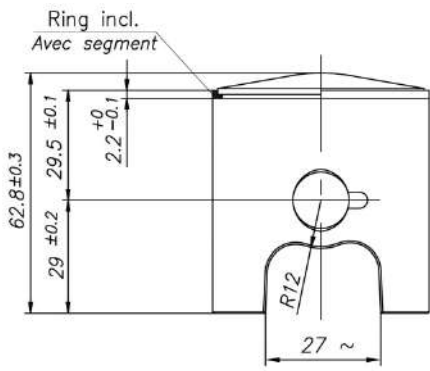
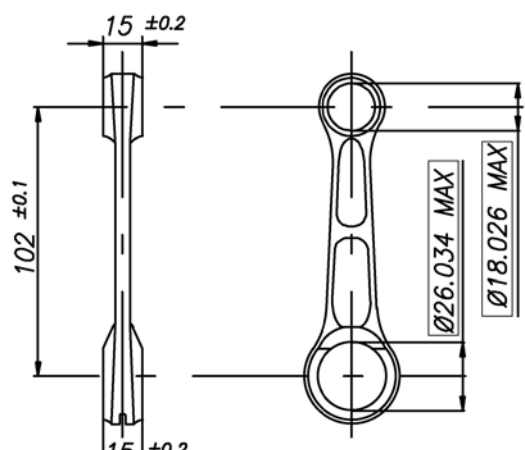
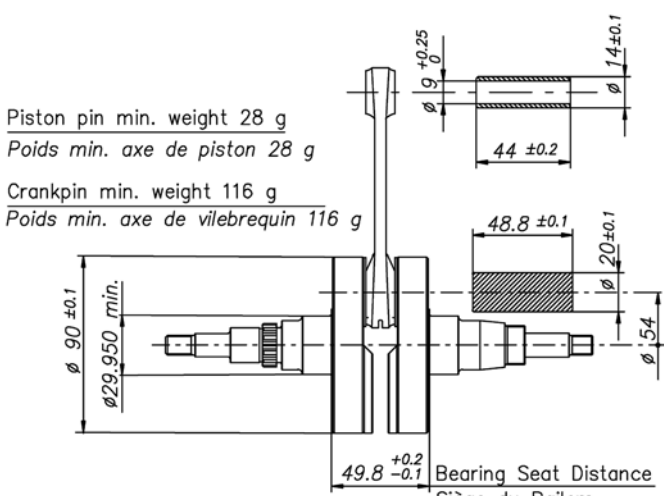
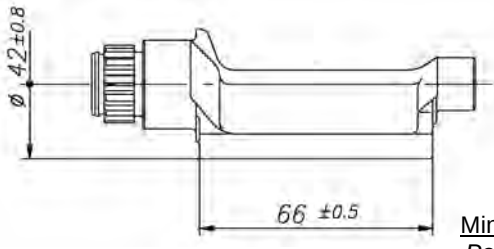
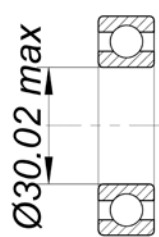
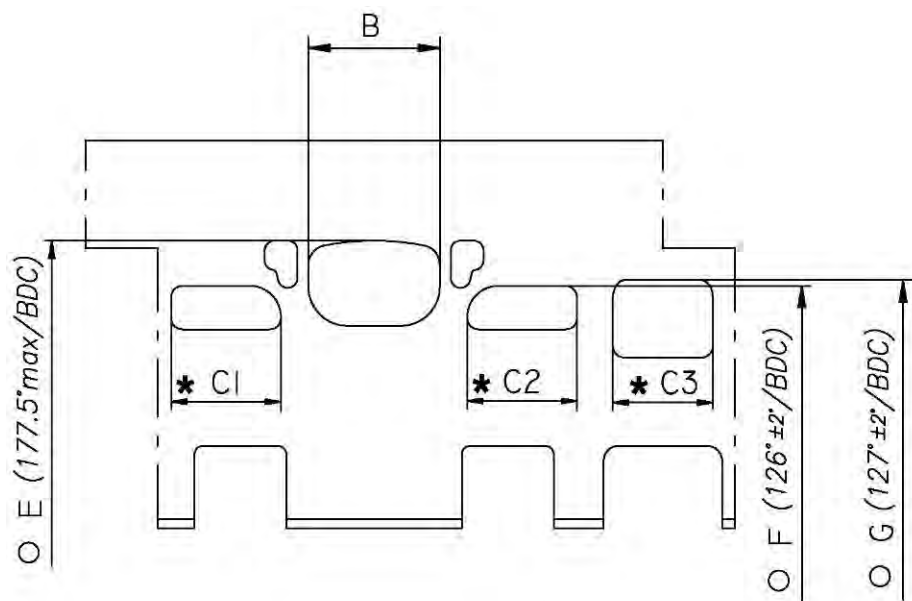


