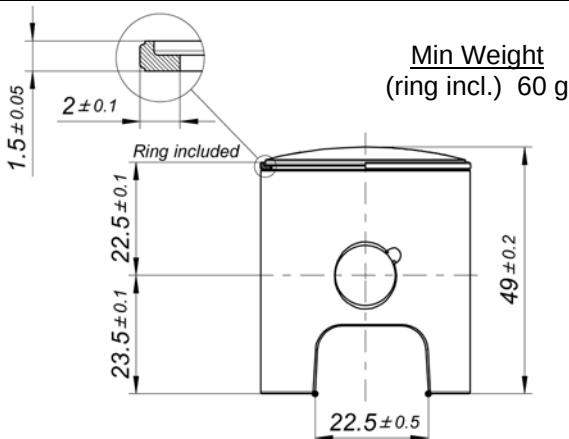
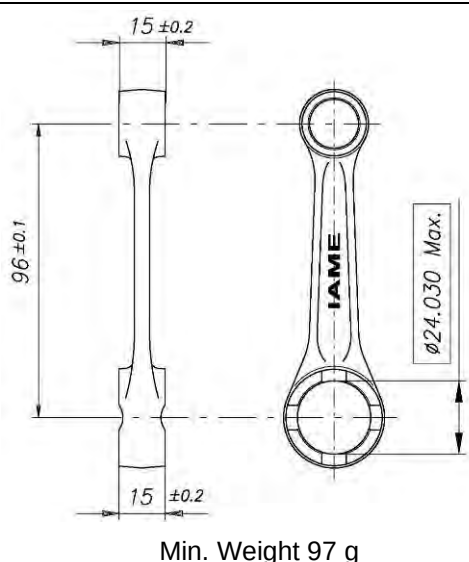
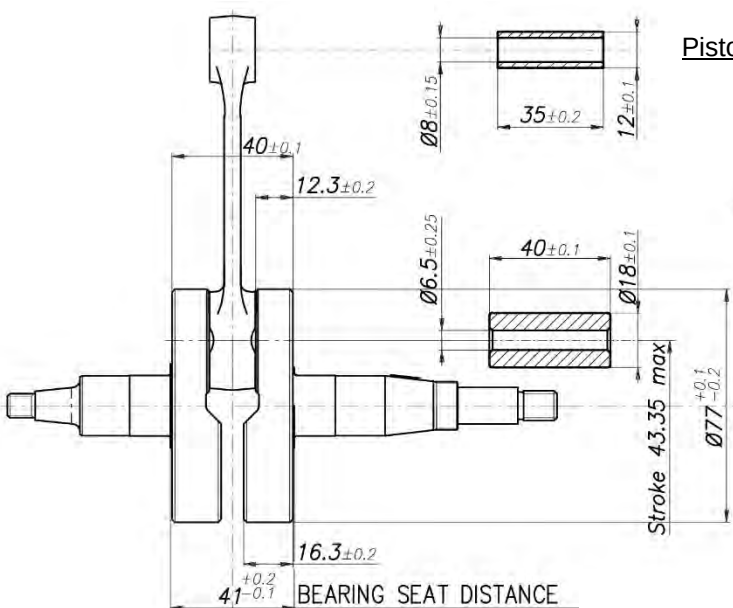
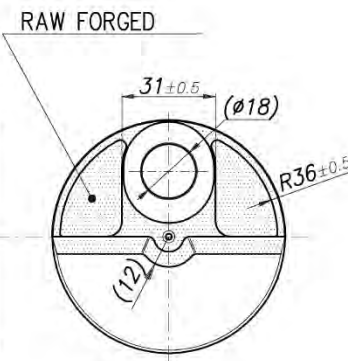


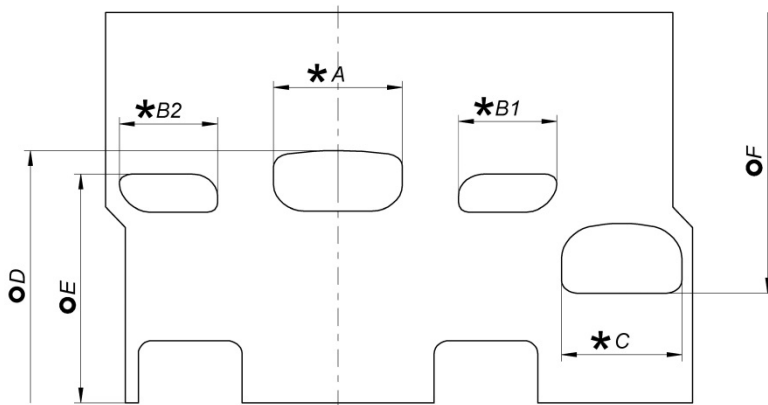
M1 - 60cc PULL START

		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	

CRANKSHAFT		
	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

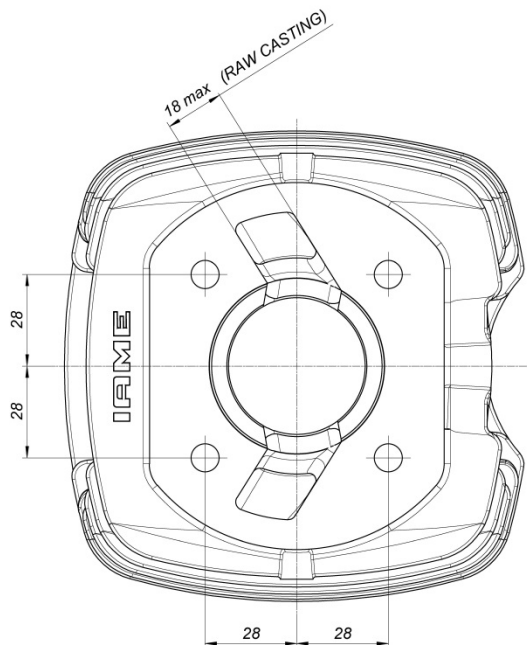


* CHORDAL READING

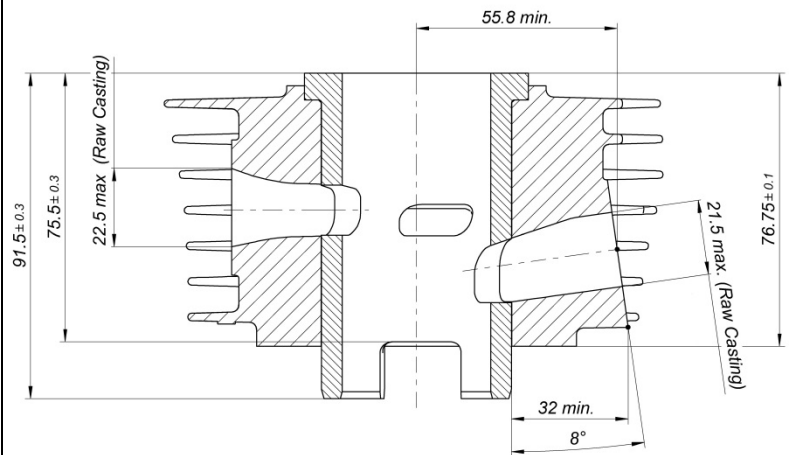
○ ANGULAR READING BY INSERT A 0.2x5 mm GAUGE

