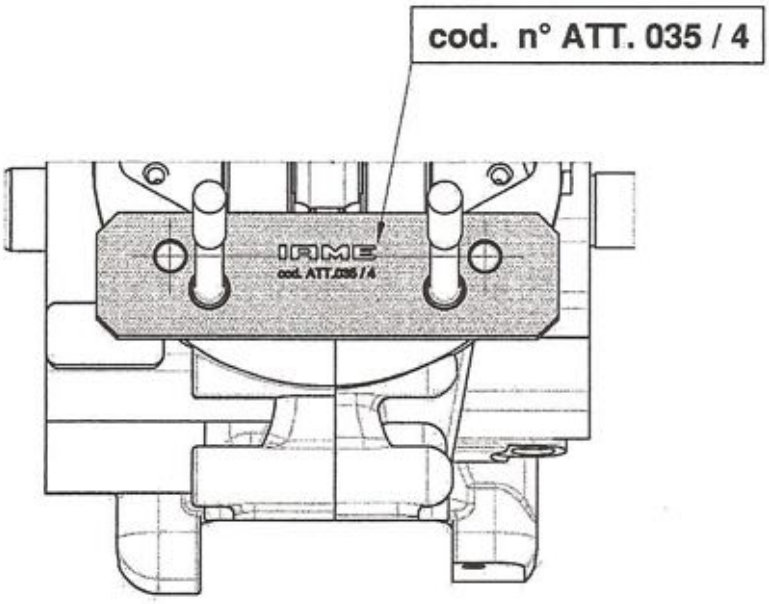


CLUTCH DRUM CHECK TOOL

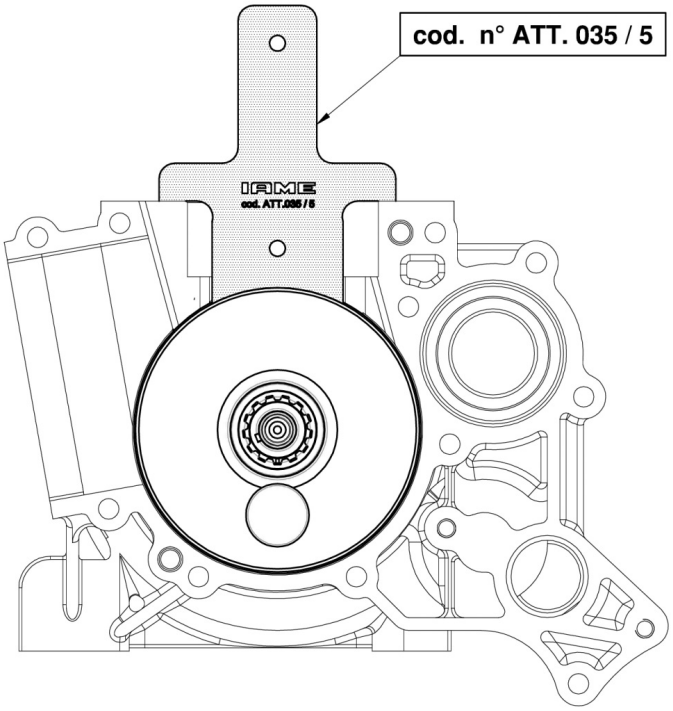


CRANKCASE CHECK TOOLS

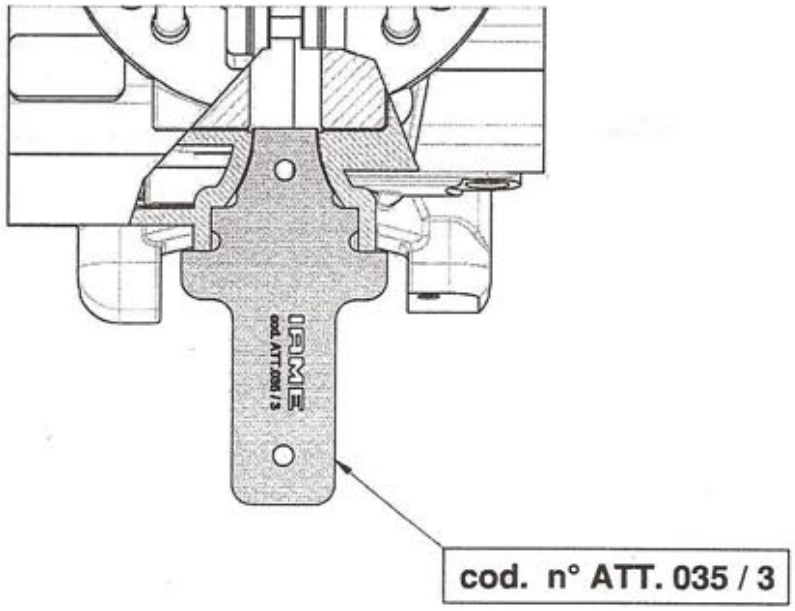
CHECKING THE DISTANCE BETWEEN THE CILYNDER PINS