X30 125cc RL-C TAG

		FEATURES - CARACTERISTIQUES	
		Cylinder volume <i>Volume du cylindre</i>	123.67 cm ³
		Bore <i>Alésage</i>	54 mm
		Max. theoretical bore <i>Alésage théorique max.</i>	54.28 mm
		Stroke <i>Course</i>	54 mm
		Cooling system <i>Système de refroidissement</i>	Water <i>À Eau</i>
		Inlet system <i>Système d' admission</i>	Reed valve <i>À clapets</i>
		Cylinder / crankcase transfers n° <i>N° de canaux cylindre / carter</i>	3 / 3
Carburetor Tillotson <i>Carburateur Tillotson</i>	HW-27A (Ø27 Venturi)	Inlet / exhaust ports number <i>N° lumières admiss. / échapp.</i>	3 / 3
Number of piston rings <i>Nombre de segments</i>	1	Combustion chamber shape <i>Forme chambre de combustion</i>	Spherical <i>Sphérique</i>
Big end conr. ball-bearing diam. <i>Diamètre palier tête de bielle</i>	20x26x15	Selettra or PVL ignition <i>Allumage Selettra ou PVL</i>	Digital
Crankshaft ball-bearing diam. <i>Diamètre palier du vilebrequin</i>	30x62x16	Distance between conrod centers <i>Longueur (entre axe) de la bielle</i>	102 mm
Small end conr. ball-bearing diam. <i>Diamètre palier pied de bielle</i>	14x18x17.5	RPM limiter <i>Limiteur de régime</i>	Yes <i>Oui</i>
Balancing shaft <i>Arbre d' equilibrage de vilebr.</i>	Yes <i>Oui</i>	Electric starter <i>Démarrreur électrique</i>	Yes <i>Oui</i>

DESCRIPTION OF THE MATERIAL DESCRIPTION DES MATERIAUX		PISTON
Conrod material <i>Matériel de la bielle</i>	Steel <i>Acier</i>	 Piston min. weight (ring incl.) 128 g Poids min. piston (avec segment) 128g
Crankshaft material <i>Matériel du vilebrequin</i>	Steel <i>Acier</i>	
Balancing shaft material <i>Matériel de l' arbre d' équilibrage</i>	Steel <i>Acier</i>	
Gears material <i>Matériel des engrenages</i>	Steel <i>Acier</i>	
Starter ring material <i>Matériel de la couronne démarr.</i>	Steel <i>Acier</i>	
Head material <i>Matériel de la culasse</i>	Aluminium	
Cylinder material <i>Matériel du cylindre</i>	Aluminium	DISTANCE BETWEEN CONROD CENTERS ENTRE AXE DE LA BIELLE
Liner material <i>Matériel de la chemise</i>	Iron <i>Fonte</i>	
Crankcase material <i>Matériel du carter</i>	Aluminium	 Min. weight 110 g
Piston material <i>Matériel du piston</i>	Aluminium	
Piston rings material <i>Matériel des segments</i>	Iron <i>Fonte</i>	
Exhaust muffler material <i>Matériel du pot d' échappement</i>	Sheet-steel <i>Tôle acier</i>	
Ball-bearings <i>Roulements</i>	6206 type	
CRANKSHAFT - VILEBREQUIN		BALANCING SHAFT ARBRE D' EQUILIBRAGE
 Piston pin min. weight 28 g Poids min. axe de piston 28 g Crankpin min. weight 116 g Poids min. axe de vilebrequin 116 g Complete crankshaft min. weight 2150 g Poids min. du vilebrequin complet 2150 g		 Min. weight 315 g Poids Min. 315 g
		CRANKSHAFT BEARINGS PAILERS DU VILEBREQUIN
		 Ø30.02 max