USING IAME TOOL - Cod. 10194

CYLINDER BASE VIEW



CYLINDER CROSS SECTION VIEW



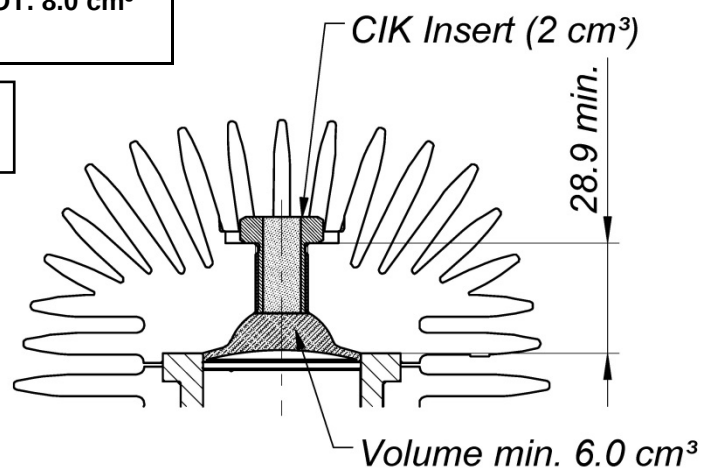
COMBUSTION CHAMBER VIEW

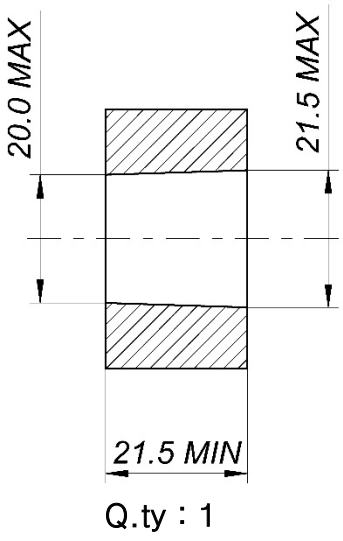
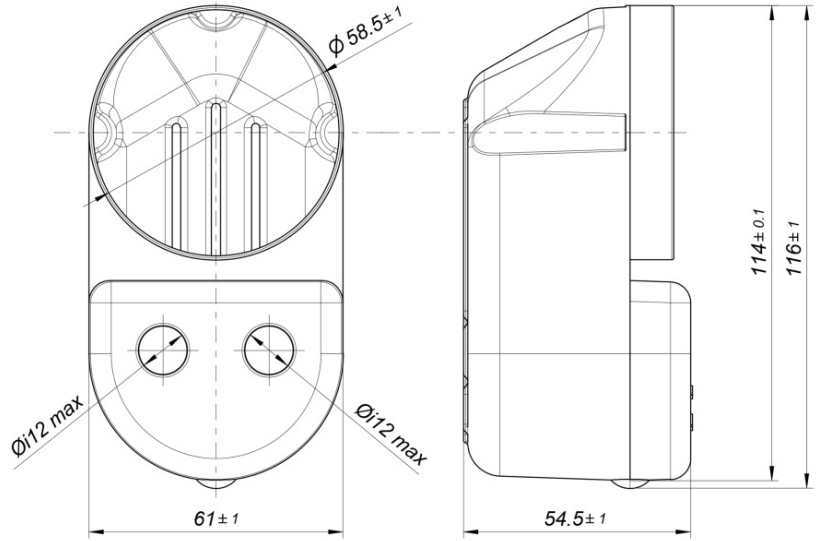
COMBUSTION CHAMBER VOLUME = 6.0 + 2 = TOT. 8.0 cm³
min.

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

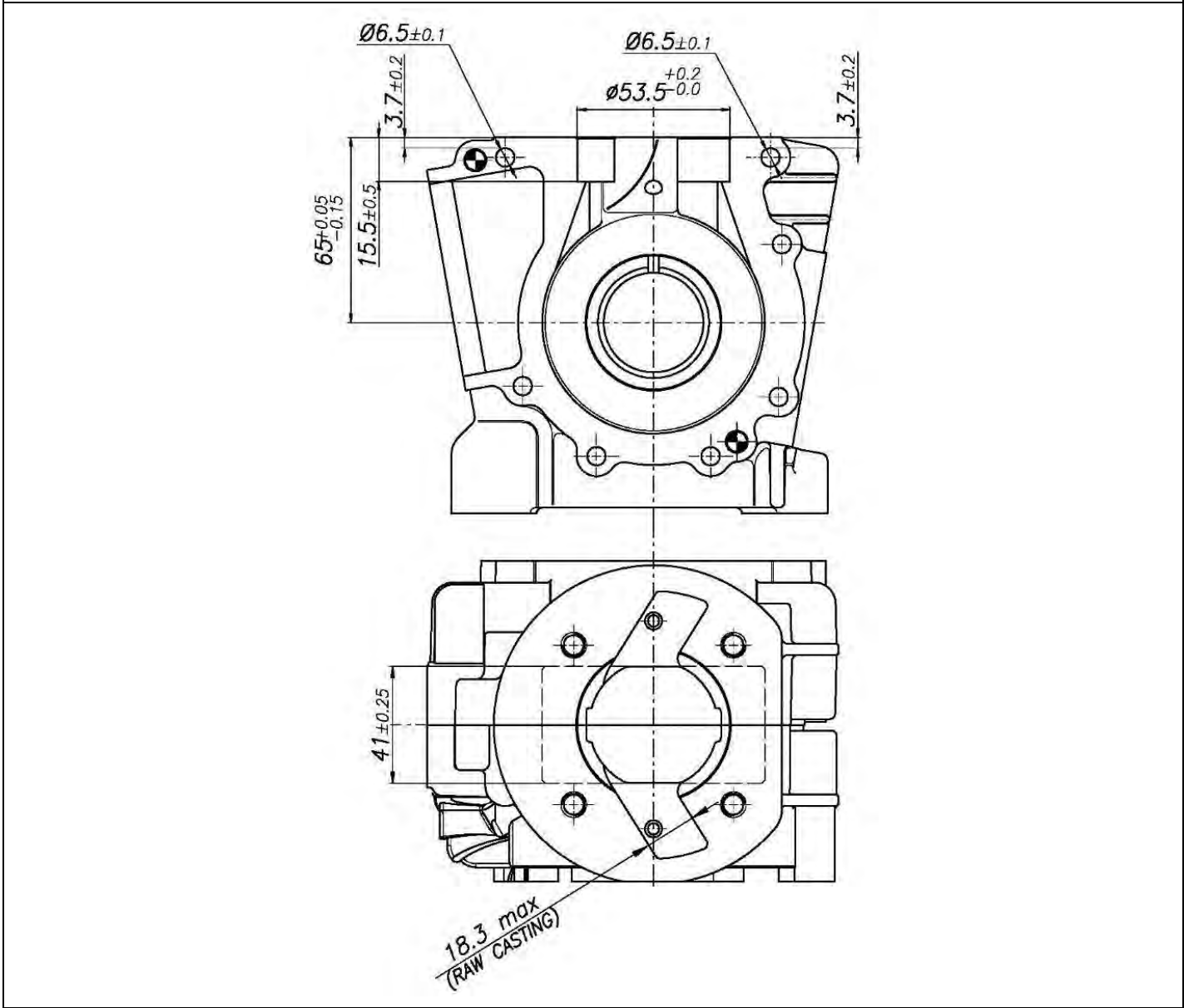
Combustion chamber volume in the cylinder head
(with Volumeter and CIK insert):

