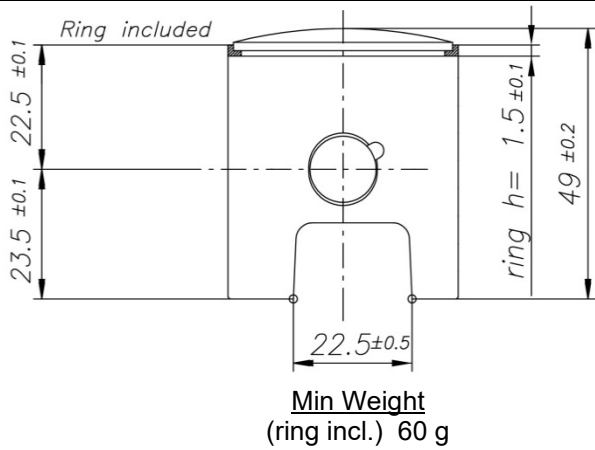
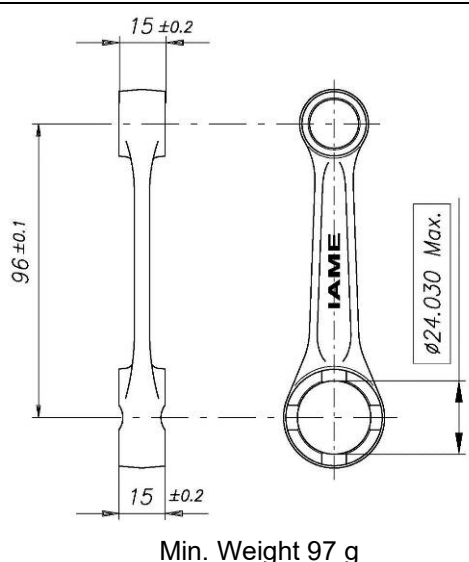
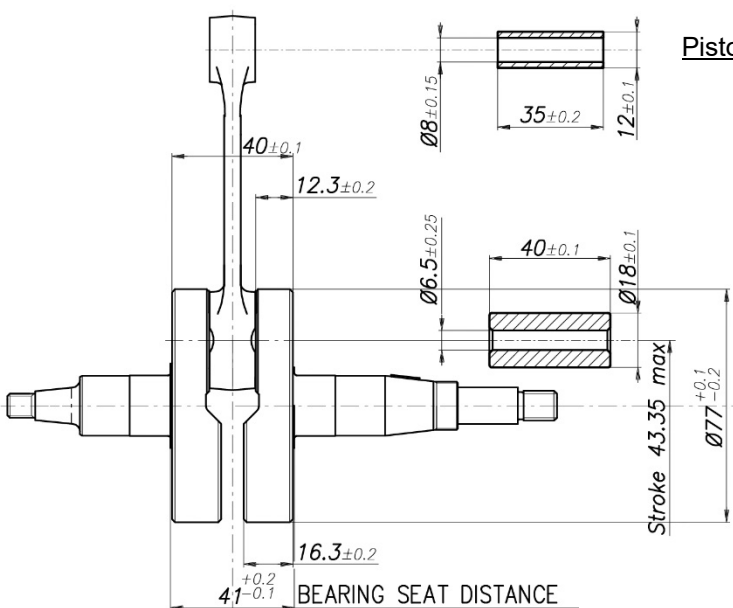
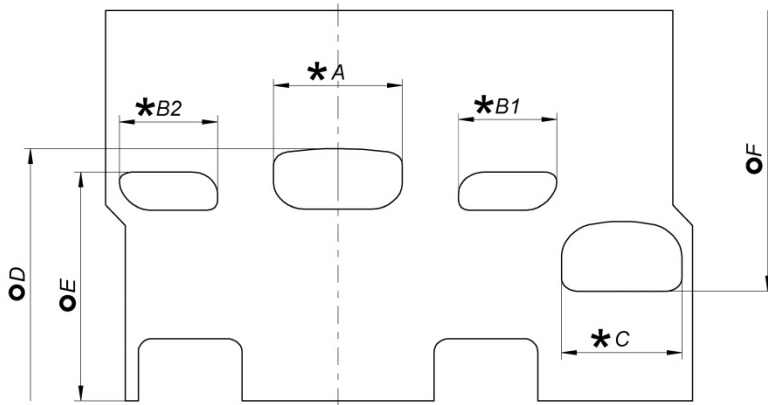


M1 - 60cc PULL START

		FEATURES	
		Cylinder volume	60.00 cm ³ max
		Bore	41.80 mm
		Max. theoretical bore	41.97 mm
		Stroke	43.35 mm max
		Cooling system	Air
		Inlet system	Piston Valve
		Number of carbs	1
Carburettor Tillotson	HS-325A (Venturi Ø10.3mm)	Cylinder/crankcase transfers n°	2 / 2
Number of piston rings	1	Inlet/exhaust ports	1 / 2
Big end conrod ball-bearing diameter	18x24x15	Combustion chamber shape	Spherical
Crankshaft ball-bearing diameter	20x47x14	Selettra ignition	Analogic Cod. A-61953-C
Small end conrod ball-bearing diameter	12x16x16	Distance between Conrod centres	96 mm

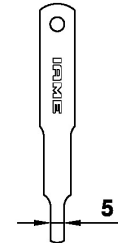
DESCRIPTION OF THE MATERIAL		PISTON
Conrod material	Steel	
Crankshaft material	Steel	
Head material	Aluminium	
Cylinder material	Aluminium	
Liner material	Cast Iron	
		DISTANCE BETWEEN CONROD CENTERS
Crankcase material	Aluminium	
Piston material	Aluminium	
Piston rings material	Cast Iron	
Exhaust muffler material	Sheet-steel	
Ball-bearings	6204 type	
		Piston pin min. weight 15.5g Complete Crankshaft min. weight 1280 g

CYLINDER DEVELOPMENT



A	27.5 ±0.2 mm
B1 = B2	21.7 ±0.4 mm
C	26 ±0.2 mm
D	151.5° max.
E	114.5° ±1.5°
F	141.5° max.

TOOL IAME Cod. 10194

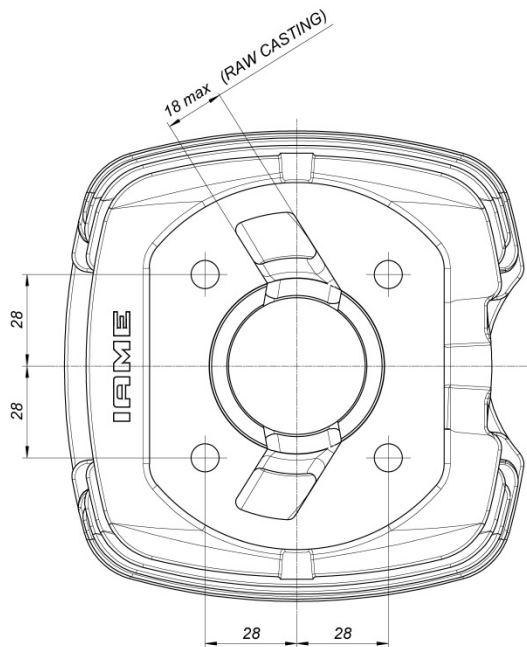


* CHORDAL READING

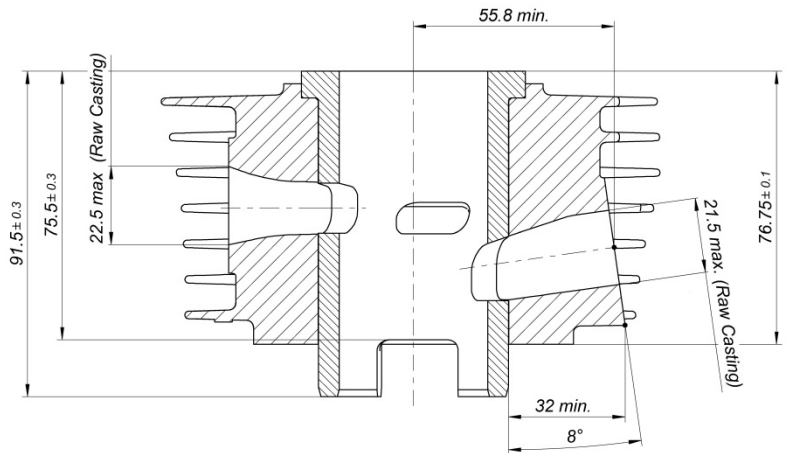
○ ANGULAR READING BY INSERT A 0.2x5 mm GAUGE