CYLINDER DEVELOPMENT - DEVELOPPEMENT DU CYLINDRE

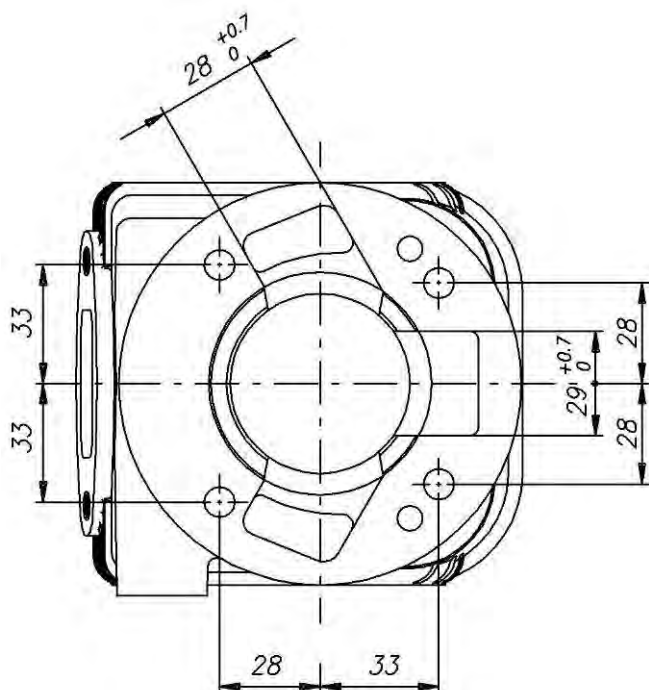


B	$\leq 36.5 \text{ mm}$
C1 = C2	$\leq 30 \text{ mm}$
C3	$\leq 28.5 \text{ mm}$
E	177.5° max
F	$126^\circ \pm 2^\circ$
G	$127^\circ \pm 2^\circ$

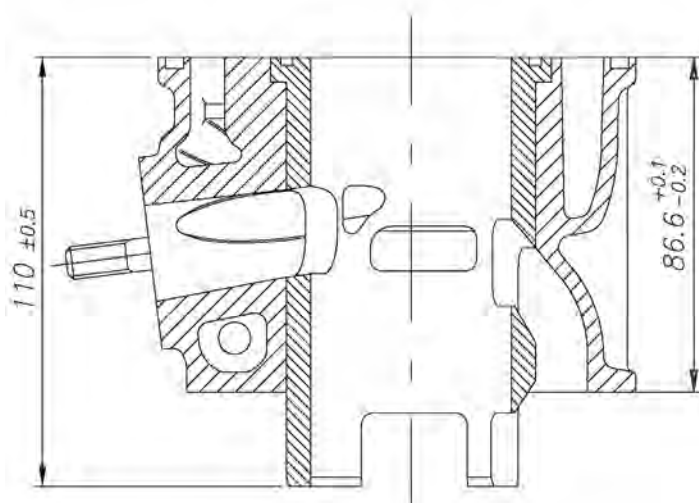
* **CHORDAL READING**
LECTURE CORDALE

○ **ANGULAR READING BY INSERTING A 0.2x5 mm GAUGE**
LECTURE ANGULAIRE PAR INSERTION D'UNE CALE DE 0.2x5 mm

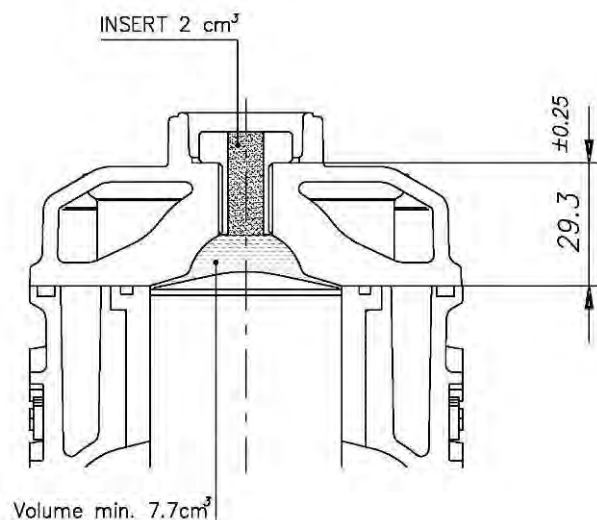
CYLINDER BASE VIEW VUE DE LA BASE DU CYLINDRE