7.0 cm³ min

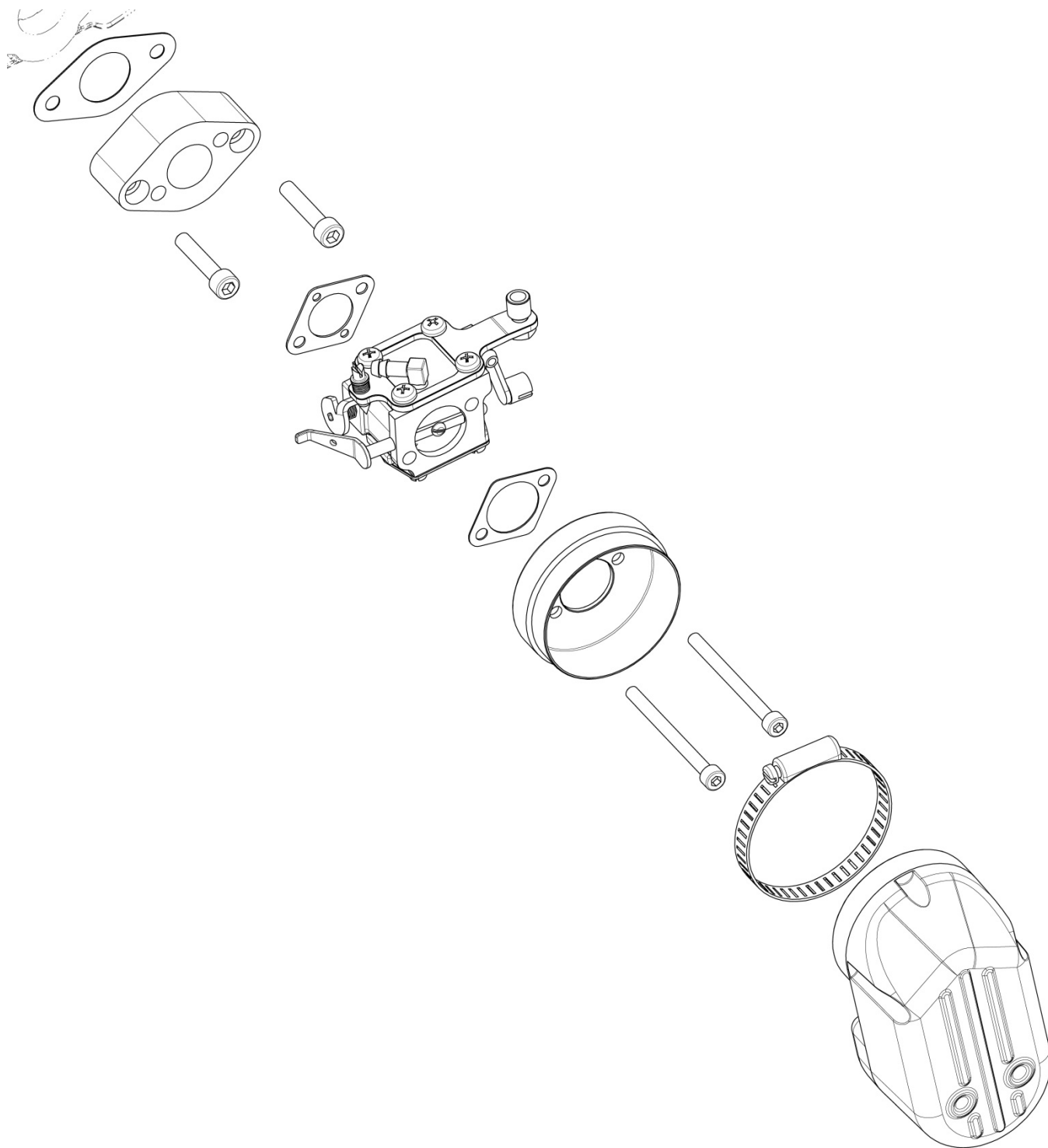


THERMAL SPACER	INLET SILENCER
 20.0 MAX 21.5 MAX 21.5 MIN Q.ty : 1	 Ø58.5±1 Ø12 max 61±1 54.5±1 114±0.1 116±1

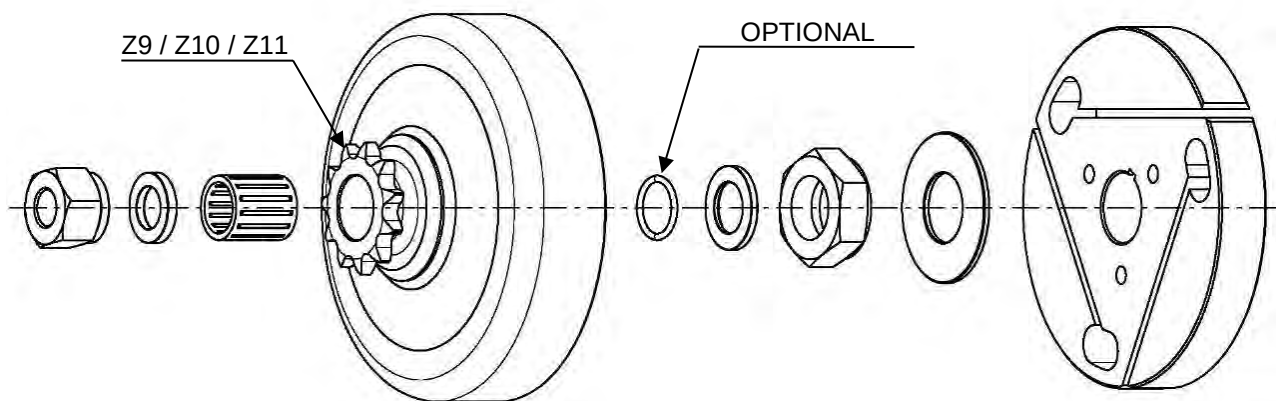
CRANKCASE INSIDE VIEW



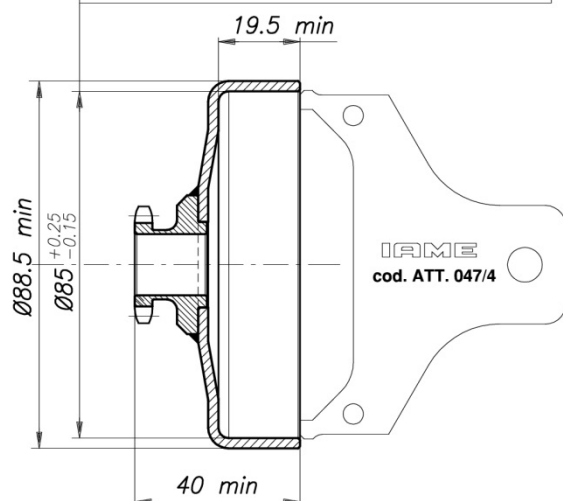
INLET SYSTEM EXPLODED VIEW



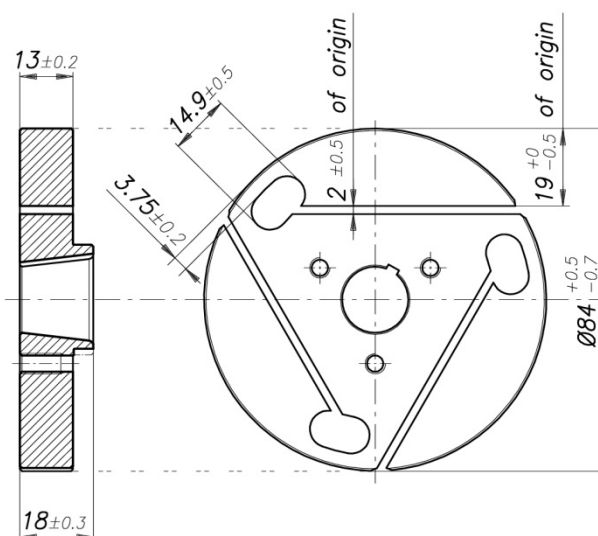
DESCRIPTION OF THE CLUTCH



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

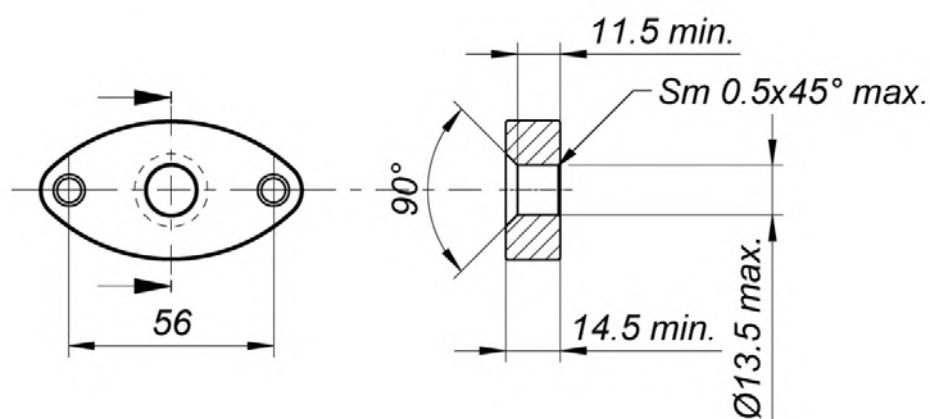


Min. Weight
210 g



Min. Weight
445 g

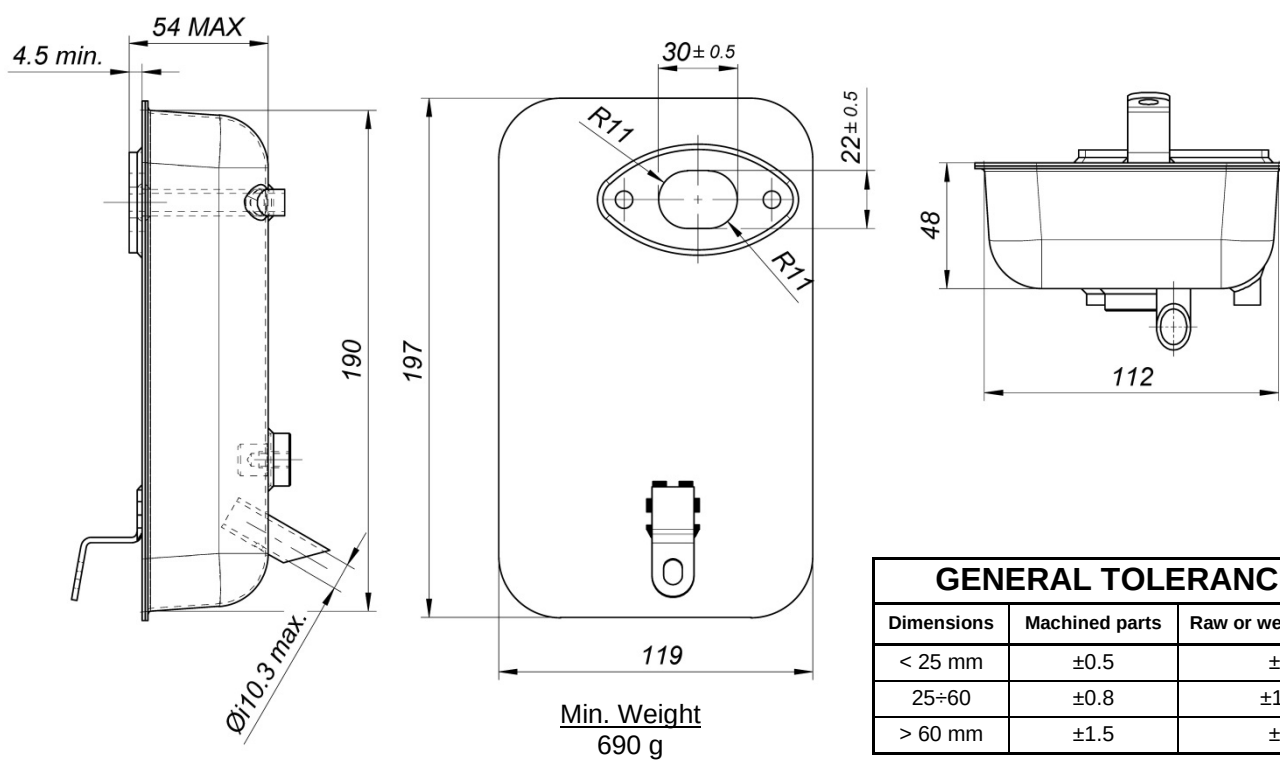
EXHAUST MANIFOLD



Identification marking
(on both sides)