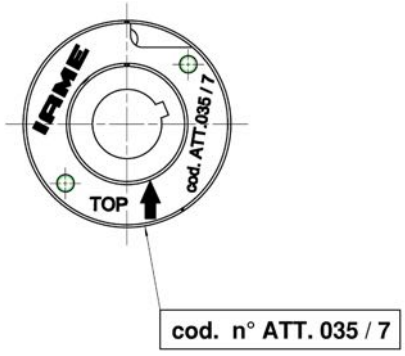
CONTROL OF THE HEIGHT OF THE JOINT PLANE



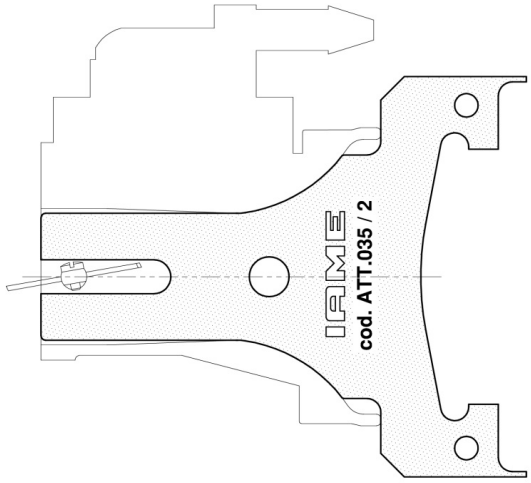
CHECKING OF THE REEDS VALVE SEAL PLANE



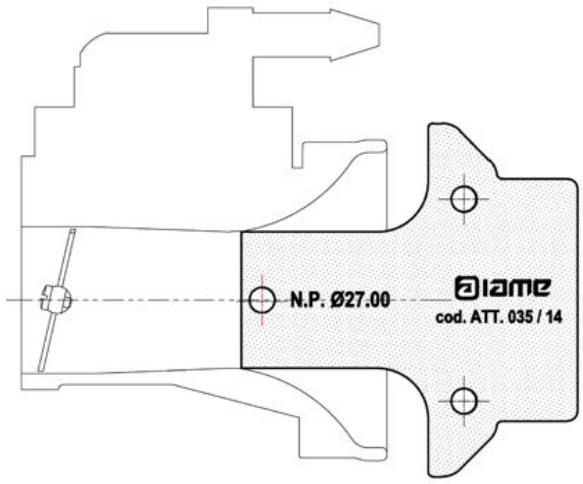
CONTROL OF THE POSITION OF SELETTRA DIGITAL "S" PHASE MARKING



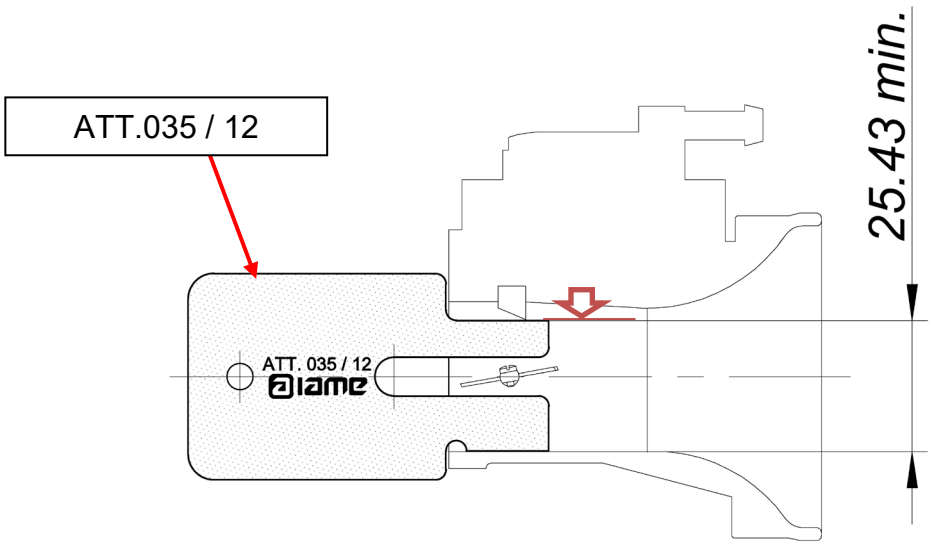
VENTURI SHAPE CONTROL OF TILLOTSON HW-27A CARBURETTOR



CHECK THAT THE TOOL DOES NOT ENTER INTO THE VENTURE DUCT INLET OF TILLOTSON HW-27A CARBURETTOR.