CYLINDER CROSS SECTION VIEW VUE EN SECTION DU CYLINDRE



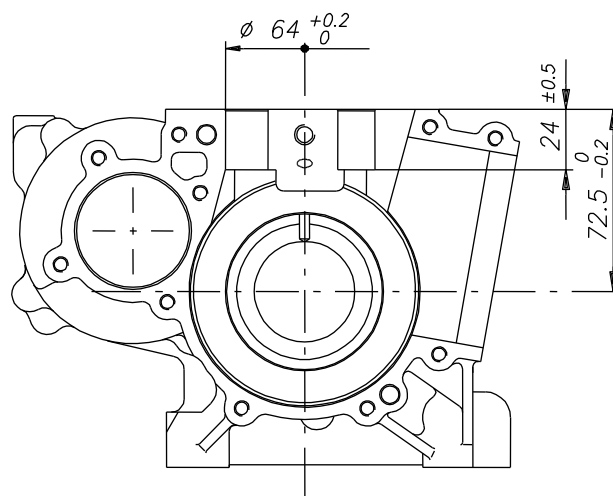
COMBUSTION CHAMBER VIEW
VUE DE LA CHAMBRE DE COMPRESSION



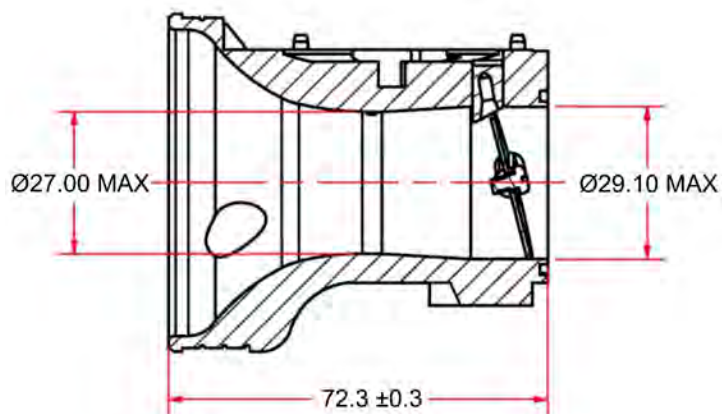
COMBUSTION CHAMBER VOLUME TOT. = 9.7 cm³ min.
VOLUME CHAMBRE COMBUSTION TOT. = 9.7 cm³ min.

ATT. : SQUISH MIN. = 0.90 mm
(measured with Ø1.5mm TIN - mesurée avec de l'étain Ø1.5mm)

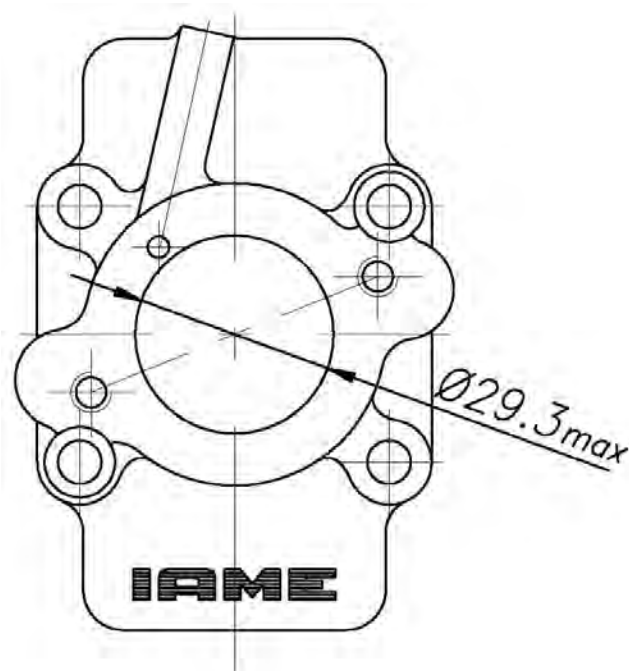
CRANKCASE INSIDE VIEW
VUE A' L' INTERIEUR DU CARTER