USING IAME TOOL - Cod. 10194

CYLINDER BASE VIEW



CYLINDER CROSS SECTION VIEW



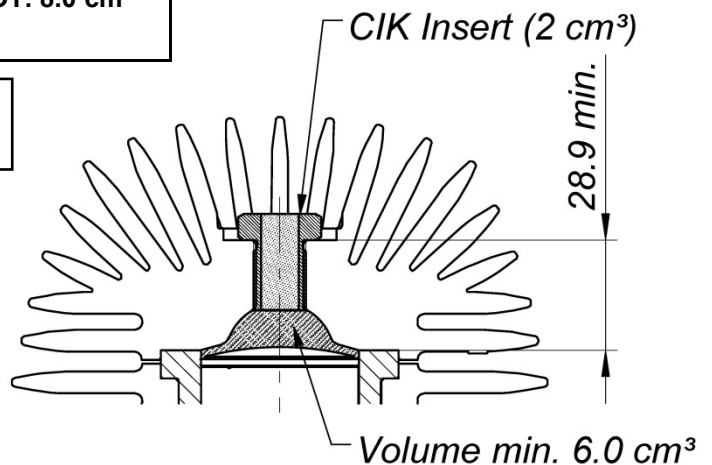
COMBUSTION CHAMBER VIEW

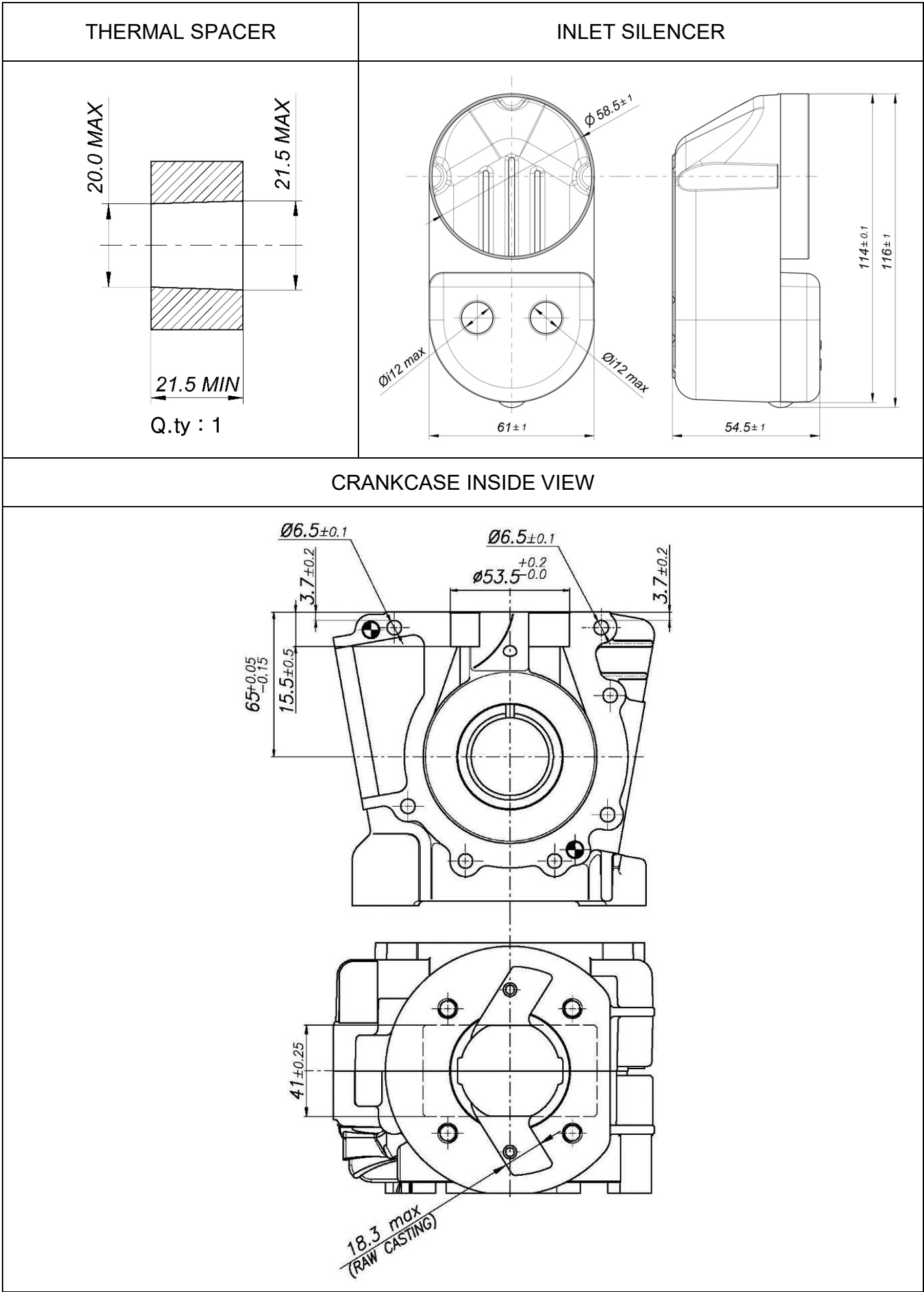
COMBUSTION CHAMBER VOLUME = 6.0 + 2 = TOT. 8.0 cm³ min.

SQUISH MIN.= 0.078" (2.0 mm)
(measured with 0.125" (1/8") / Ø3.175mm solder)

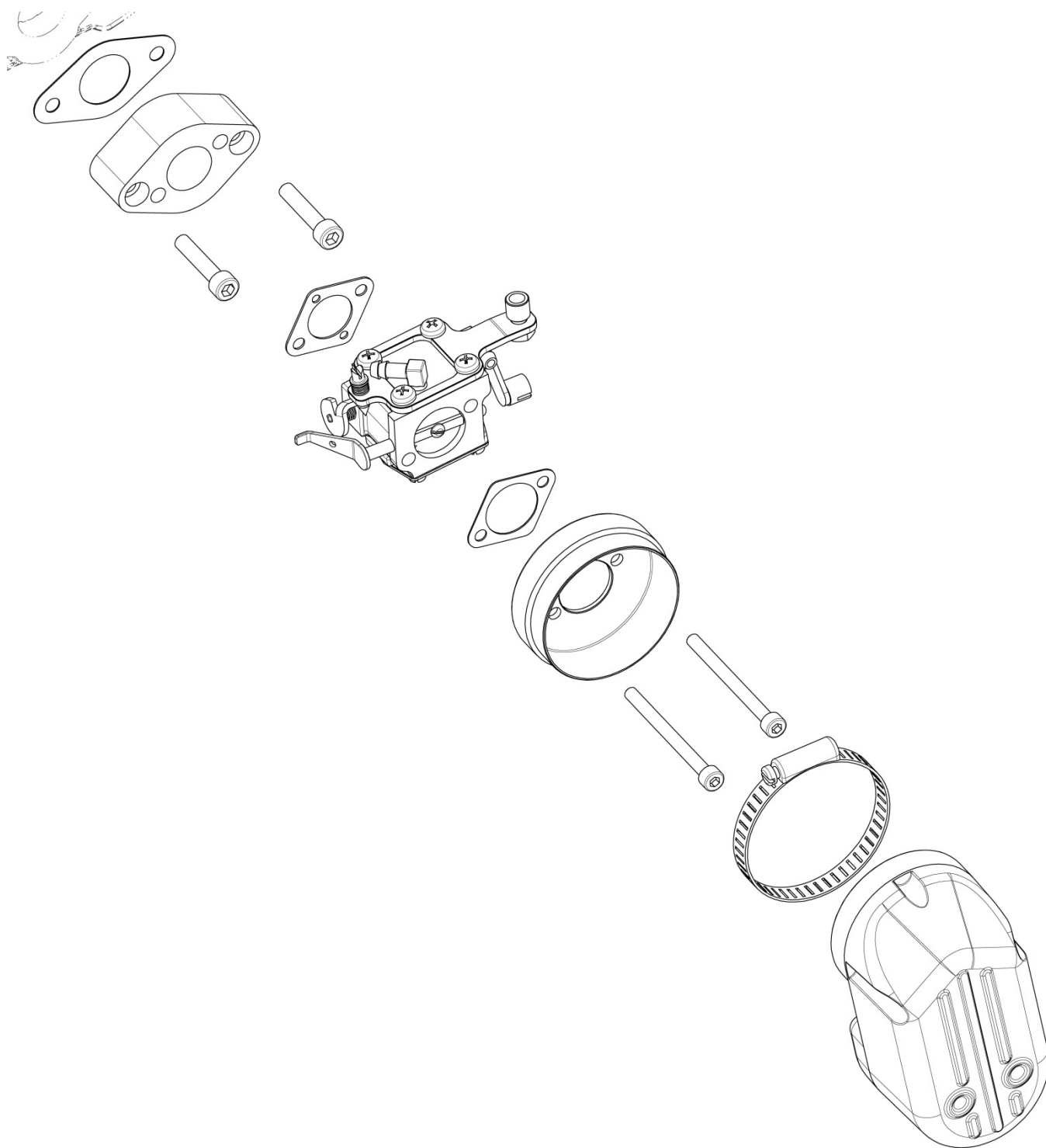
Combustion chamber volume in the cylinder head
(with Volumeter and CIK insert):

7.0 cm³ min

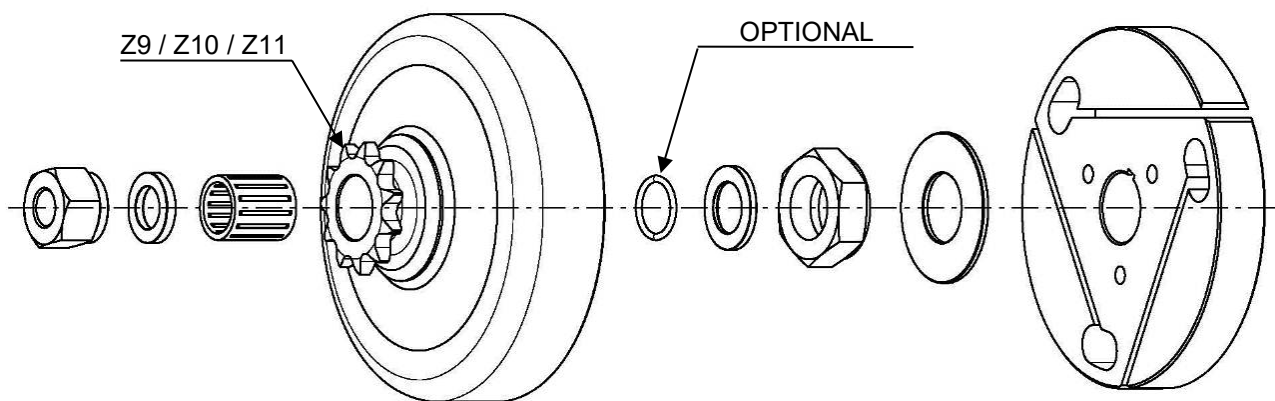




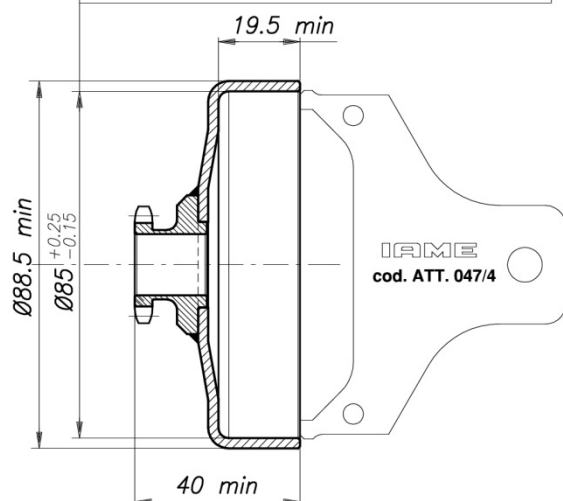
INLET SYSTEM EXPLODED VIEW



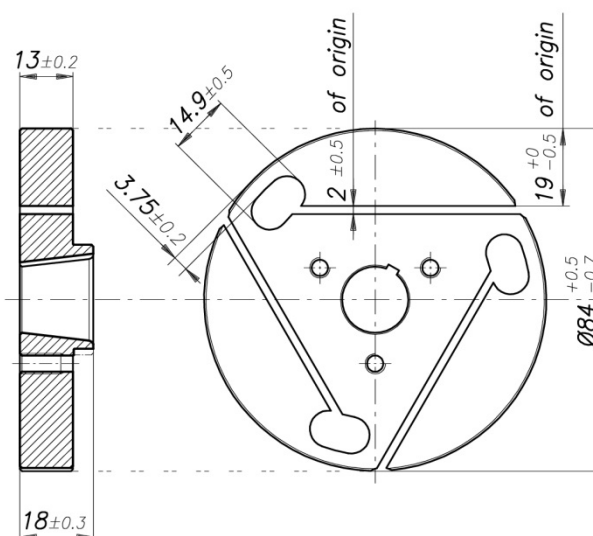
DESCRIPTION OF THE CLUTCH



The template "N.P." must be used in multiple directions.
In case it happen that in a direction "PASS" and another,
"DO NOT PASS", the clutch drum is considered regular.