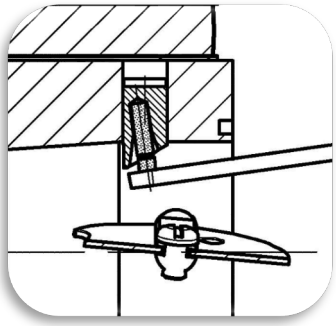


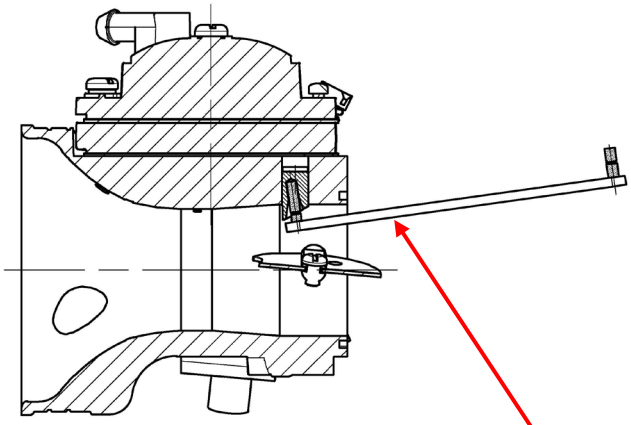
CHECK THE MINIMUM HIGHT OF ATOMIZER – GO IF IT'S OK



CHECK HOLE OF ATOMIZER

Pass Side - OK





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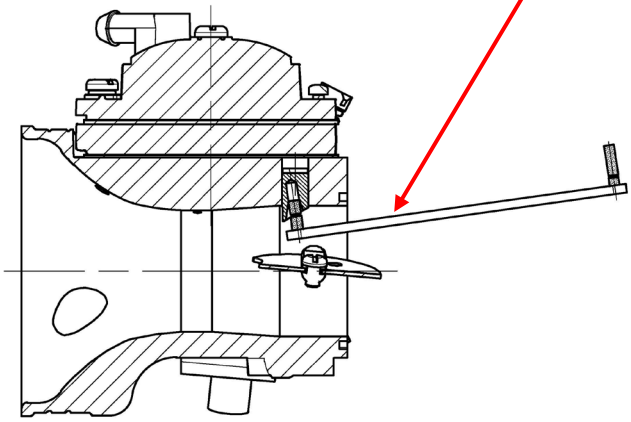
No Pass Side - OK