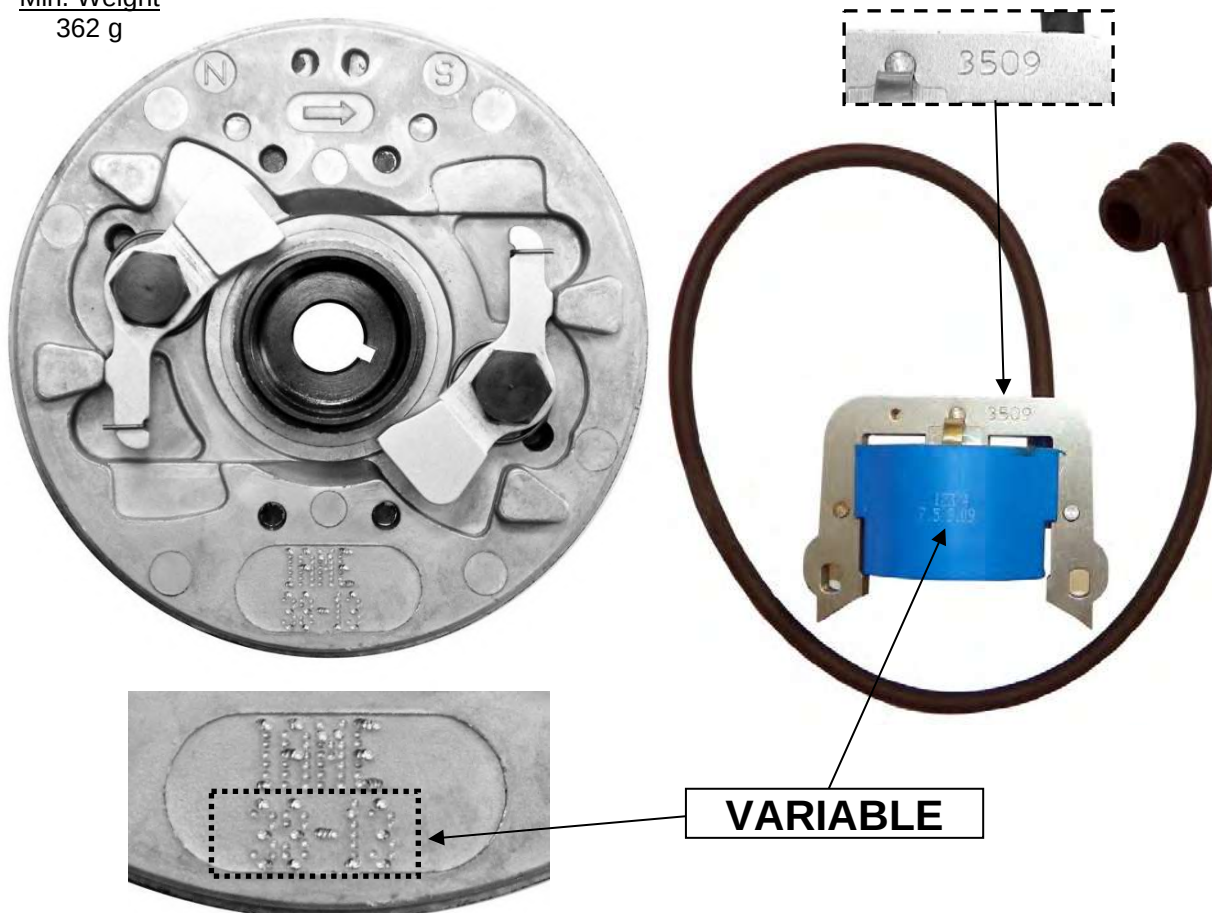


EXHAUST MUFFLER VIEW AND DIMENSIONS



IGNITION PHOTO IDENTIFICATION MARKING

Min. Weight
362 g



ALTERNATIVE IGNITION ROTOR

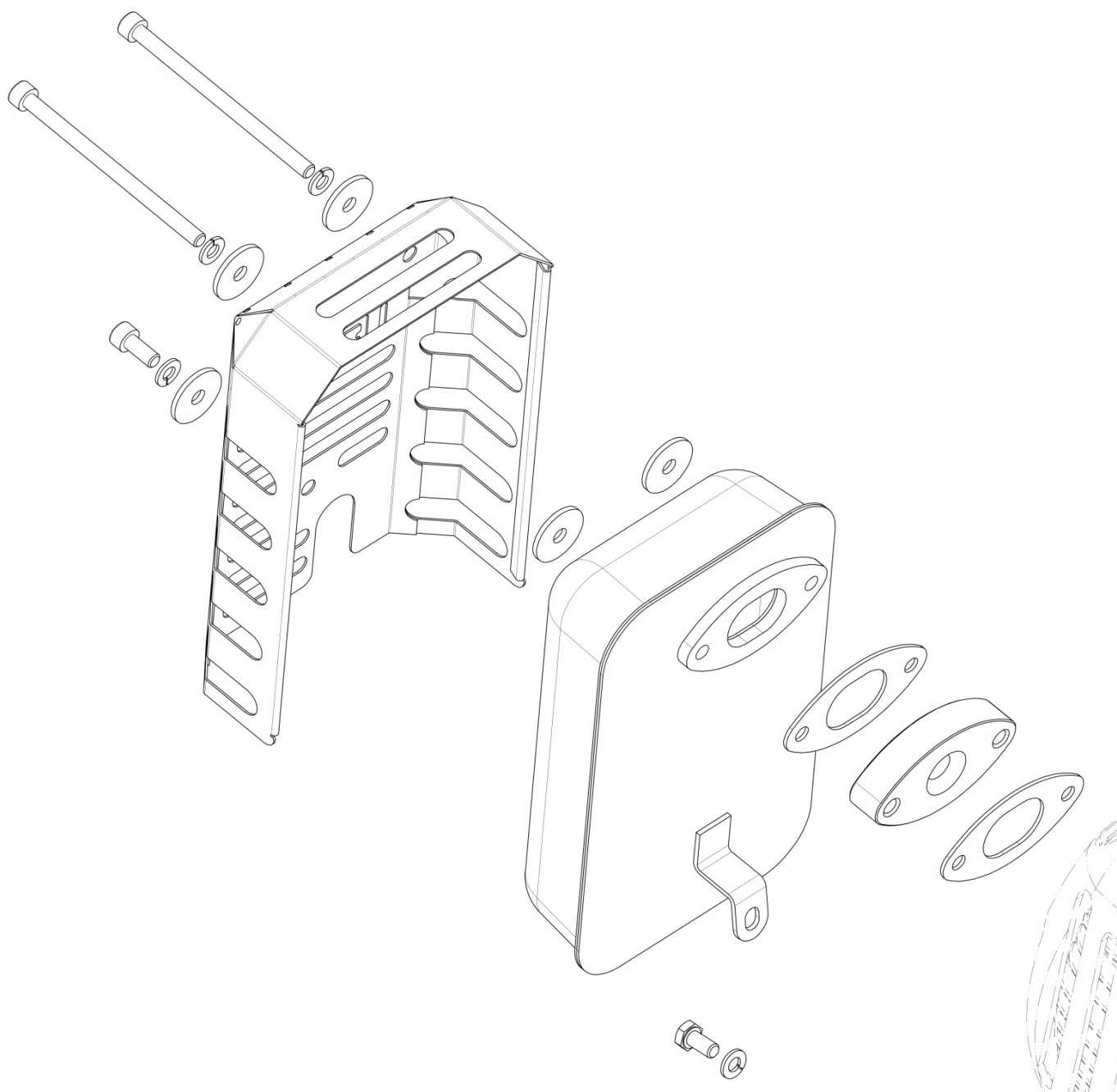
ROTOR TYPE 1