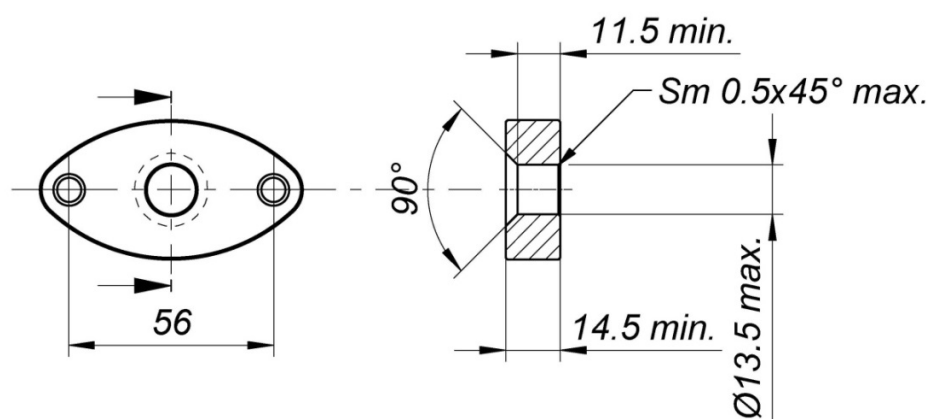


Min. Weight
210 g



Min. Weight
445 g

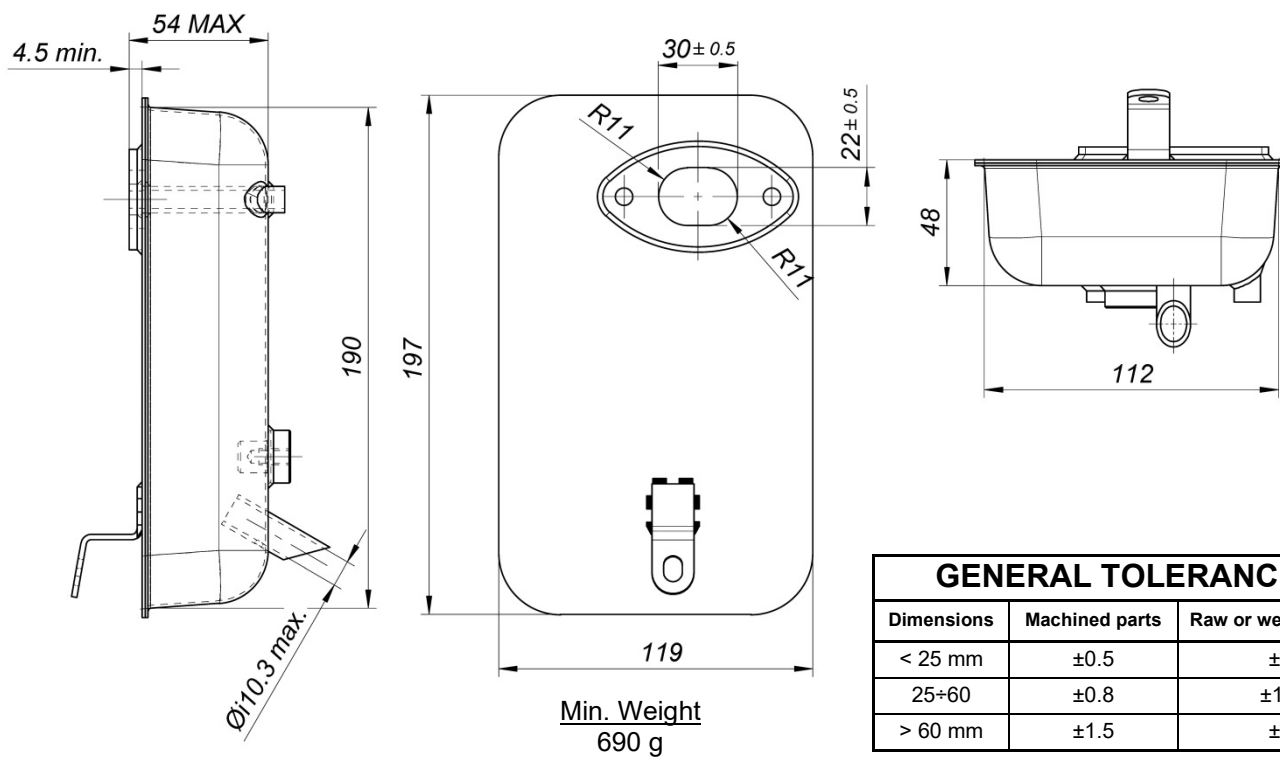
EXHAUST MANIFOLD



Identification marking
(on both sides)

