



YZ125G / 250G CYLINDER RELIEF

The exhaust port bridge in the YZ125G/250G has been relief ground at the factory. This bridge **must** be reground whenever a YZ125G/250G cylinder is bored. Proper bridge relief is essential. Follow the instructions below when boring a YZ125G/250G cylinder.

AFFECTED MODELS

YZ125G and YZ250G

SPECIAL TOOLS

Cylinder Bore Gauge 50-100mm (90890-03017-00)
Dial Indicator (90890-03097-00)

PROCEDURE

1. Bore the cylinder for proper piston/cylinder clearance:

YZ125G 0.045 ~ 0.050mm
 (0.0018 ~ 0.0020")

YZ250G 0.045 ~ 0.050mm
 (0.0018 ~ 0.0020")

2. Carefully grind the exhaust port bridge area in an arch shape as shown in Illustrations 1 & 2. The length of the relief must equal the specified length. Taper the relief from zero at the top and bottom of the relief to the specified depth at the center of the relief. Carefully grind the full width of the bridge. Use a hand grinder and a very fine tooth carbide burr cutting tool or a very fine abrasive wheel. The relief must be smooth. Any irregularity will damage the ring. Check the relief with a cylinder bore gauge to assure that it conforms to specifications.

3. Feather the top and bottom edges of the relief. Use silicon carbide sandpaper for a smooth finish.

ILLUSTRATION 1

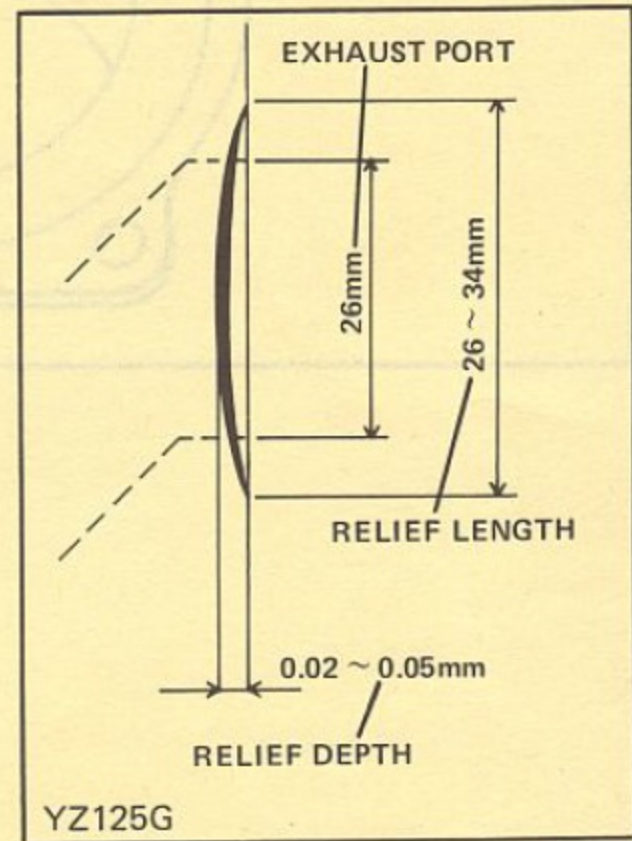
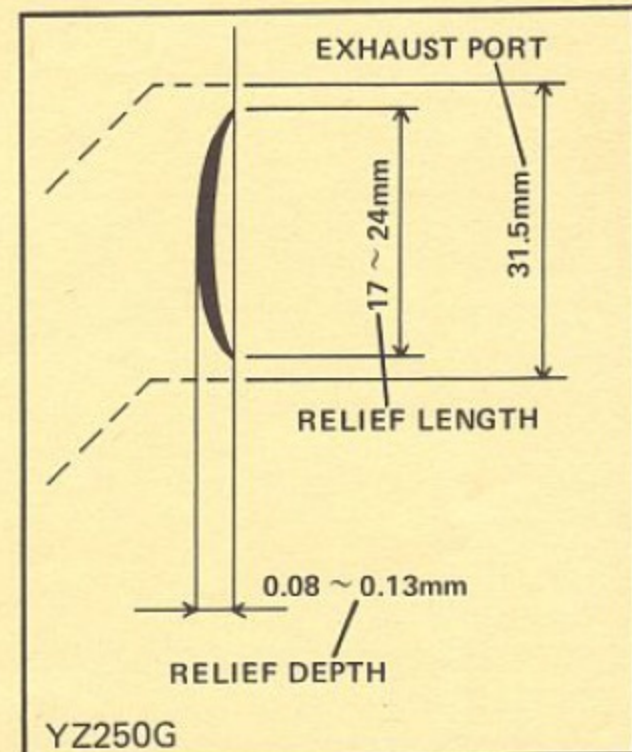
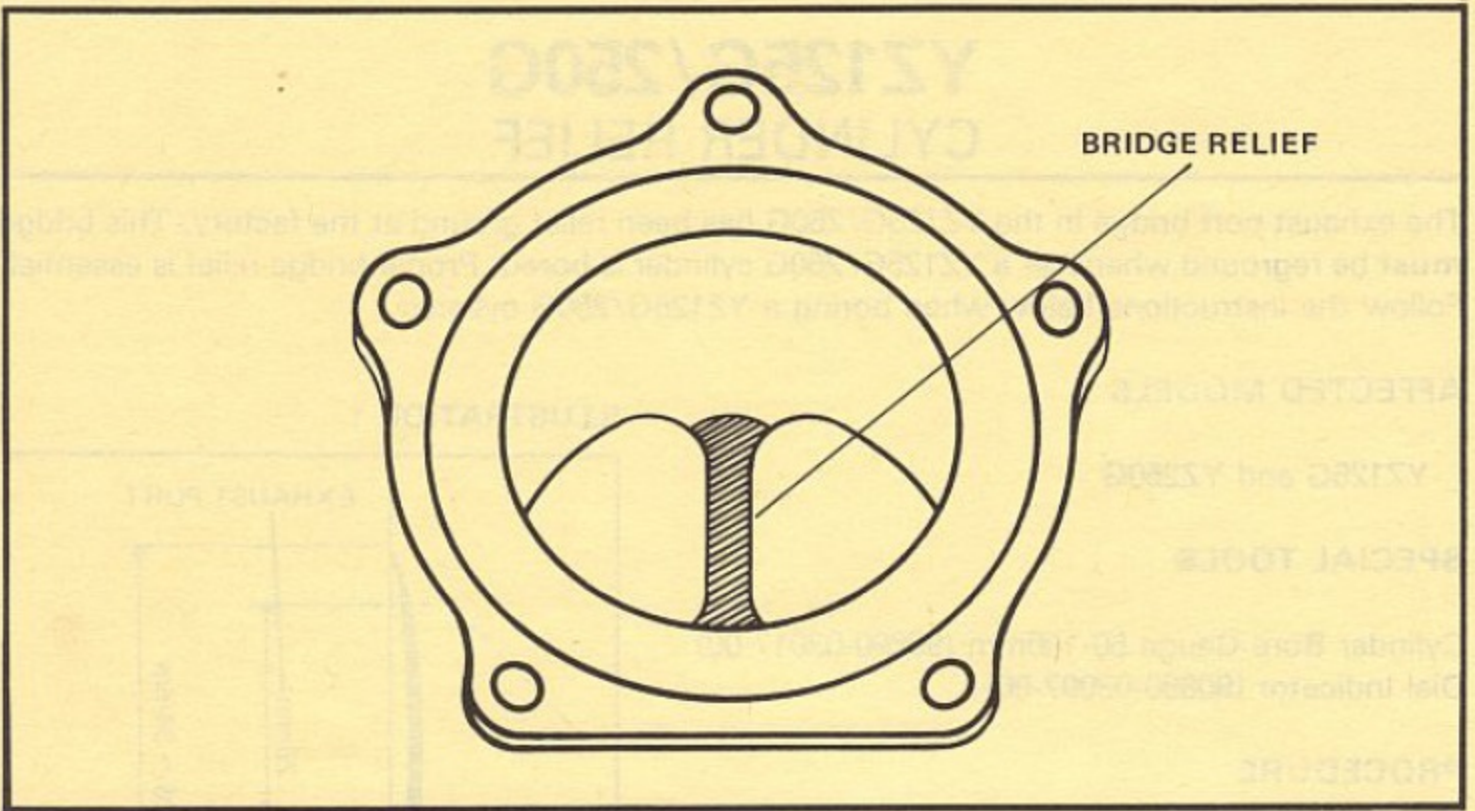


ILLUSTRATION 2



TECHNICAL BULLETIN
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ILLUSTRATION 3



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