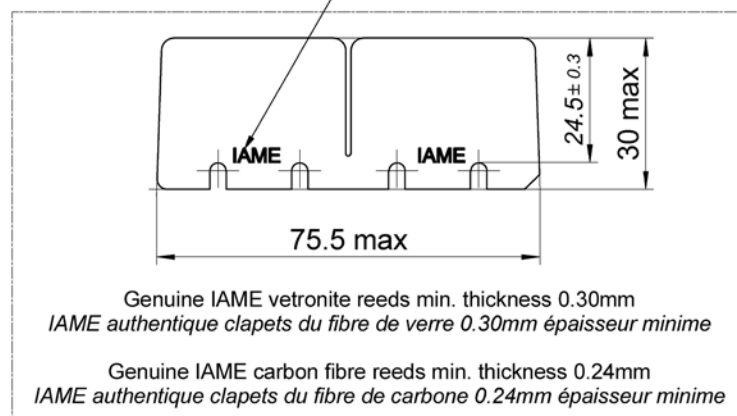
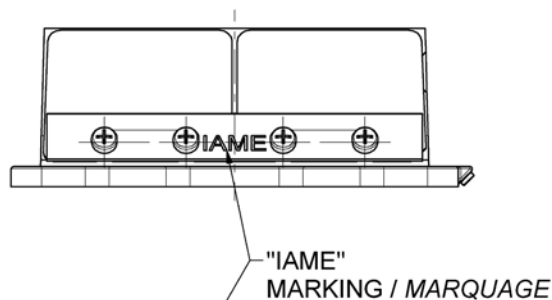
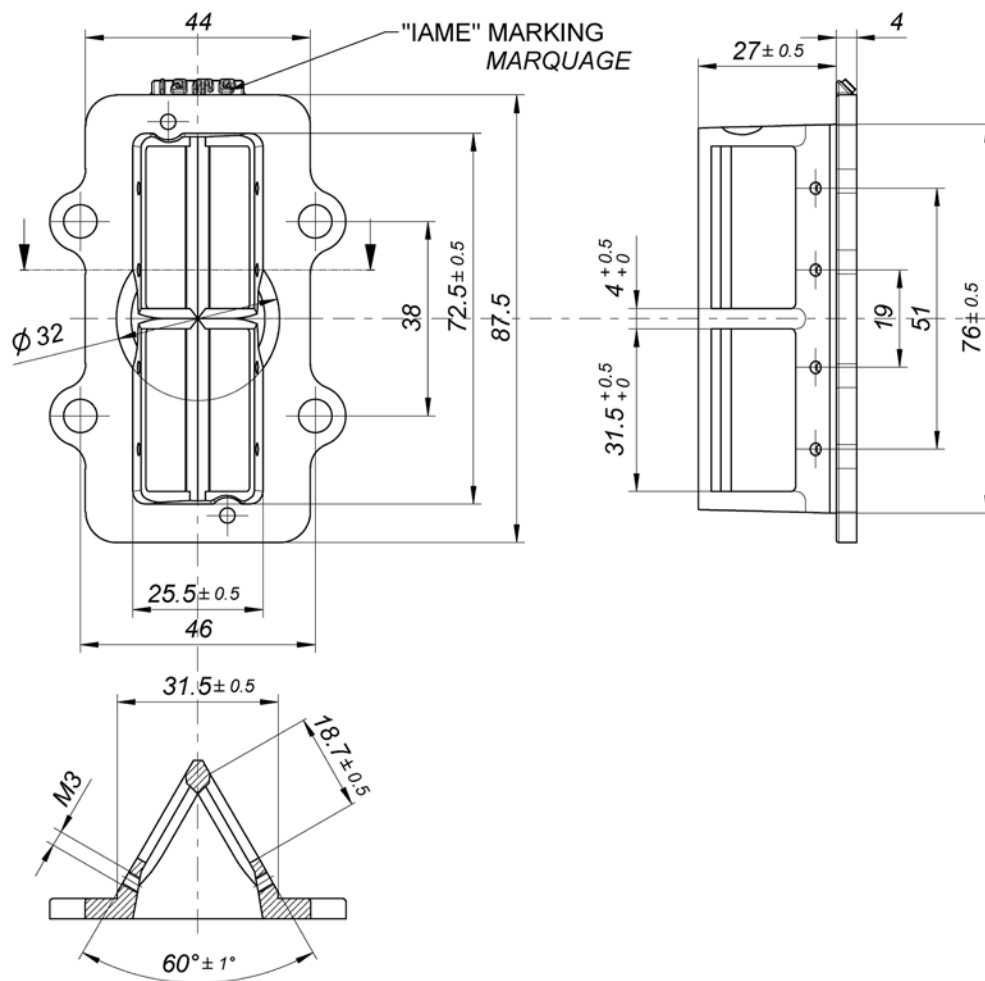
VENTURI CARB. DIMENSIONS
DIMENSIONS DU VENTURI DU CARBURATEUR