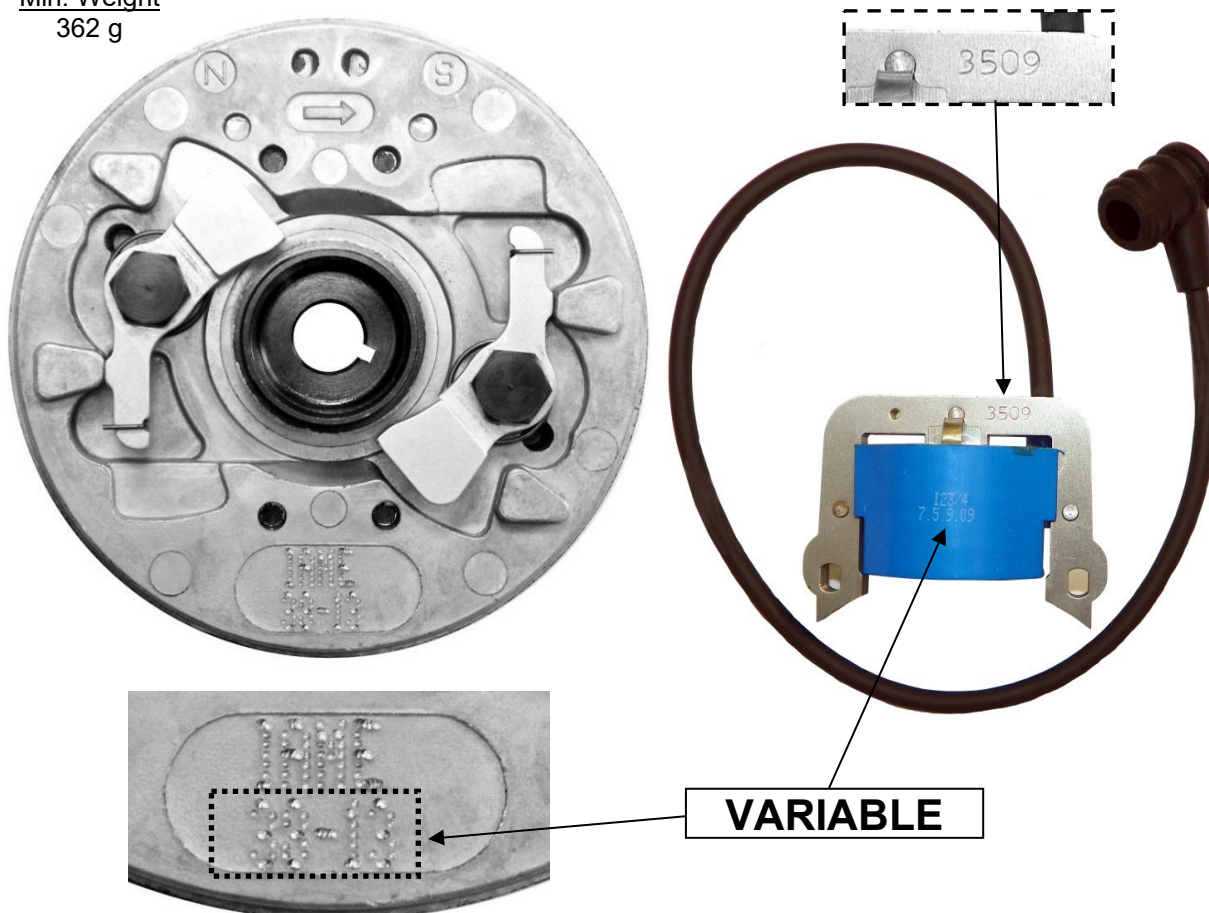


EXHAUST MUFFLER VIEW AND DIMENSIONS



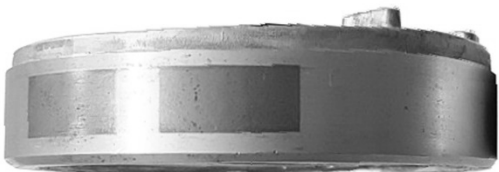
IGNITION PHOTO IDENTIFICATION MARKING

Min. Weight
362 g



ALTERNATIVE IGNITION ROTOR

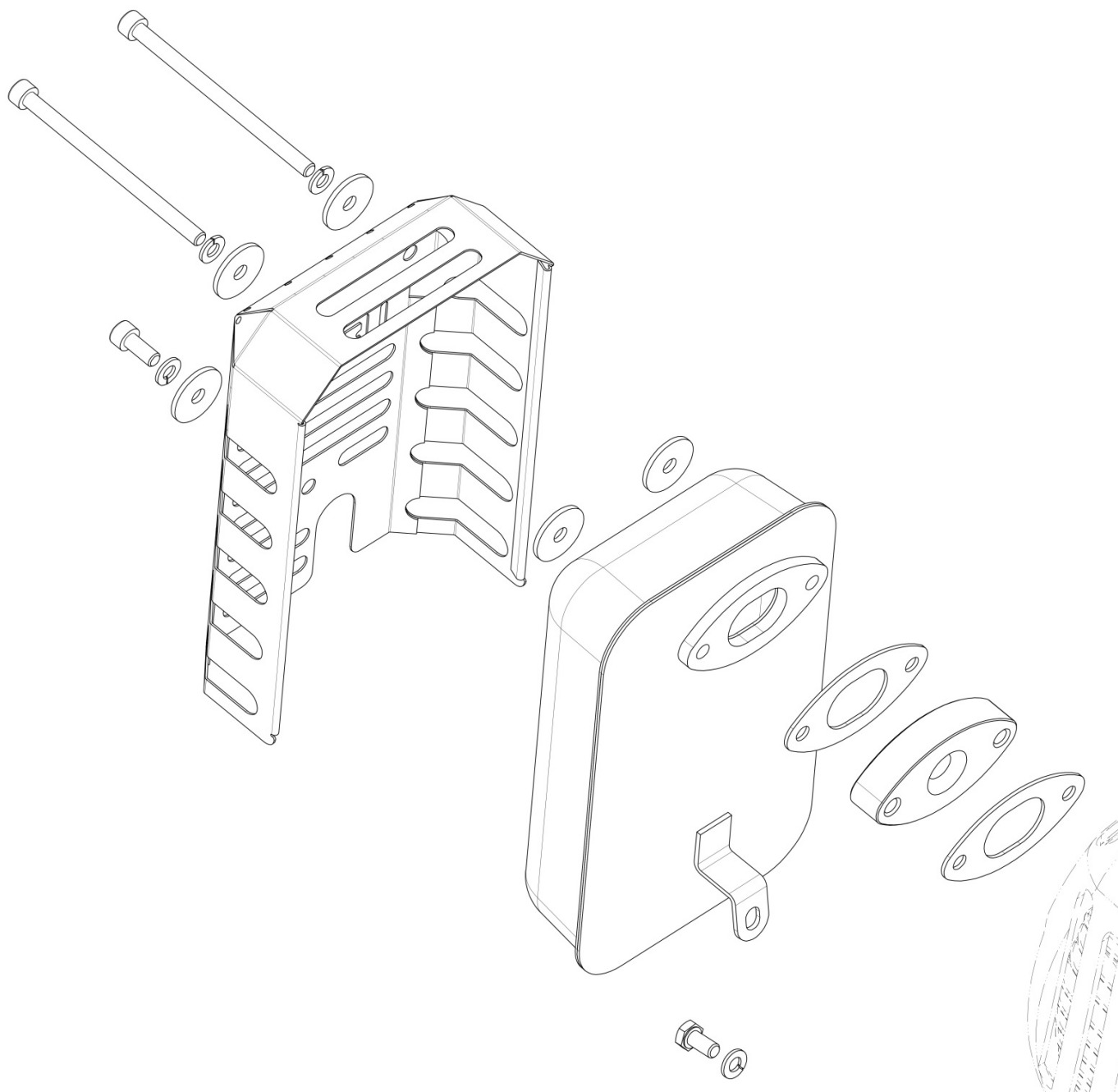
ROTOR TYPE 1



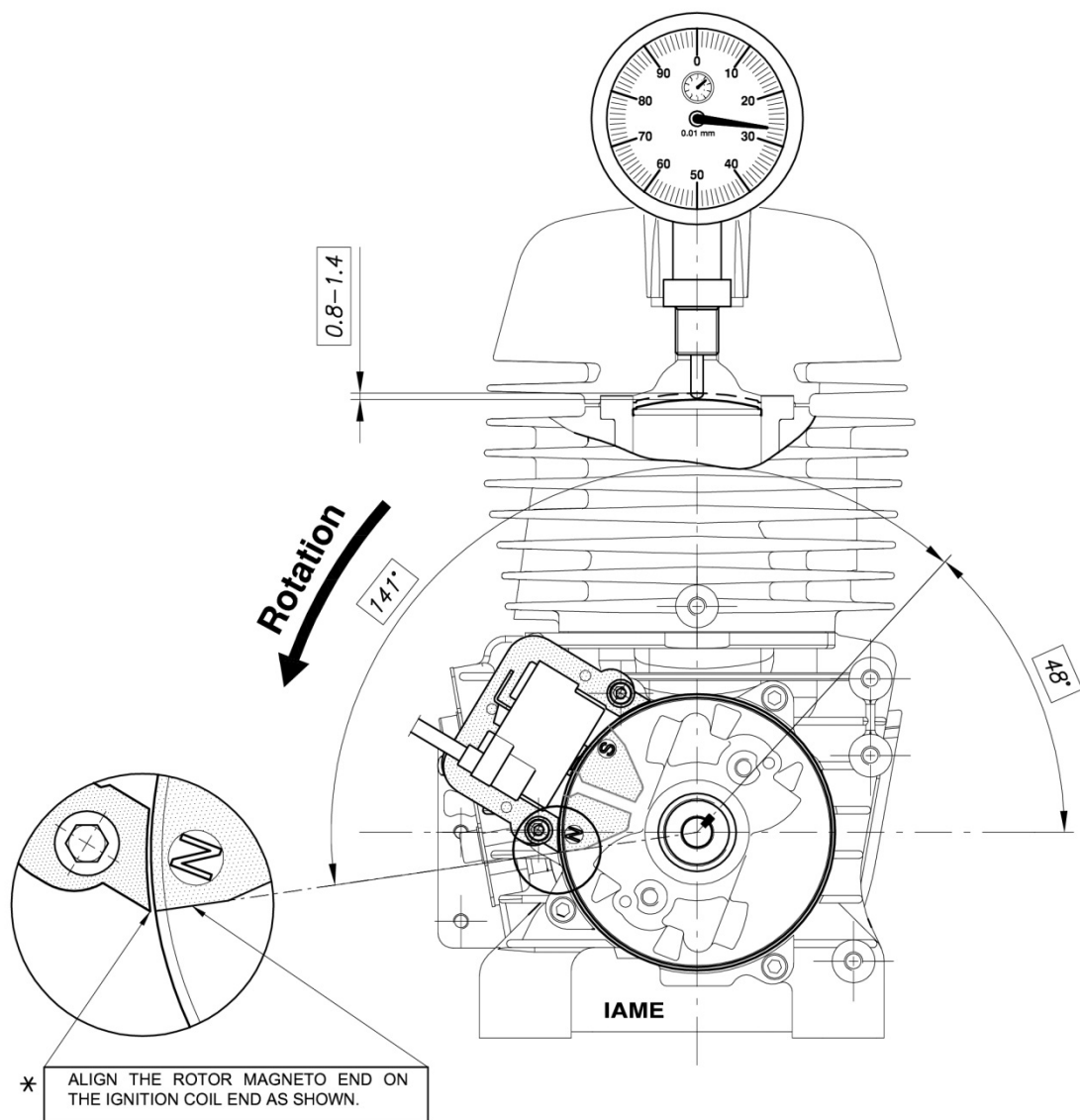
ROTOR TYPE 2



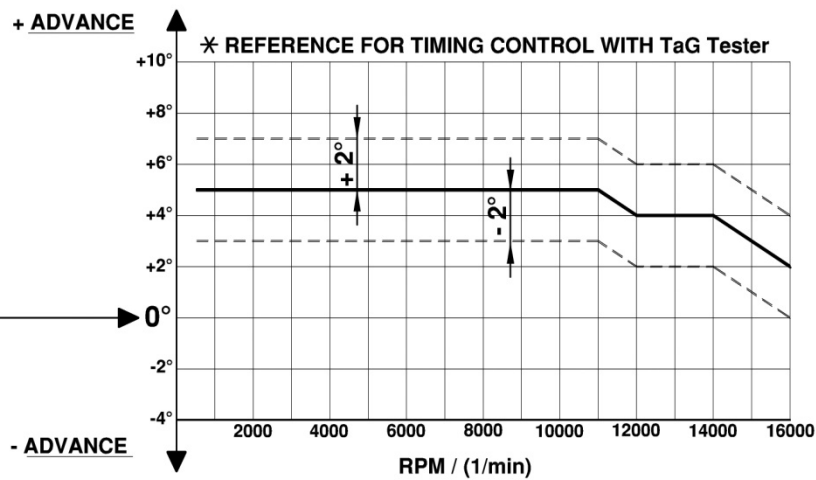