"NO GO" GAUGE & PROFILE CHECKING TOOL
EXHAUST MANIFOLD WITH RESTRICTOR Ø22.7mm

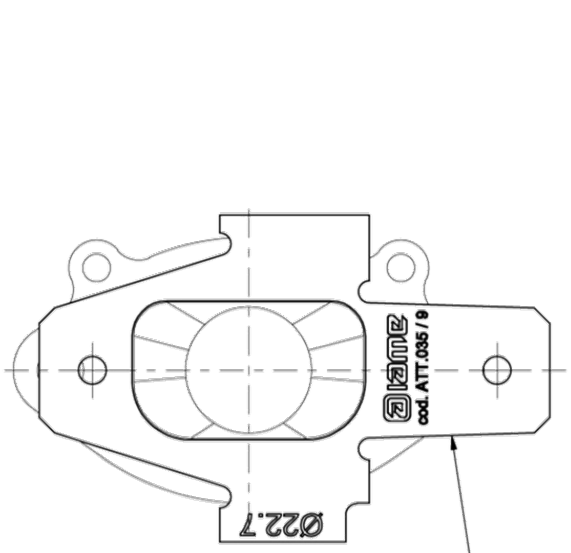


fig. 1

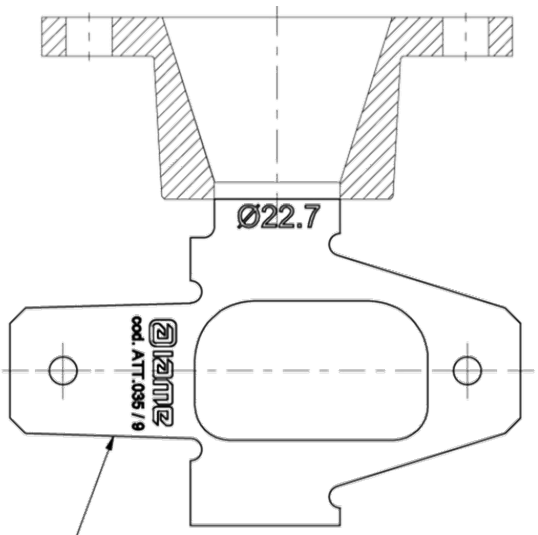


fig. 2

cod. ATT.035 / 9

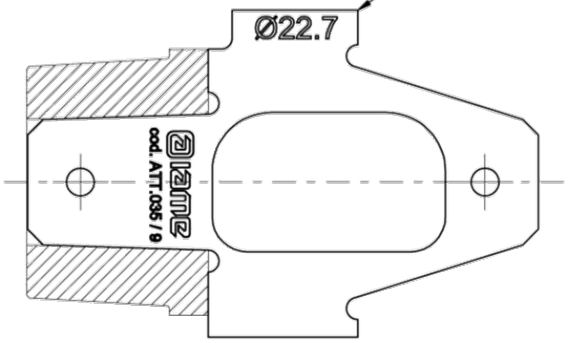


fig. 3

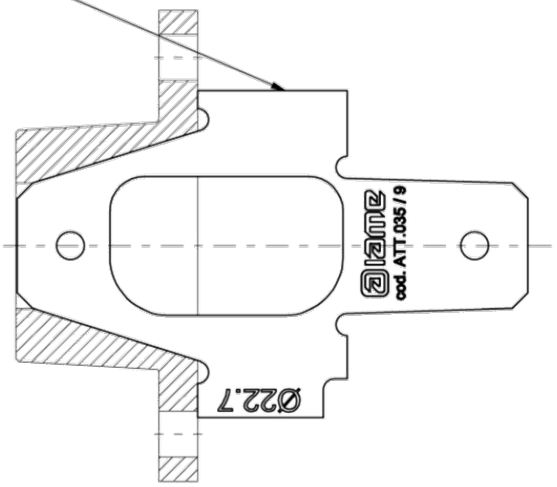


fig. 4

Scrutineer's are supplied with a "No Go" Gauge & Profile Checking Tool that is manufactured by IAME. They are to be used as indicated herein.