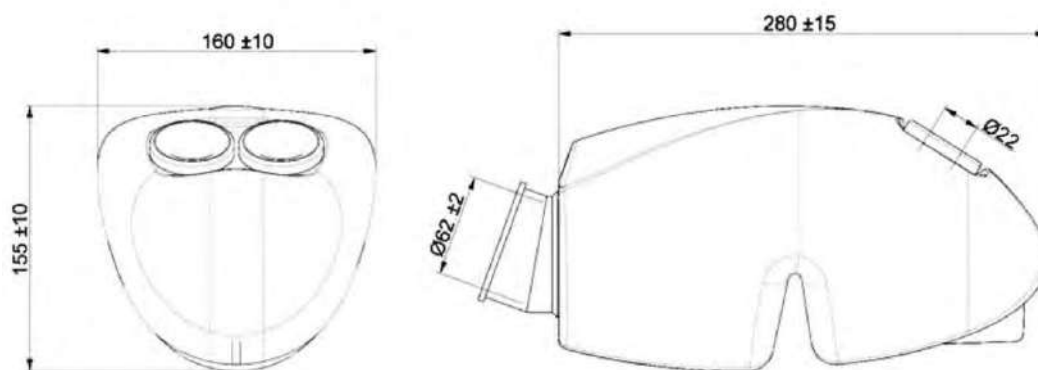
INLET CONVEYOR DIMENSIONS
CONVOYEUR D'ADMISSION