EXHAUST SYSTEM EXPLODED VIEW



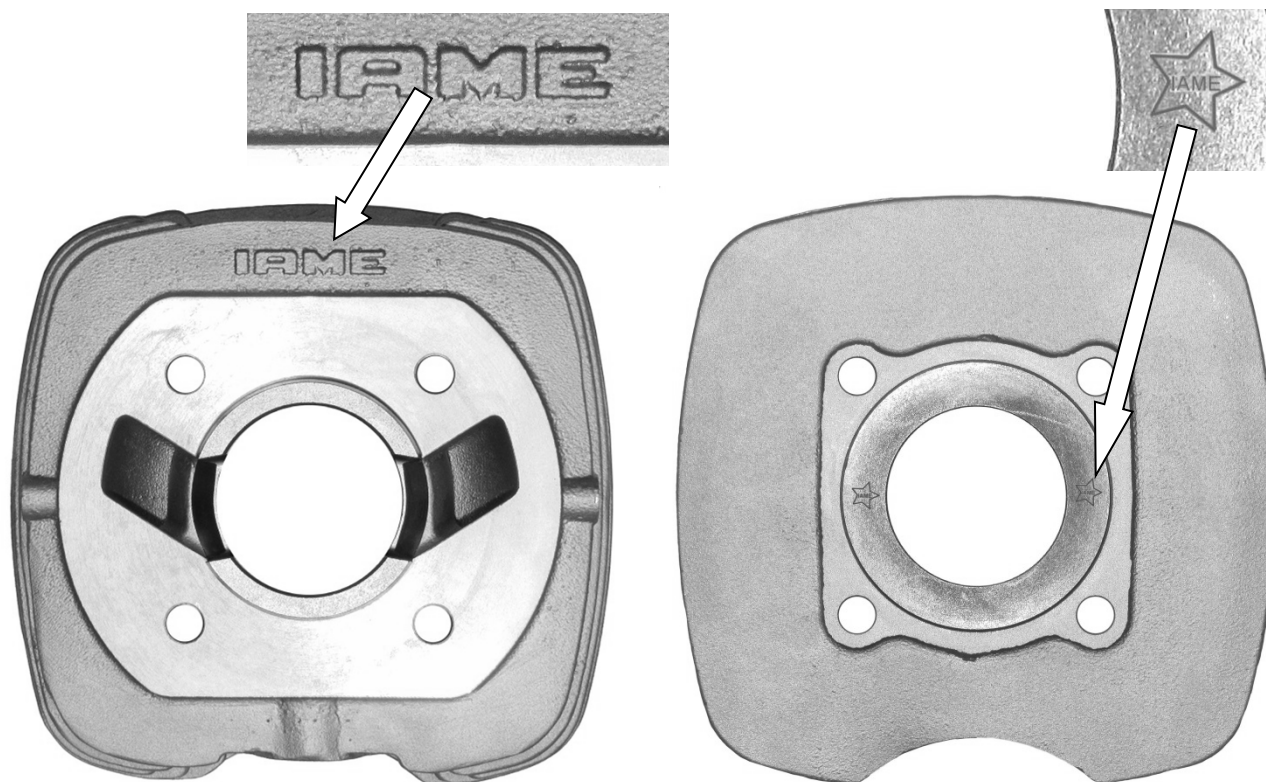
SCHEME FOR ADVANCE CONTROL



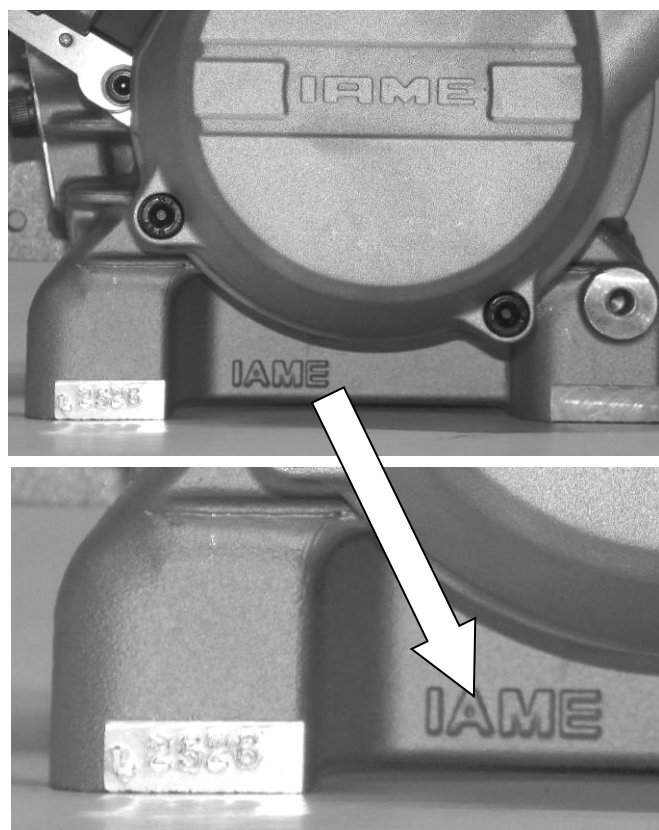
ADVANCE CURVE GRAPHS



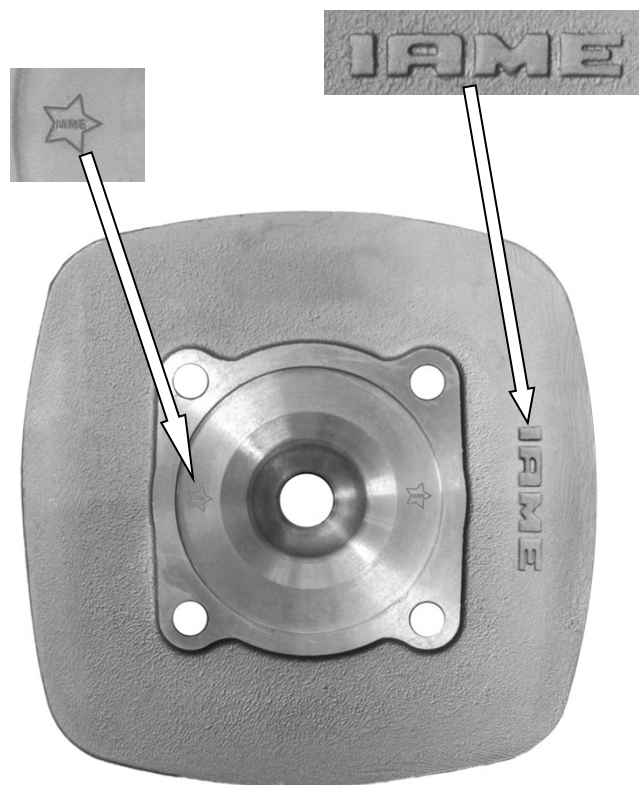
CYLINDER IDENTIFICATION MARKING

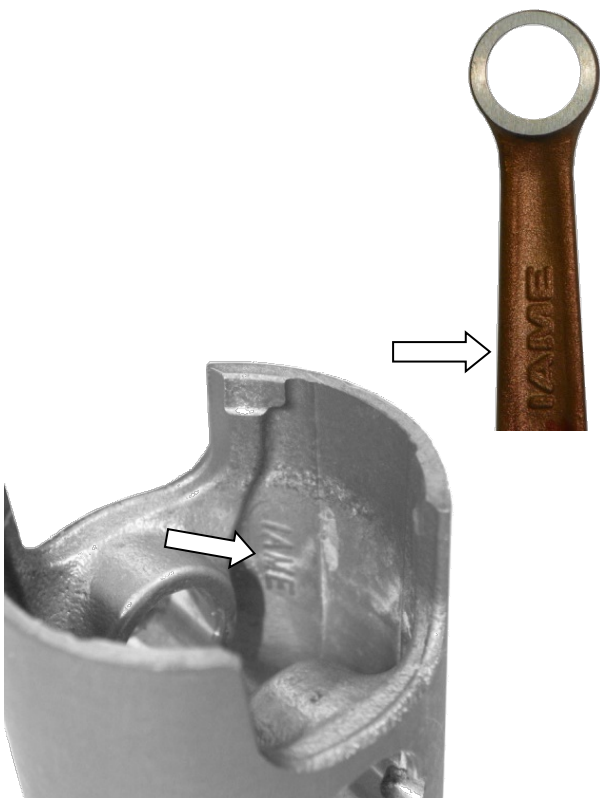
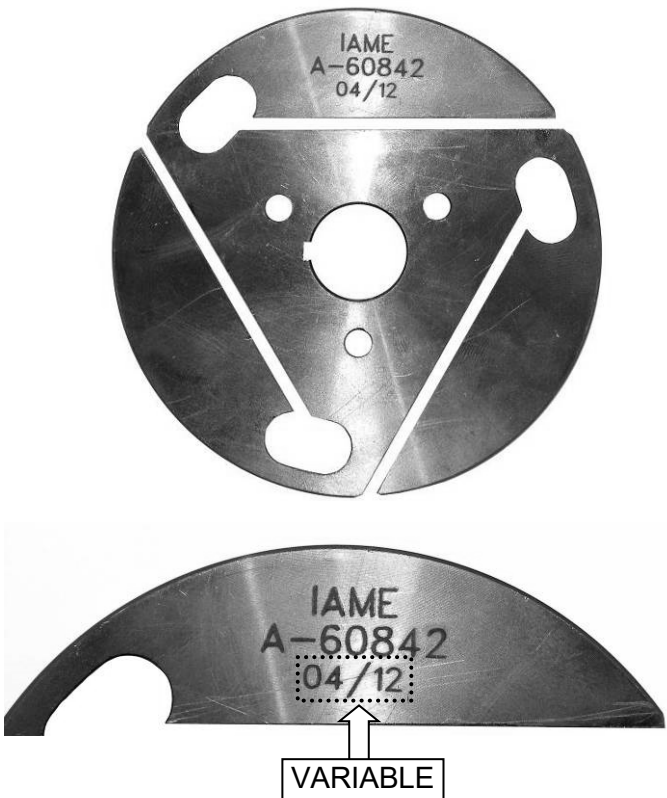
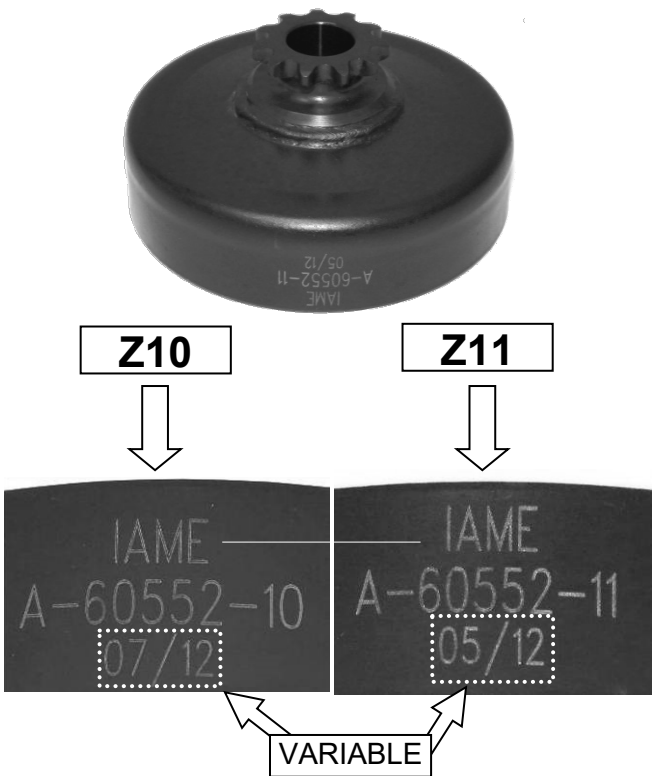