1. CHECK THAT THE NO-GO GAUGE DOES NOT ENTER INTO THE EXHAUST RESTRICTOR. (fig.2)

2. CHECK THAT THE TOOL MATCHES THE SHAPE OF THE EXHAUST MANIFOLD. (fig.1,3 and 4)

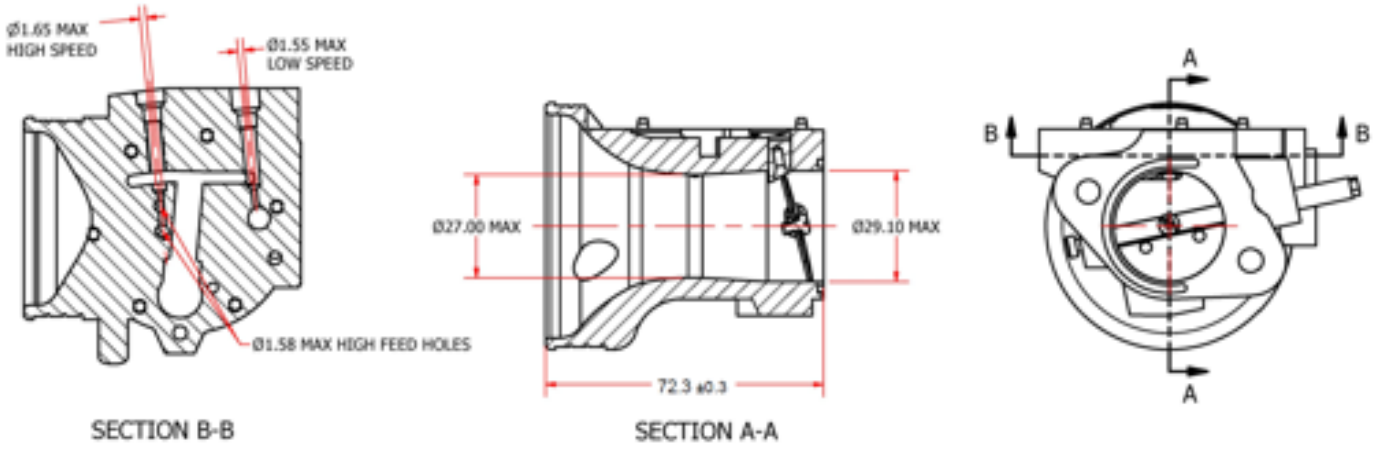
CARBURETTOR

Tillotson HW-27A

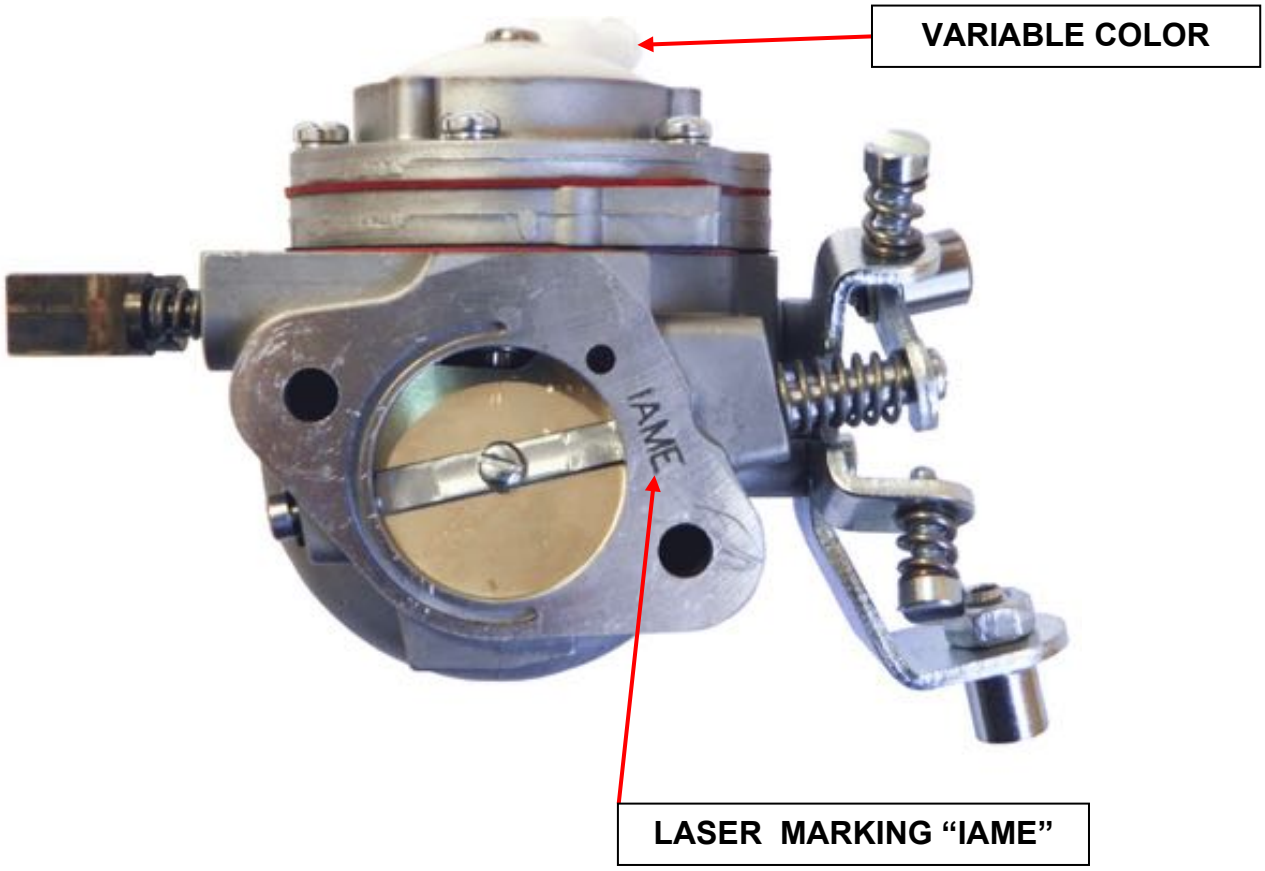
PHOTO OF ADJUSTING SIDE	PHOTO OF INLET SIDE