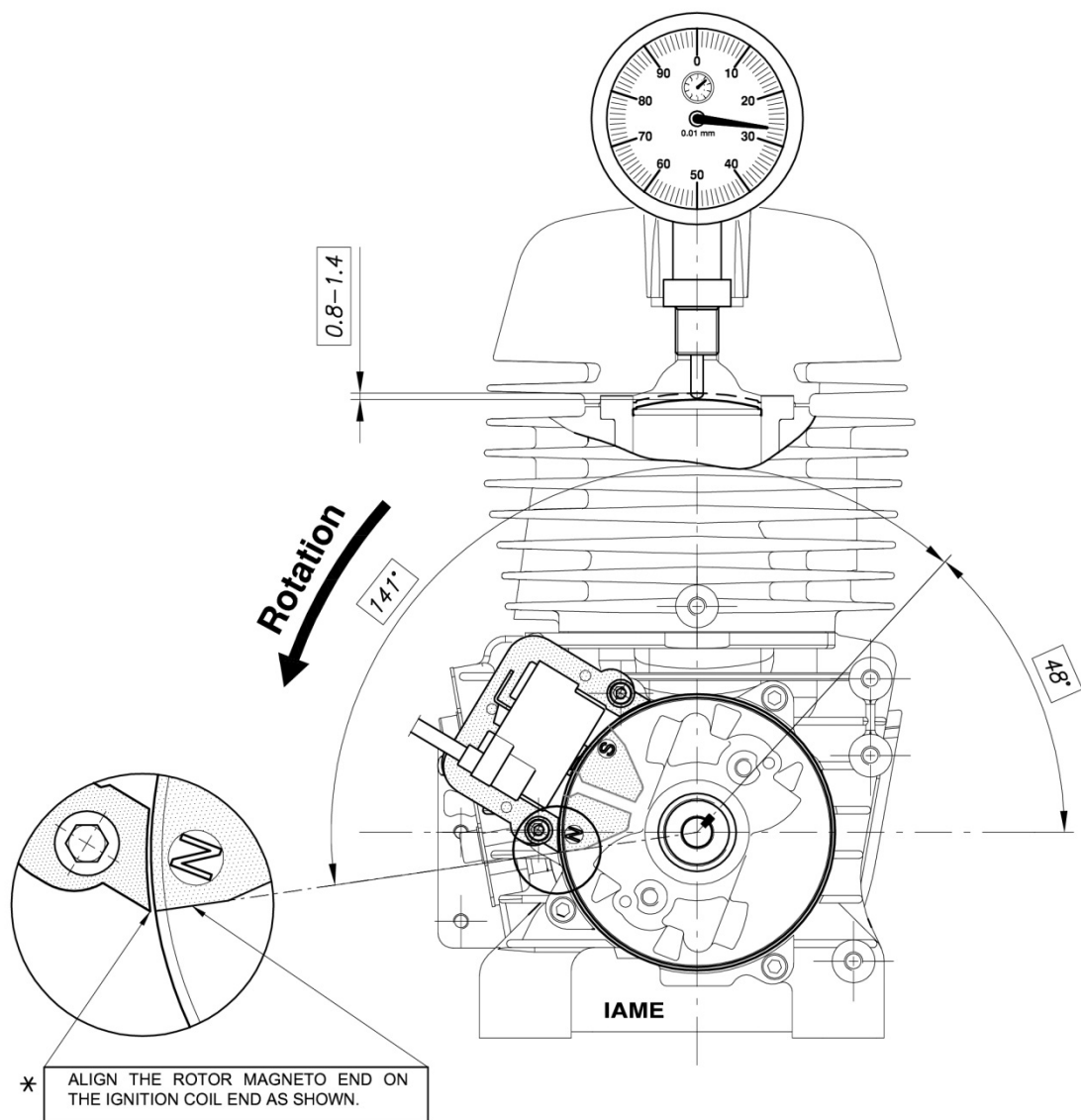
ROTOR TYPE 2



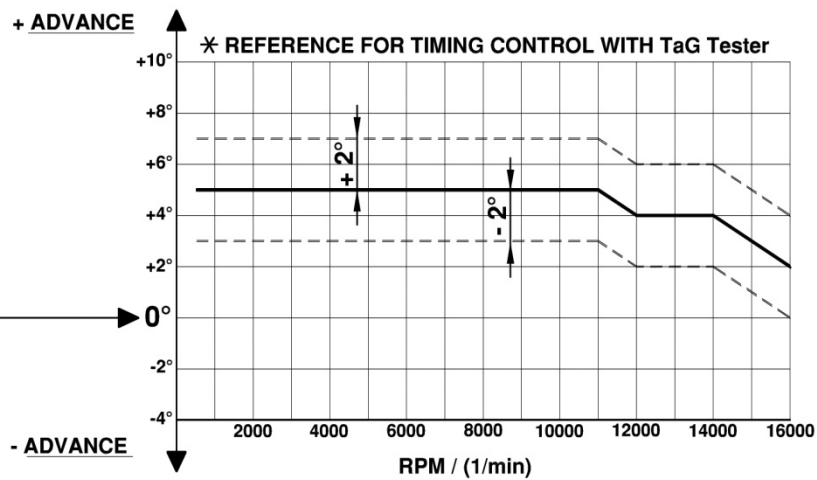
EXHAUST SYSTEM EXPLODED VIEW



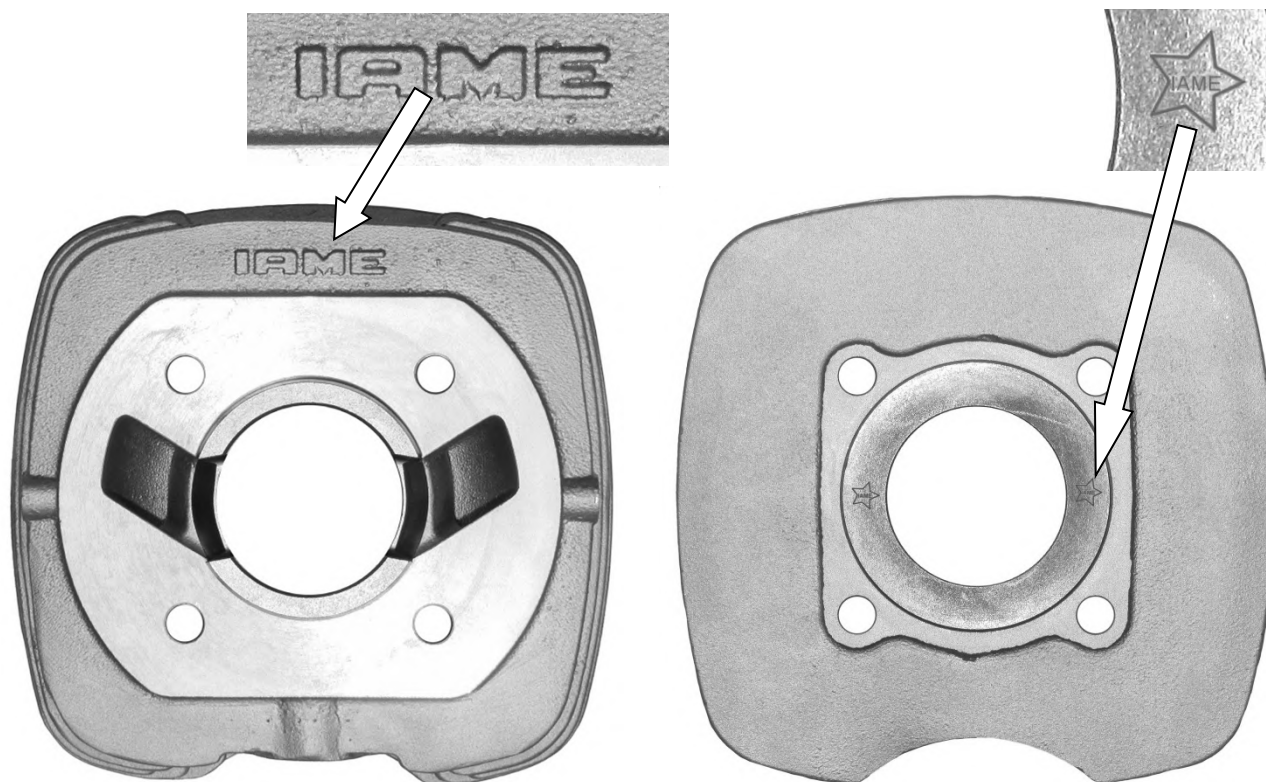
SCHEME FOR ADVANCE CONTROL



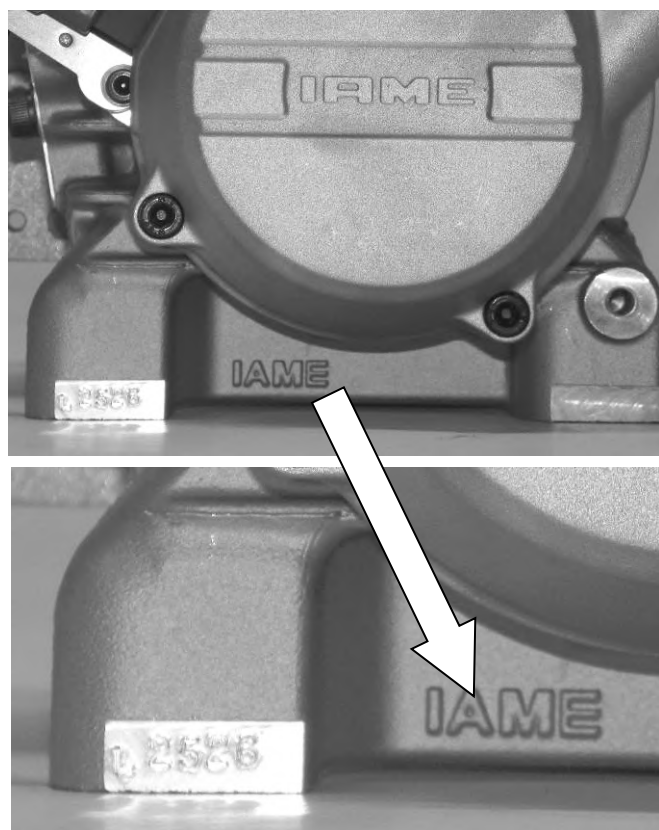