CRANKCASE IDENTIFICATION MARKING

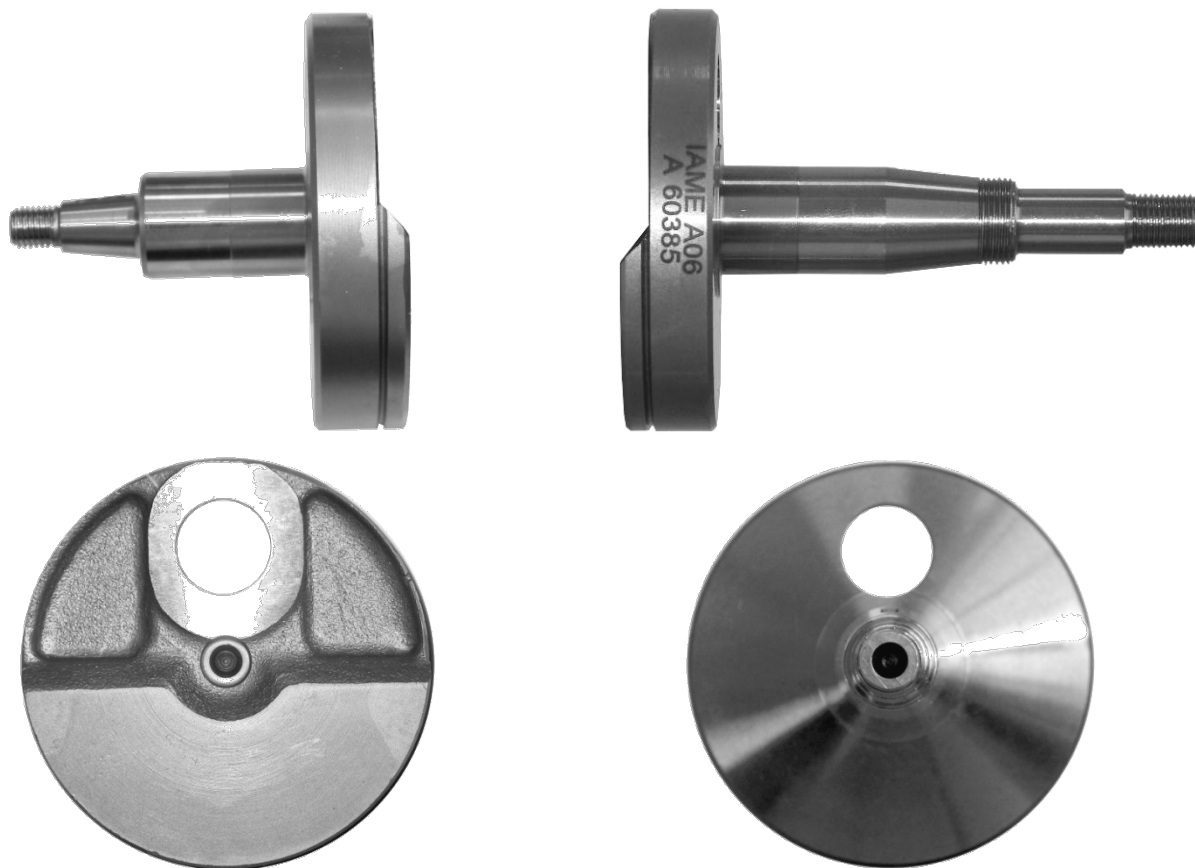


CYLINDER HEAD IDENTIFICATION MARKING



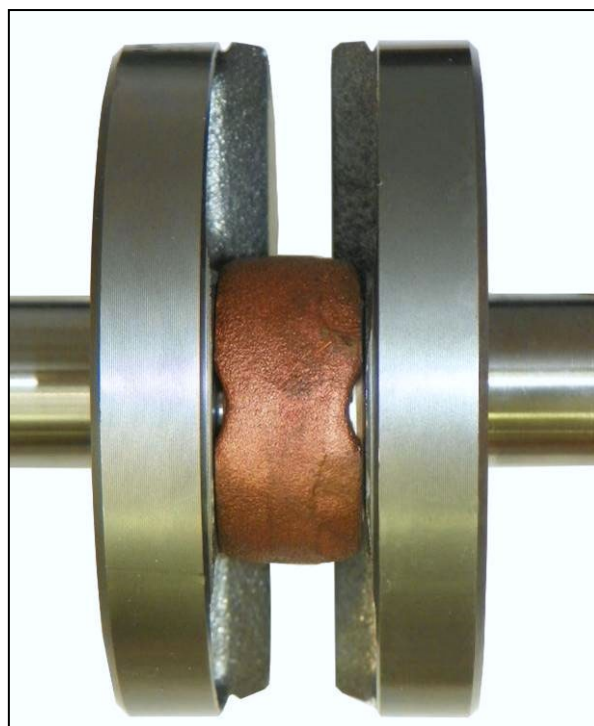
EXHAUST IDENTIFICATION MARKING	CONROD / PISTON IDENTIFICATION MARKINGS
 The image shows a black exhaust manifold. A white arrow points from a close-up of the 'IAME' logo on a black background to the 'IAME' marking on the manifold itself.	 The image shows a piston and a connecting rod. A white arrow points from a close-up of the 'IAME' marking on the piston to the 'IAME' marking on the connecting rod.
CLUTCH HUB IDENTIFICATION MARKING	CLUTCH DRUM IDENTIFICATION MARKING
 The image shows two views of a clutch hub. The top view is a full hub with the marking 'IAME A-60842 04/12'. The bottom view is a half-section of the hub with the marking 'IAME A-60842 04/12'. A white arrow points from the '04/12' to a box labeled 'VARIABLE'.	 The image shows a clutch drum with the marking 'IAME A-60552-11 05/12'. Below it are two boxes labeled 'Z10' and 'Z11'. Arrows point from these boxes to two images of the drum's marking. The left image shows 'IAME A-60552-10 07/12' with a white arrow pointing from the '07/12' to a box labeled 'VARIABLE'. The right image shows 'IAME A-60552-11 05/12' with a white arrow pointing from the '05/12' to a box labeled 'VARIABLE'.

CRANKSHAFT PHOTOS

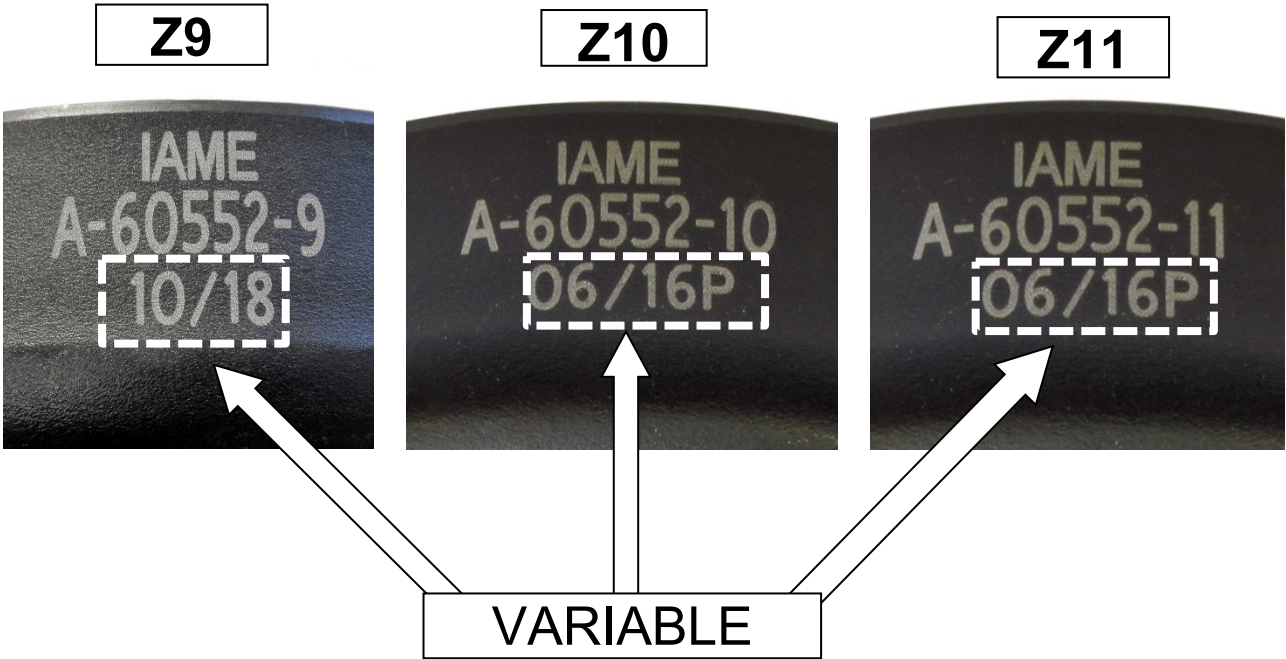


CRANKSHAFT IDENTIFICATION MARKINGS

PARTICULAR OF COMPLETE CRANKSHAFT



ALTERNATIVE CLUTCH DRUM



ALTERNATIVE CLUTCH COVER

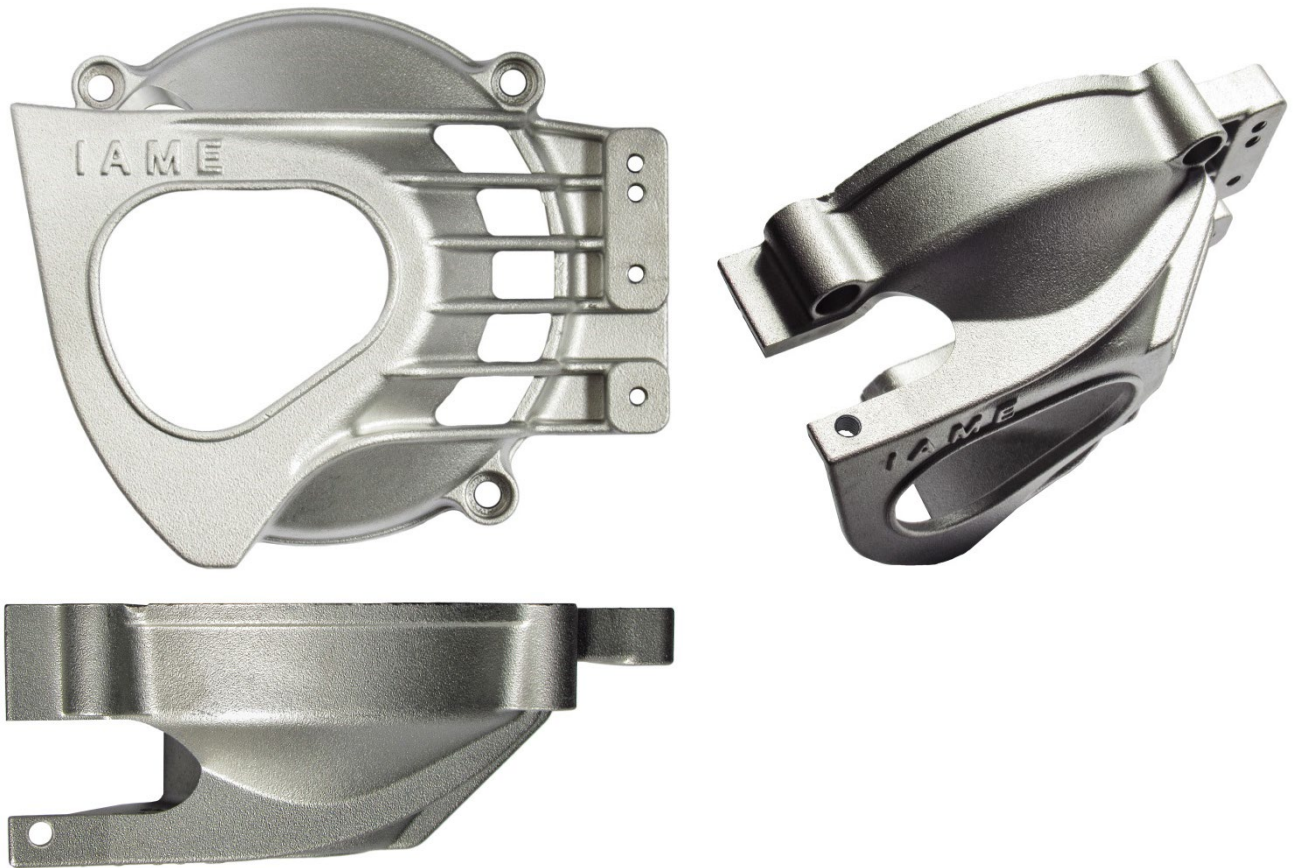
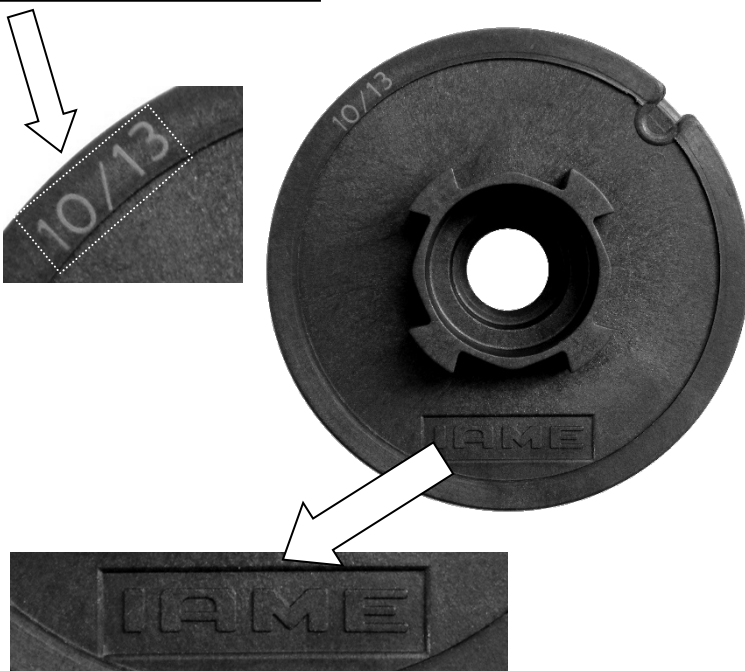