Manufacturer	**TILLOTSON LTD.**
Make	**TILLOTSON**
Model	**HW-27A**

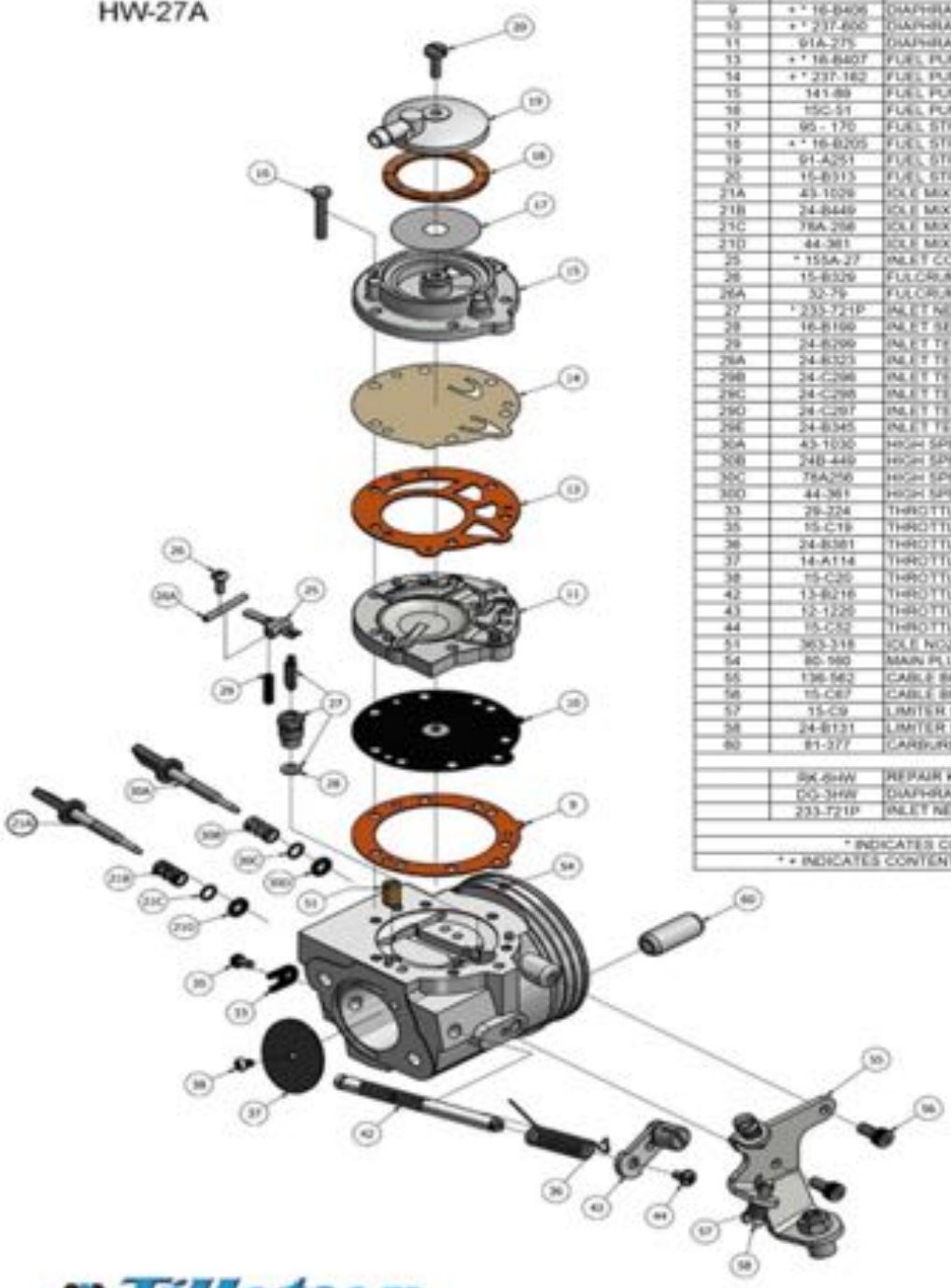
SECTION VIEW



MARKING



HW-27A



ITEM	PART NO	DESCRIPTION	QTY
9	+ * 16-8406	DIAPHRAGM GASKET (ORANGE)	1
10	+ * 237-600	DIAPHRAGM	1
11	91A-275	DIAPHRAGM COVER	1
13	+ * 16-8407	FUEL PUMP GASKET (ORANGE)	1
14	+ * 237-162	FUEL PUMP DIAPHRAGM	1
15	141-89	FUEL PUMP BODY	1
16	15C-51	FUEL PUMP BODY SCREW	6
17	95 - 170	FUEL STRAINER SCREEN	1
18	+ * 16-8205	FUEL STRAINER COVER GASKET	1
19	91-A251	FUEL STRAINER COVER	1
20	15-8315	FUEL STRAINER COVER RETAINING SCREW	1
21A	43-1029	IDLE MIXTURE SCREW	1
21B	24-8449	IDLE MIXTURE SCREW SPRING	1
21C	78A-256	IDLE MIXTURE SCREW WASHER	1
21D	44-361	IDLE MIXTURE SCREW PACKING	1
25	* 155A-27	INLET CONTROL LEVER	1
26	15-8329	FULCRUM LEVER SCREW	1
26A	32-79	FULCRUM LEVER PIN	1
27	* 233-721P	INLET NEEDLE & SEAT SET	1
28	16-8166	INLET SEAT GASKET	1
29	24-8299	INLET TENSION SPRING (STD 37 grams)	1
29A	24-8323	INLET TENSION SPRING (26 grams)	1
29B	24-C296	INLET TENSION SPRING (31 grams)	1
29C	24-C298	INLET TENSION SPRING (42 grams)	1
29D	24-C297	INLET TENSION SPRING (48 grams)	1