ADVANCE CURVE GRAPHS



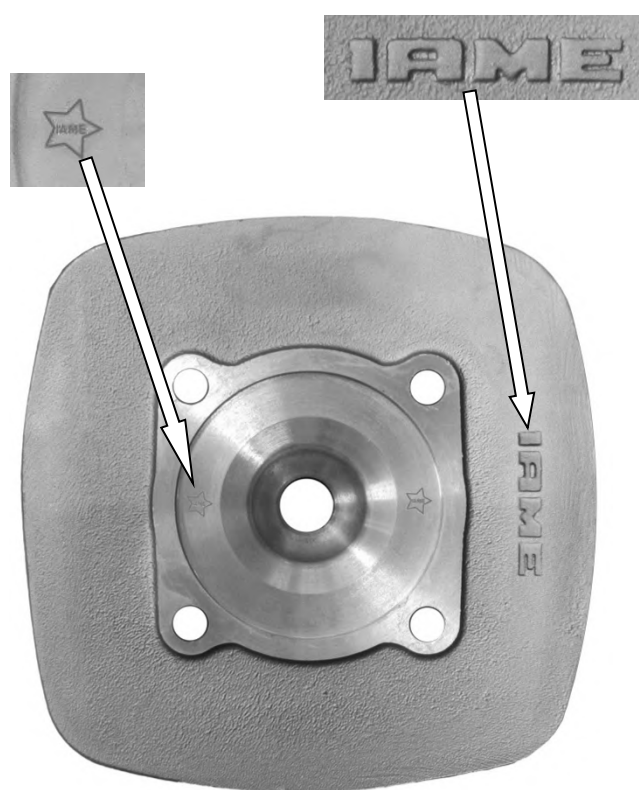
CYLINDER IDENTIFICATION MARKING

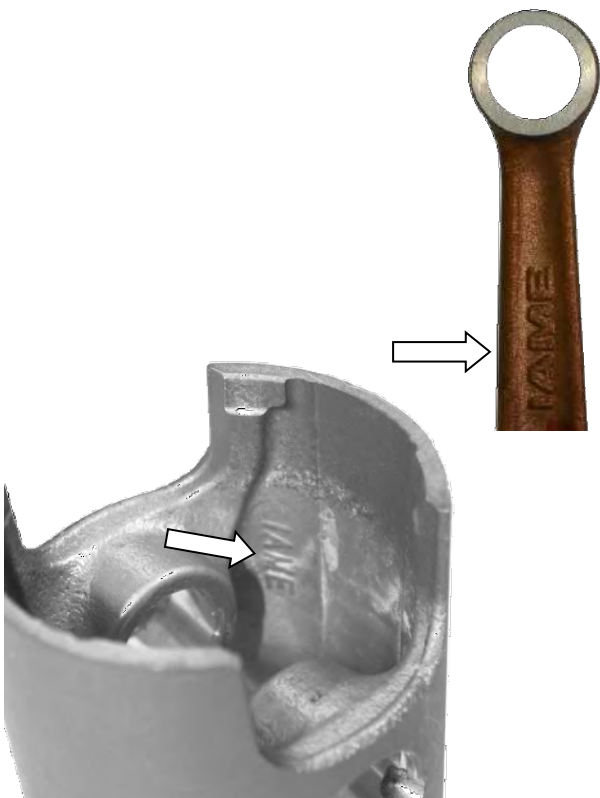
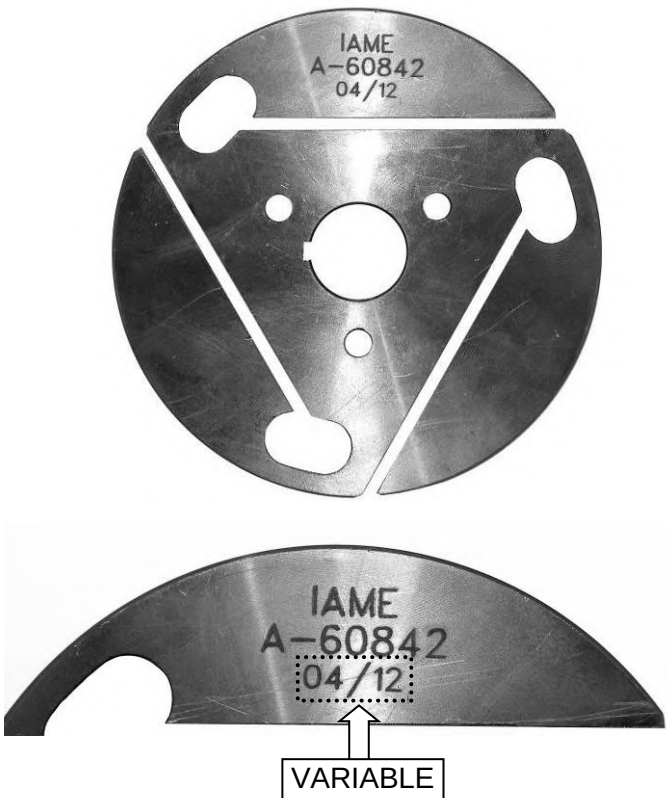
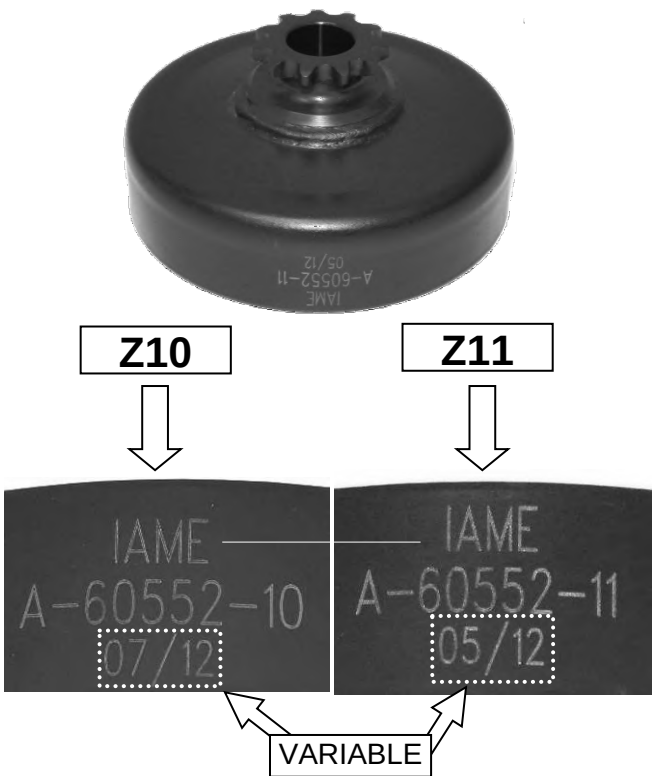