PHOTO IDENTIFICATION OF PULLEY – TYPES ALTERNATIVE

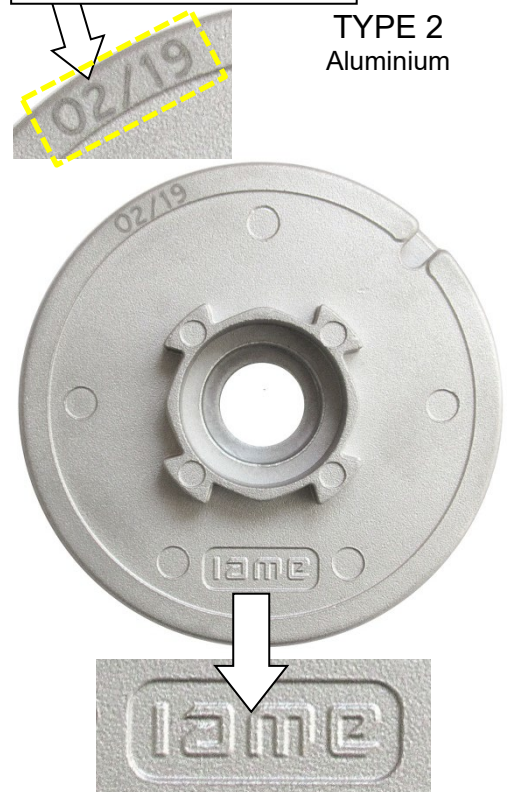
VARIABLE

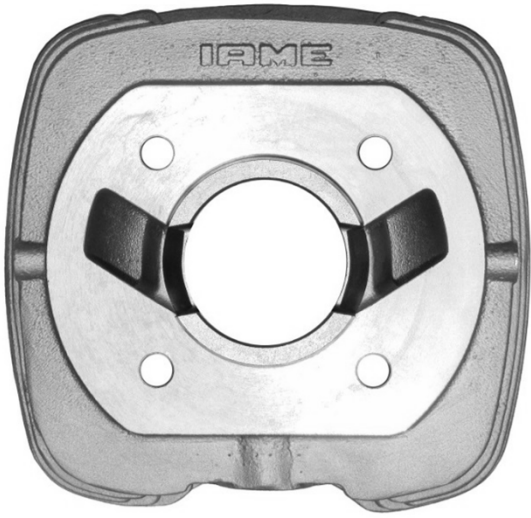
TYPE 1
Plastic



VARIABLE

TYPE 2
Aluminium



COMPONENTS WITH ALTERNATIVE NEW LOGO "IAME"	
CYLINDER HEAD	CYLINDER
 NEW LOGO 	 NEW LOGO 
SEMICARTER TRANSMISSION SIDE	SEMICARTER IGNITION SIDE
 NEW LOGO 	 NEW LOGO 

COMPONENTS WITH ALTERNATIVE NEW LOGO "IAME"	
RECOIL COVER	CLUTCH COVER
 A circular, silver-colored metal recoil cover with a blue-painted section on the right. The IAME logo is embossed in the center. NEW LOGO  A close-up of the embossed IAME logo on the recoil cover.	 A silver-colored metal clutch cover with a large central opening and a slatted design. The IAME logo is embossed on the upper left. NEW LOGO  A close-up of the embossed IAME logo on the clutch cover.
EXHAUST	
 A black, rectangular exhaust manifold with four mounting points. The IAME logo is embossed on the front. NEW LOGO  A close-up of the embossed IAME logo on the exhaust manifold.	

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

I A M E

or

IAME

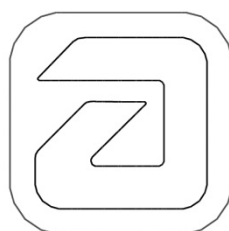
NOW COULD BE MARKED WITH NEW LOGO "IAME"