29E	24-8345	INLET TENSION SPRING (48 grams)	1
30A	43-1030	HIGH SPEED MIXTURE SCREW	1
30B	24B-449	HIGH SPEED MIXTURE SCREW SPRING	1
30C	78A-256	HIGH SPEED MIXTURE SCREW WASHER	1
30D	44-361	HIGH SPEED MIXTURE SCREW PACKING	1
33	29-224	THROTTLE SHAFT CLIP	1
35	15-C19	THROTTLE SHAFT CLIP RETAINING SCREW	1
36	24-8381	THROTTLE RETURN SPRING	1
37	14-A114	THROTTLE SHUTTER	1
38	15-C20	THROTTLE SHUTTER SCREW	1
42	13-8216	THROTTLE SHAFT	1
43	12-1220	THROTTLE LEVER ASSEMBLY	1
44	15-C52	THROTTLE LEVER RETAINING SCREW	1
51	363-318	IDLE NOZZLE	1
54	80-560	MAIN PLUG	2
55	136-562	CABLE BRAKET	1
56	15-C67	CABLE BRACKET RETAINING SCREW	2
57	15-C9	LIMITER SCREW	2
58	24-8131	LIMITER SPRING	2
60	81-377	CARBURETTOR MOUNTING NUT	2
	9X-6HW	REPAIR KIT	
	DG-3HW	DIAPHRAGM & GASKET (STANDARD)	
	233-721P	INLET NEEDLE & SEAT SET	
* INDICATES CONTENTS OF REPAIR KIT			
* + INDICATES CONTENTS OF DIAPHRAGM & GASKET SET			

Clash Industrial Estate - Tralee - Ireland
www.tillotson-racing.com

PARTS OF CARBURETTOR

REF.9 - P. N°16-B406
DIAPHRAGM GASKET (ORANGE COLOR)

Thickness = 0.5 ±0.1 mm

REF.13 - P. N° 16-B407
PUMP DIAPHRAGM GASKET (ORANGE COLOR)