CRANKCASE IDENTIFICATION MARKING

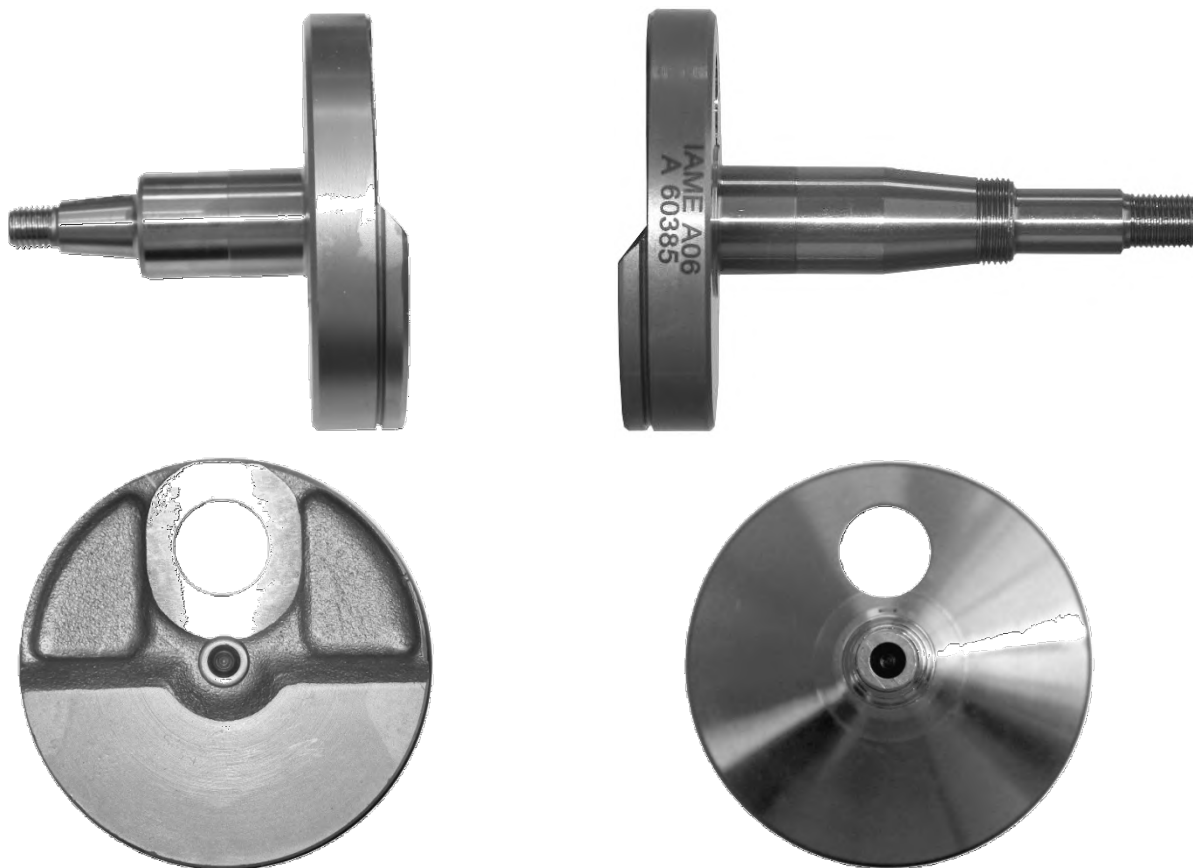


CYLINDER HEAD IDENTIFICATION MARKING



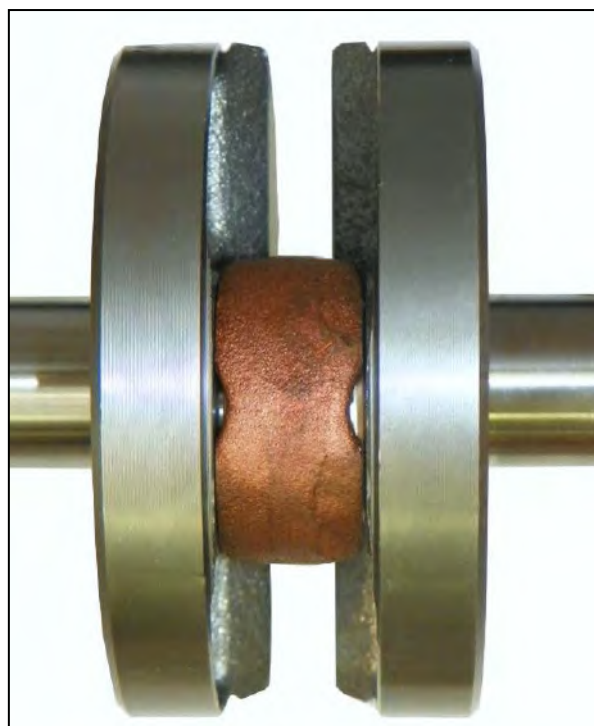
EXHAUST IDENTIFICATION MARKING	CONROD / PISTON IDENTIFICATION MARKINGS
 The image shows a black exhaust manifold. A white arrow points from a close-up of the 'IAME' marking on the top surface to the same marking on the side of the manifold.	 The image shows a piston and a connecting rod. A white arrow points from the 'IAME' marking on the piston skirt 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' date to a box labeled 'VARIABLE'.	 The image shows a clutch drum with the marking 'IAME A-60552-11 05/12'. Below the drum, two boxes labeled 'Z10' and 'Z11' have arrows pointing to two different views of the drum's marking. The 'Z10' view shows 'IAME A-60552-10 07/12' and the 'Z11' view shows 'IAME A-60552-11 05/12'. A white arrow points from the '07/12' date to a box labeled 'VARIABLE'.