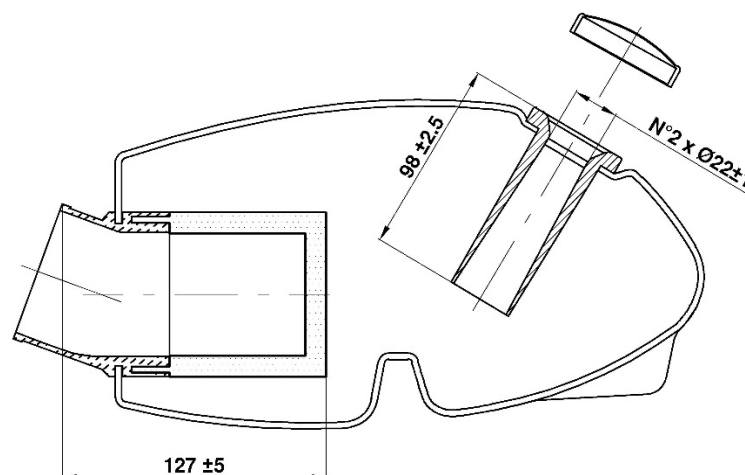
REED VALVE - DIMENSIONS AND MARKING BOÎTE À CLAPETS - DIMENSIONS AND MARQUAGE



INLET SILENCER – DRAWING
DESSIN DU SILENCIEUX D'ASPIRATION



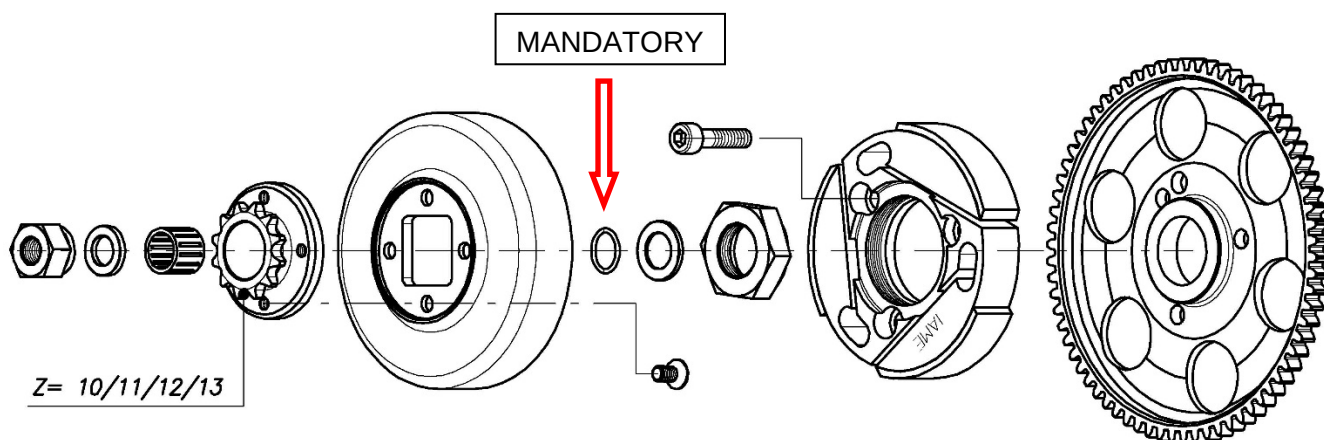
WITH SPONGE AIR FILTER
AVEC MANCHON COMPLETE DE FILTRE D'AIR



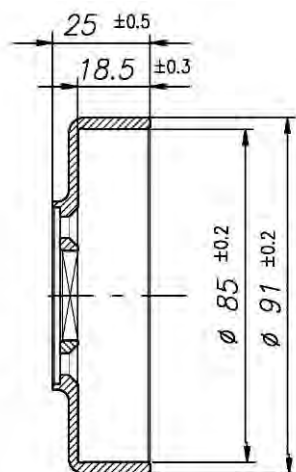
INLET SILENCER - PHOTO
PHOTO - SILENCIEUX D'ASPIRATION



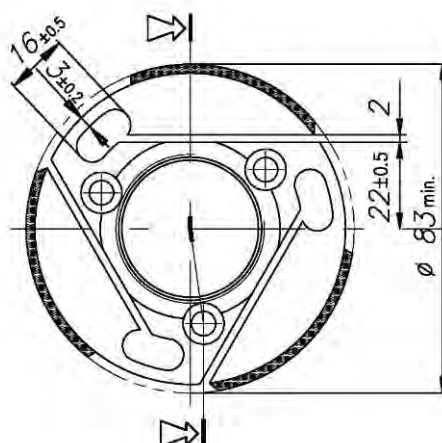
DESCRIPTION OF THE CLUTCH - DESCRIPTION DE L' EMBRAYAGE



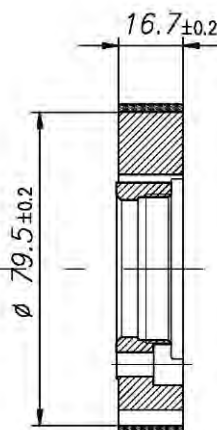
COMPONENTS THE CLUTCH – COMPOSANTS DE L' EMBRAYAGE