IAME

or

IAME

or





CARBURETTOR Tillotson HS-325A



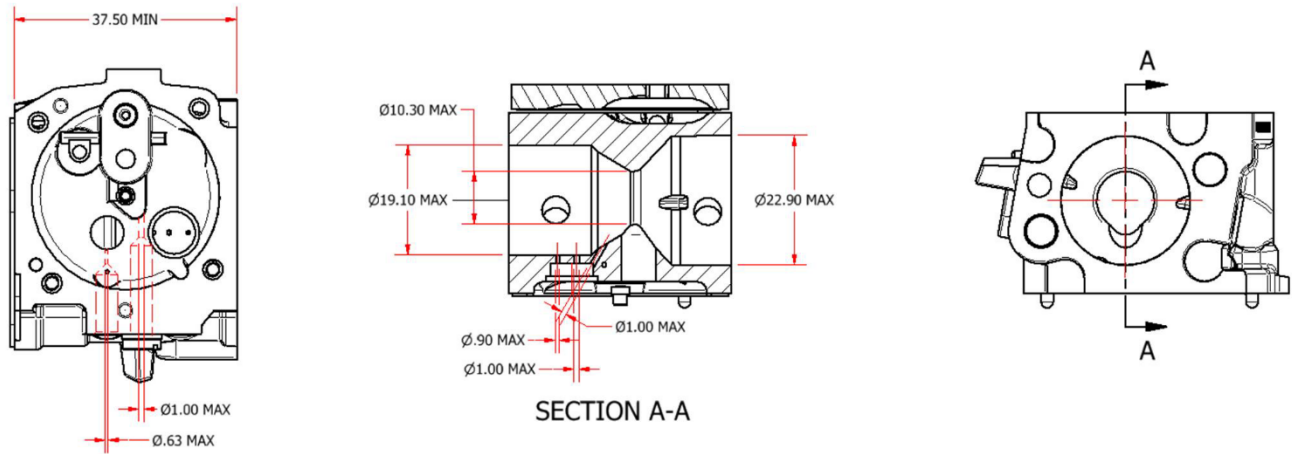
PHOTO OF ADJUSTING SIDE



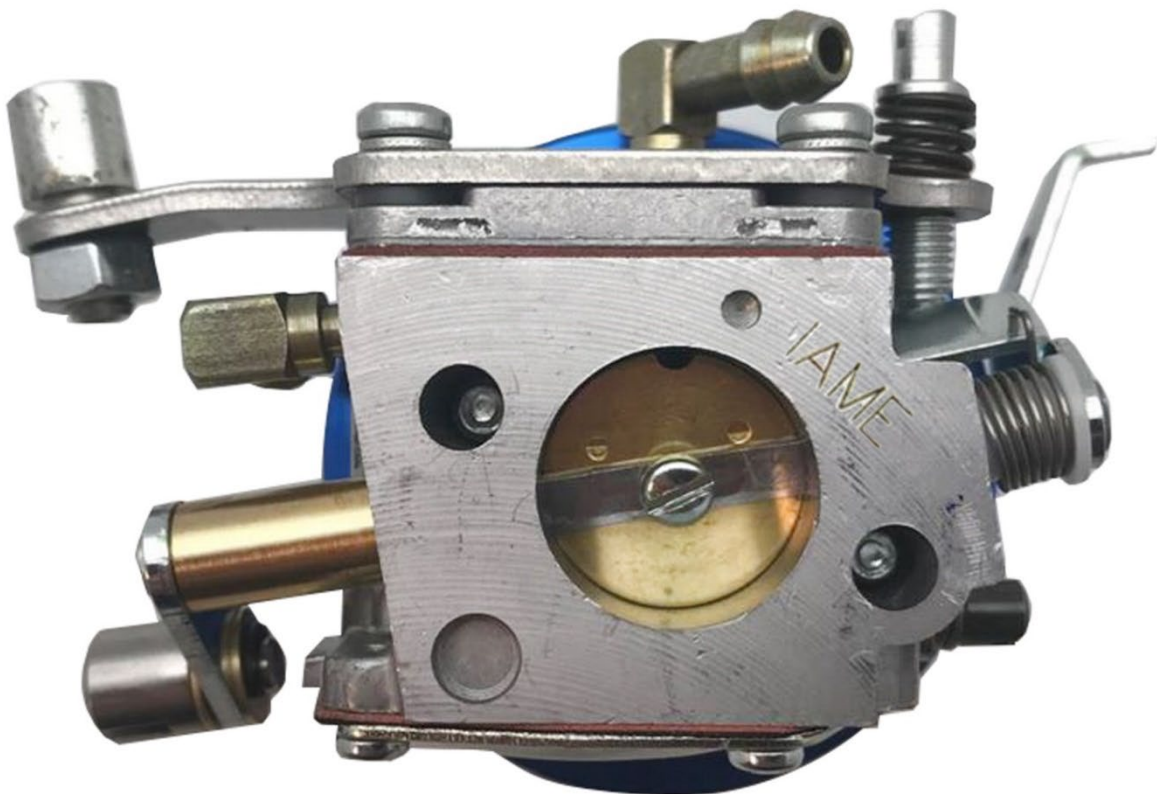
PHOTO OF INLET SIDE

Manufacteur	TILLOTSON LTD.
Make	TILLOTSON
Model	HS-325A

SECTION VIEW



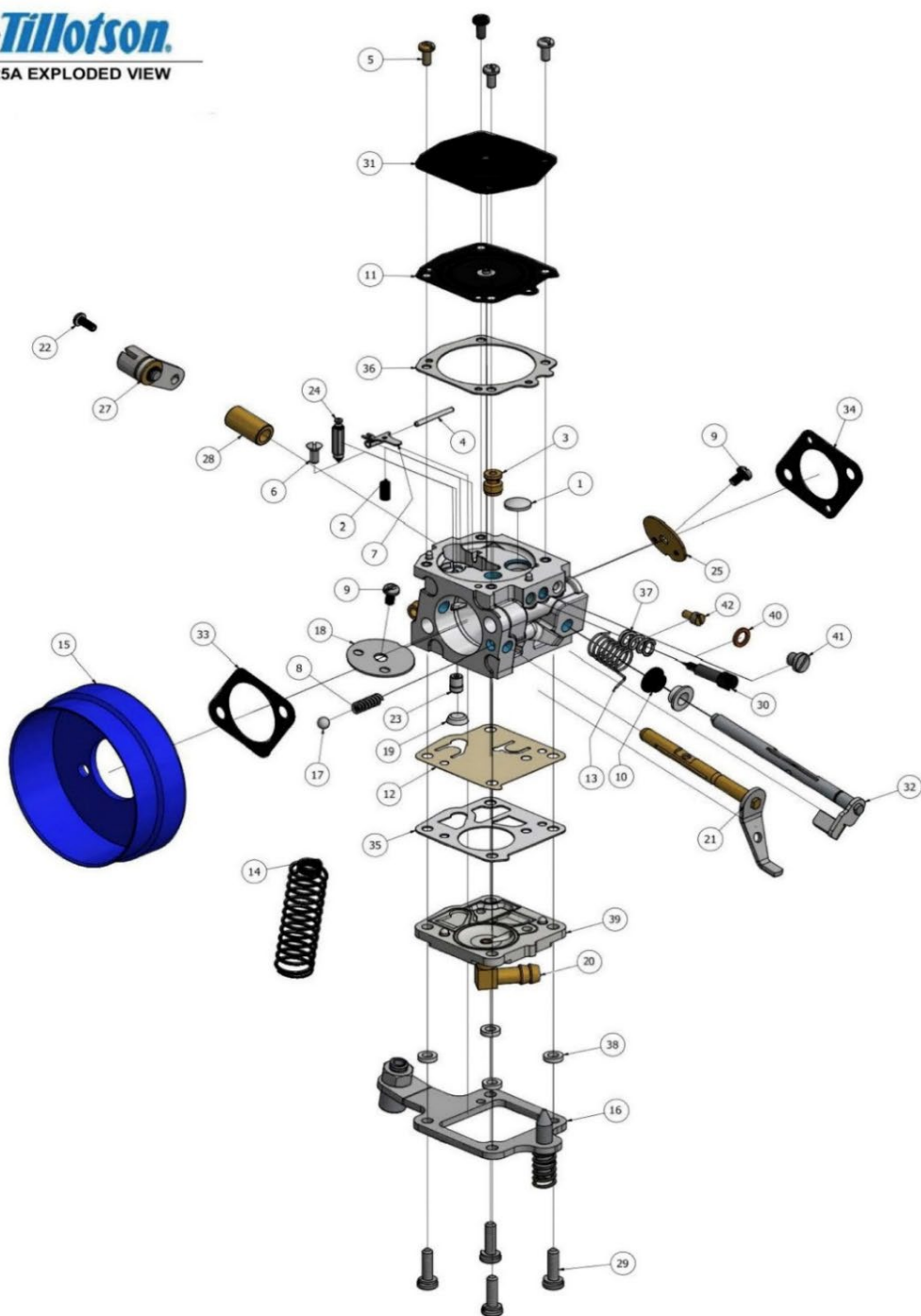
"IAME" MARKING



CARBURETTOR DESCRIPTION AND SKETCH OF PARTS



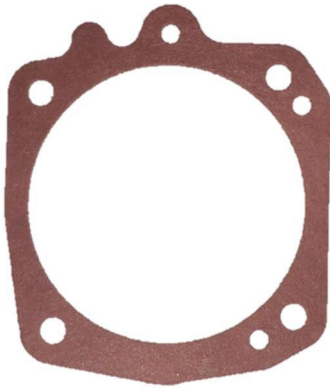
HS-325A EXPLODED VIEW



ITEM	QTY	PART NUMBER	DESCRIPTION	ITEM	QTY	PART NUMBER	DESCRIPTION	ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	179-59	* WELCH PLUG	18	1	27-392	CHOKE SHUTTER	35	1	16-B514	++ PUMP GASKET (ORANGE)
2	1	24-B323	INLET TENSION SPRING 26g	19	1	95-177	FILTER SCREEN	36	1	16-B513	++ METERING GASKET (ORANGE)
3	1	363-598	CHECK VALVE	20	1	68-307	FUEL CONNECTOR	37	1	24-B449	ADJUSTMENT SCREW SPRING
4	1	32-78	FULCRUM PIN	21	1	26-1279	CHOKE SHAFT & LEVER ASSEMBLY	38	4	78-A351	NYLON WASHER
5	4	15-C19	4-40 UNC SCREW	22	1	15-B348	3-48 UNC SCREW	39	1	91-1036	PUMP COVER ASSEMBLY
6	1	15-B345	FULCRUM PIN SCREW	23	1	36-A33	INLET SEAT	40	1	16-B184	RUBBER WASHER
7	1	155-A71	* FULCRUM LEVER	24	1	34-216	+ INLET NEEDLE	41	1	15-C135	SCREW - CAP
8	1	24-B281	SPRING	25	1	14-A133	THROTTLE SHUTTER	42	1	49-B134	FIXED JET - .43MM
9	2	15-C20	4-40 UNC SCREW	26	1	219-D281	MACHINED BODY				
10	2	102-204	PLASTIC SLEEVE	27	1	12-1228	THROTTLE LEVER & SWIVEL ASSEMBLY			*	REPAIR KIT CONTENTS
11	1	237-653	++ METERING DIAPHRAGM	28	1	102-236	BRASS SLEEVE			+	DIAPHRAGM & GASKET SET CONTENTS
12	1	237-143	++ TEFLON PUMP DIAPHRAGM	29	4	15-C127	6-32 SCREW & LOCK WASHER				
13	1	24-C29	THROTTLE RETURN SPRING	30	1	43-A268	M4 X 0.5 ADJUSTMENT SCREW			RK-28HS	REPAIR KIT
14	1	24-C334	CABLE RETURN SPRING	31	1	91-A274	METERING COVER			DG-7HS	DIAPHRAGM & GASKET SET
15	1	SA-506	CHOKE TRUMPET	32	1	13-2160	THROTTLE SHAFT & LEVER ASSEMBLY				
16	1	136-569	CABLE BRACKET ASSEMBLY	33	1	16-B384	++ FLANGE GASKET (CHOKE)				
17	1	206-121	BRASS BALL	34	1	16-B228	++ FLANGE GASKET (THROTTLE)				

PARTS OF CARBURETTOR

REF.36 - P. N°16-B513
DIAPHRAGM GASKET
(ORANGE COLOR)



Thickness = 0.5 ± 0.1 mm

REF.35 - P. N° 16-B514
PUMP DIAPHRAGM GASKET
(ORANGE COLOR)



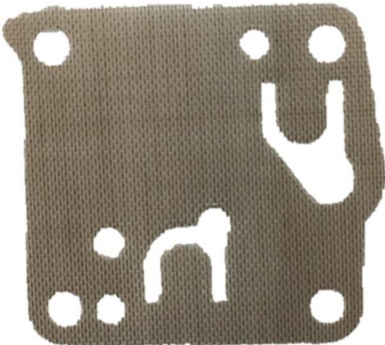
Thickness = 0.5 ± 0.1 mm

REF.11 - P. N°237-601
DIAPHRAGM



Thickness = 0.15 ± 0.05 mm

REF.12- P. N°237-143
PUMP DIAPHRAGM



Thickness = 0.21 ± 0.05 mm

REF.31 - P. N° 91-A274
DIAPHRAGM COVER

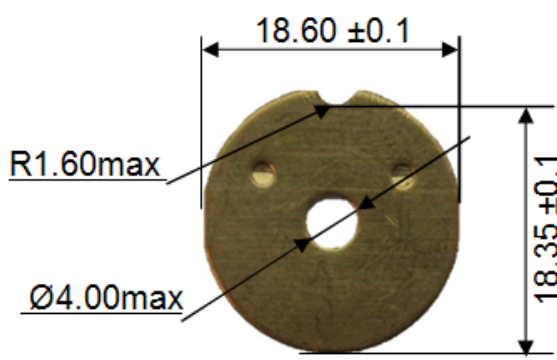
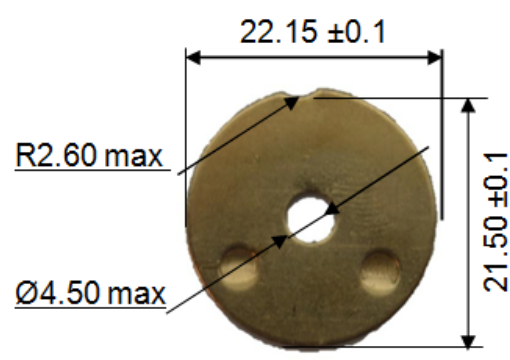
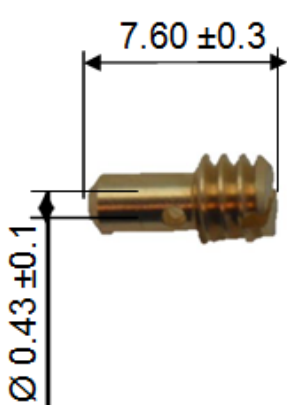
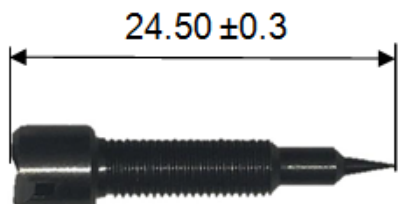
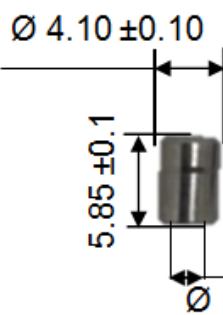
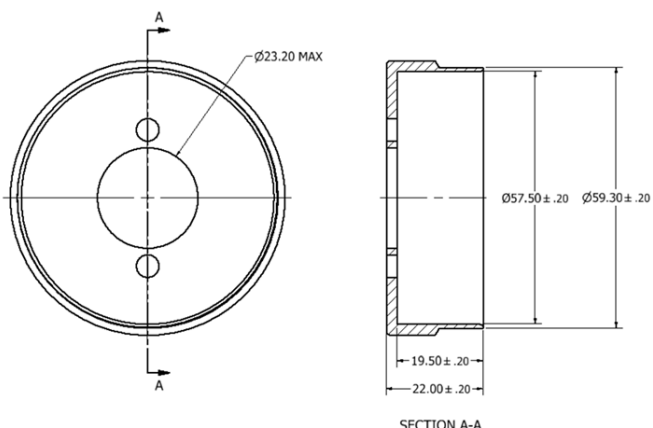


Thickness = 3.10 ± 0.15 mm

REF.39 - P. N° 91-1036
PUMP COVER



Thickness = 6.30 ± 0.15 mm

REF.25 - P. N° 14-A135 THROTTLE SHUTTER  Thickness = 0.81 ± 0.1 mm	REF.18 - P. N° 27-392 CHOKE SHUTTER  Thickness = 0.81 ± 0.1 mm
REF.42 - P. N° 49-B134 FIXED JET – 0.43mm 	REF.30 - P. N° 43-A268 NEEDLE HIGH SPEED 
REF.23 – P. N° 36-A33 INLET SEAT  REF.24 – P. N° 34-216 INLET NEEDLE 	REF.15 - P. N° SA-506 CHOKE TRUMPET  SECTION A-A