Thickness = 0.8 ±0.1 mm

REF.10 - P. N°237-600
DIAPHRAGM

Thickness = 0.13 ±0.07 mm

REF.14 - P. N°237-162
PUMP DIAPHRAGM

ALTERNATIVE

Thickness = 0.10 ±0.063 mm

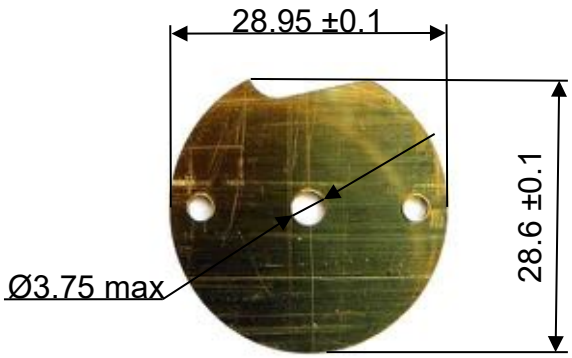
REF.11 - P. N° 91-A275
DIAPHRAGM COVER

Thickness = 6.75 ±0.15 mm

REF.15 - P. N° 141-89
PUMP COVER

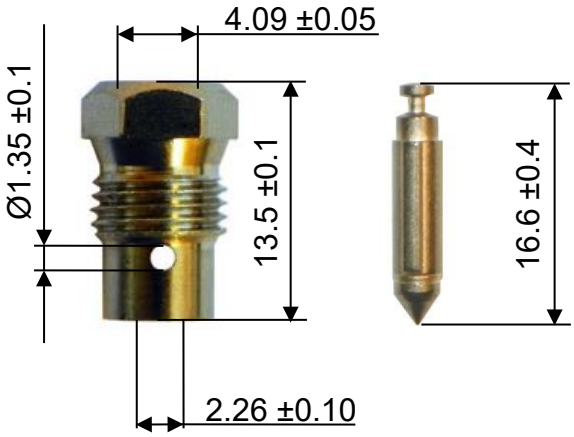
Thickness = 12.5 ±0.15 mm

REF.37 - P. N° 14-A114
THROTTLE SHUTTER



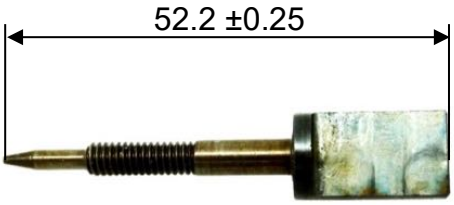
Thickness = 0.81 ±0.1 mm

REF.27 - P. N° 233-721P
SEAT + NEEDLE



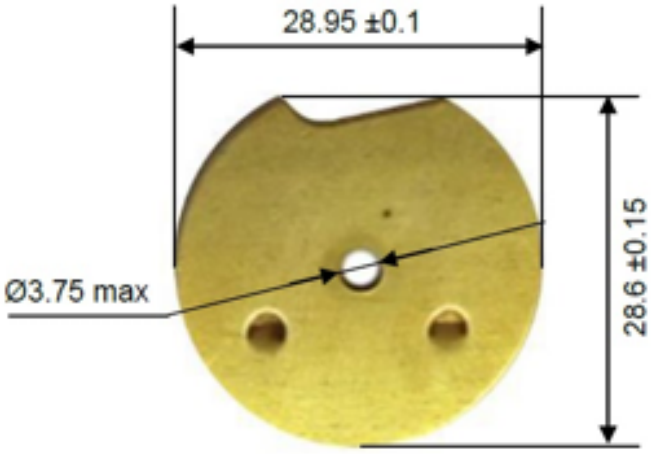
REF.21A - P. N° 43-1029
NEEDLE LOW SPEED

REF.30A - P. N° 43-1030
NEEDLE HIGH SPEED

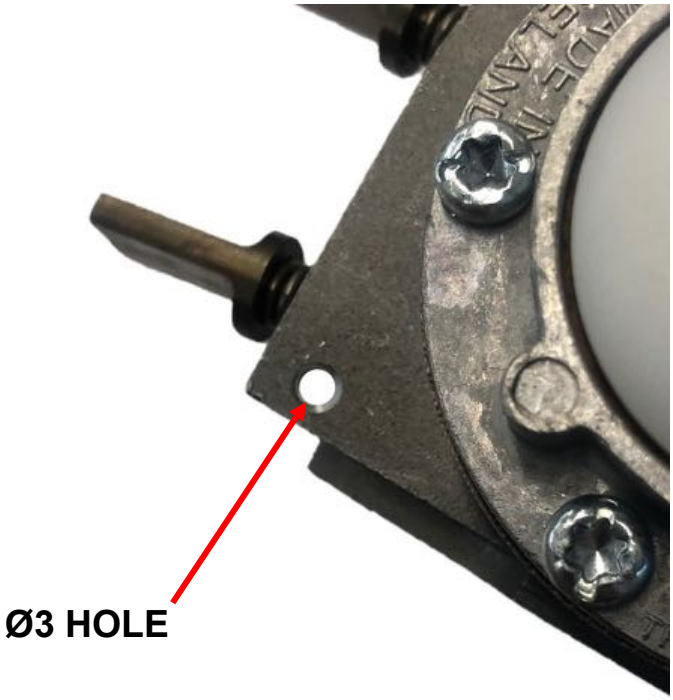


ALTERNATIVE THROTTLE SHUTTER
REF. 37 - P. N° 14-A114
(made from production tooling)

ALTERNATIVE FUEL NEEDLE



Thickness = 0.81 ±0.1 mm

REF.27 - P. N° 233-721P

The carburettor can have this hole for sealing.