CRANKSHAFT PHOTOS



CRANKSHAFT IDENTIFICATION MARKINGS

PARTICULAR OF COMPLETE CRANKSHAFT



ALTERNATIVE CLUTCH DRUM



Z9



Z10



Z11



VARIABLE

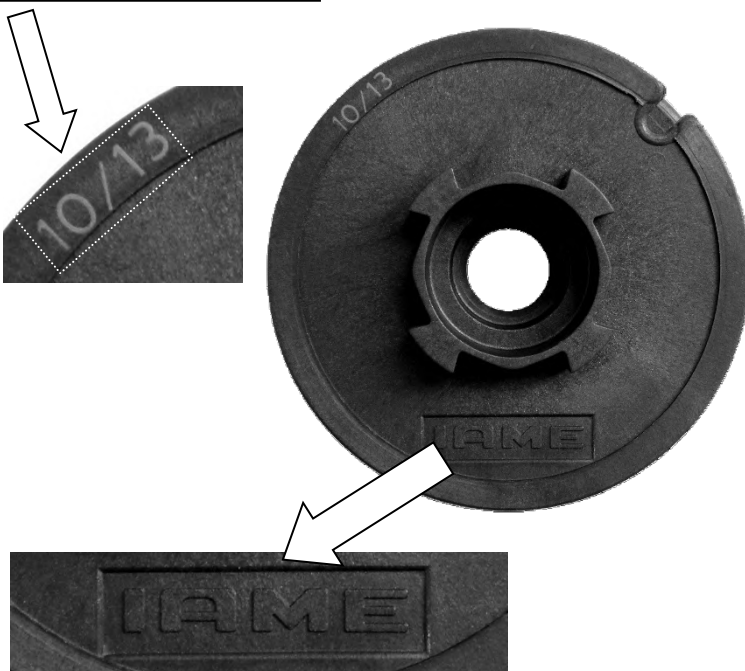
ALTERNATIVE CLUTCH COVER



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 side. 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 complex, angular shape. The IAME logo is embossed on the upper left side. 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 face. 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

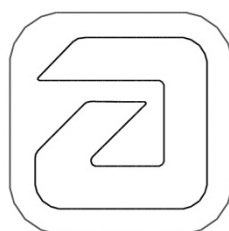
NOW COULD BE MARKED WITH NEW LOGO "IAME"

IAME

or

IAME

or





CARBURETTOR Tillotson HS-325A



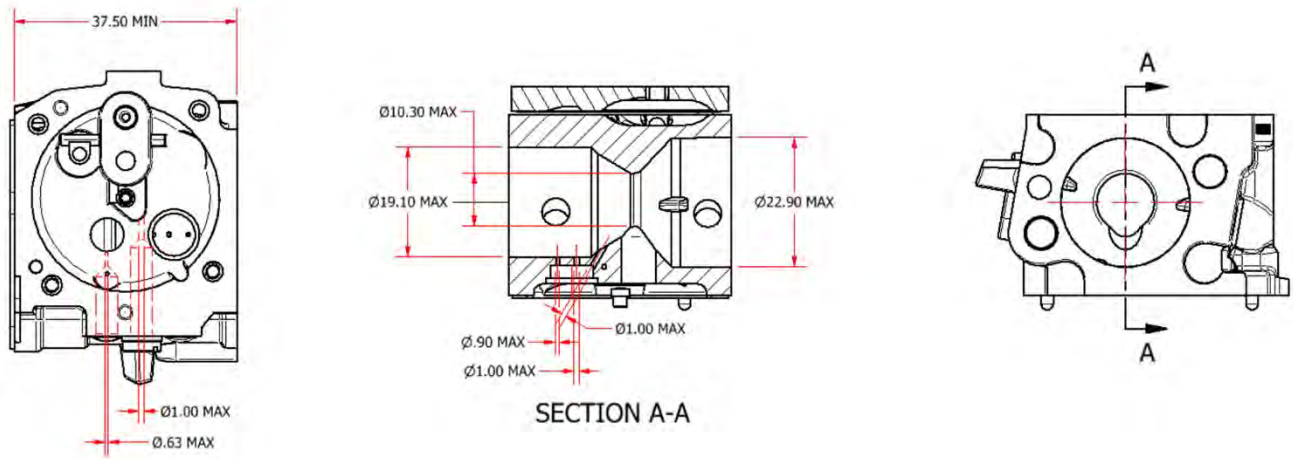
PHOTO OF ADJUSTING SIDE



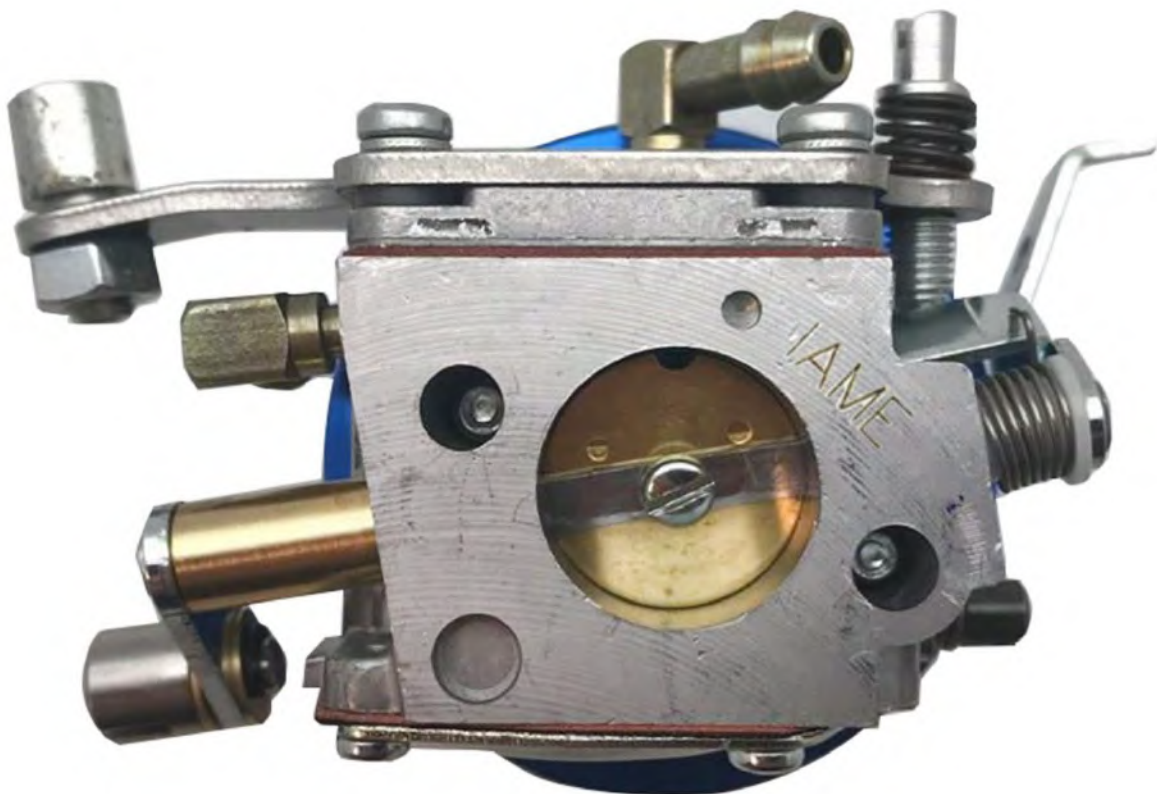
PHOTO OF INLET SIDE

Manufacteur	TILLOTSON LTD.
Make	TILLOTSON
Model	HS-325A

SECTION VIEW



"IAME" MARKING



HS-325A EXPLODED VIEW



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

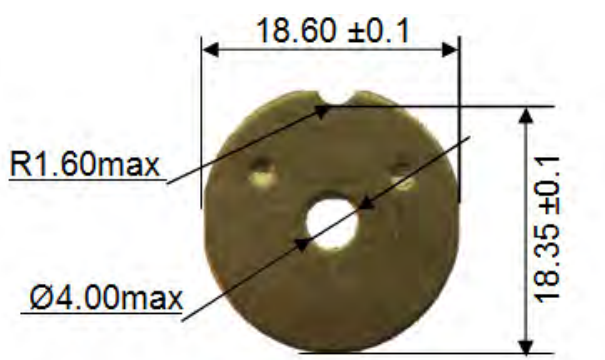
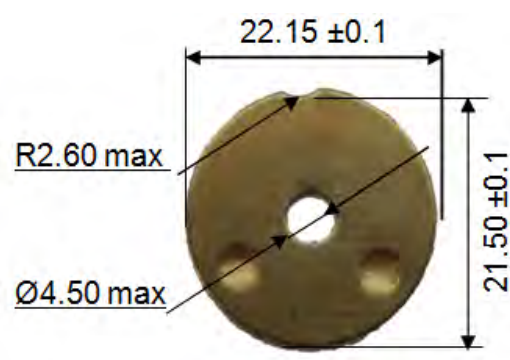
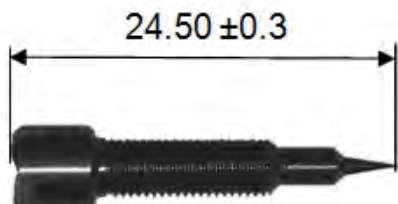
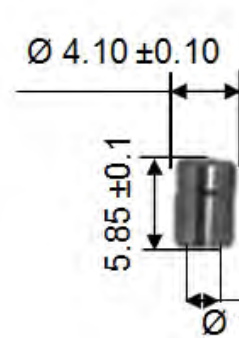


Thickness = 3.10 ± 0.15 mm

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 