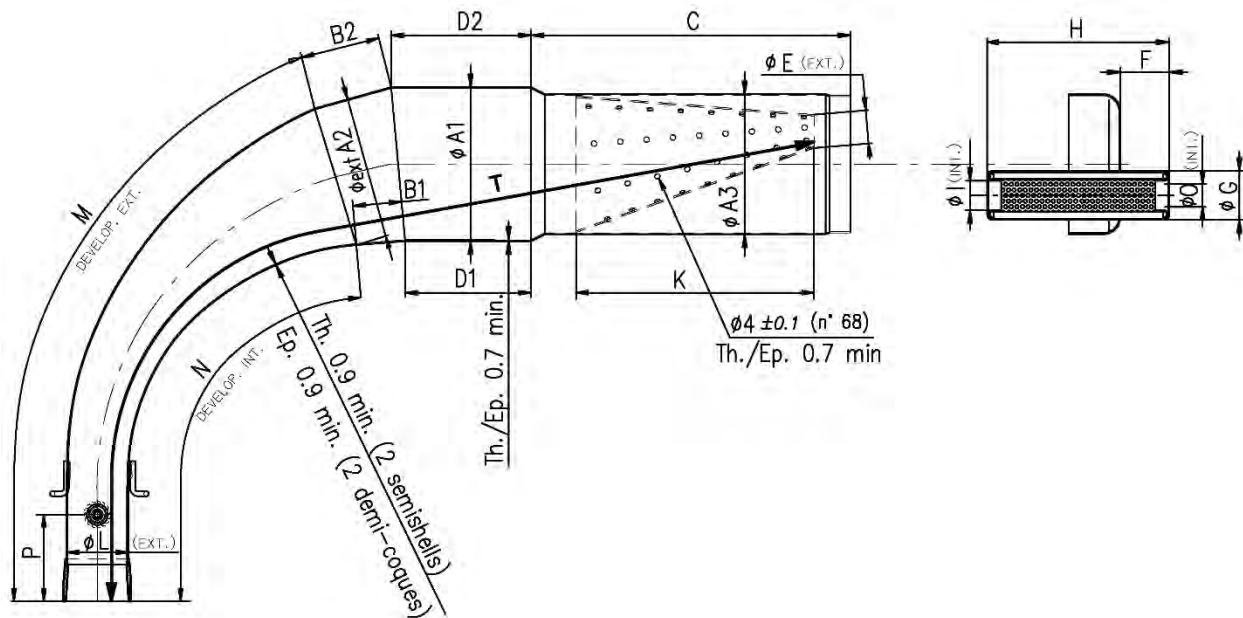
Min. weight 225 g
Poids min. 225g



Min. weight 375 g
Poids min. 375g



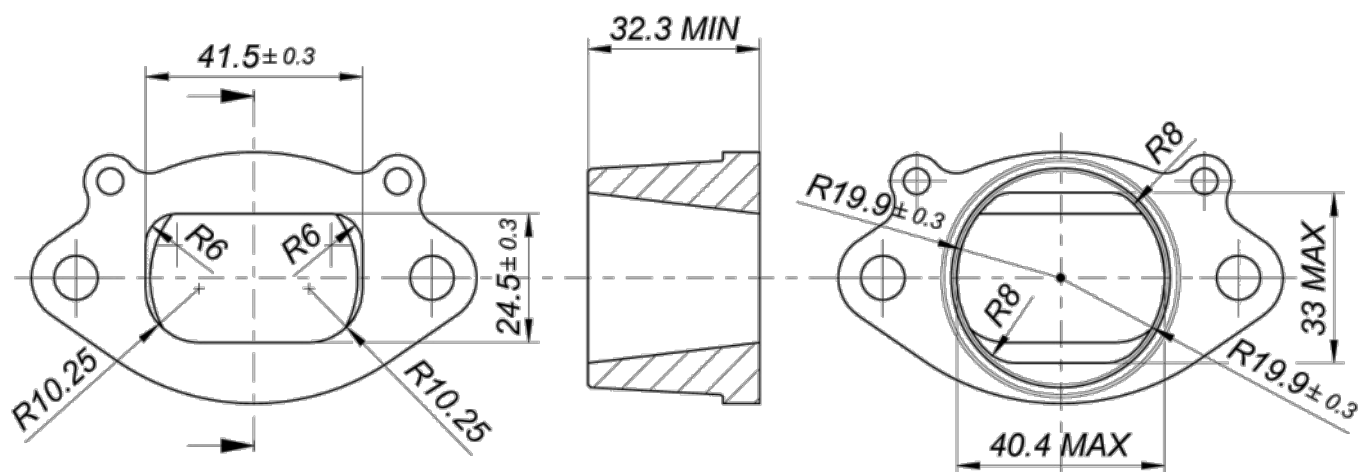
EXHAUST MUFFLER VIEW AND DIMENSIONS
VUE ET DIMENSIONS DU SILENCIEUX D'ÉCHAPPEMENT



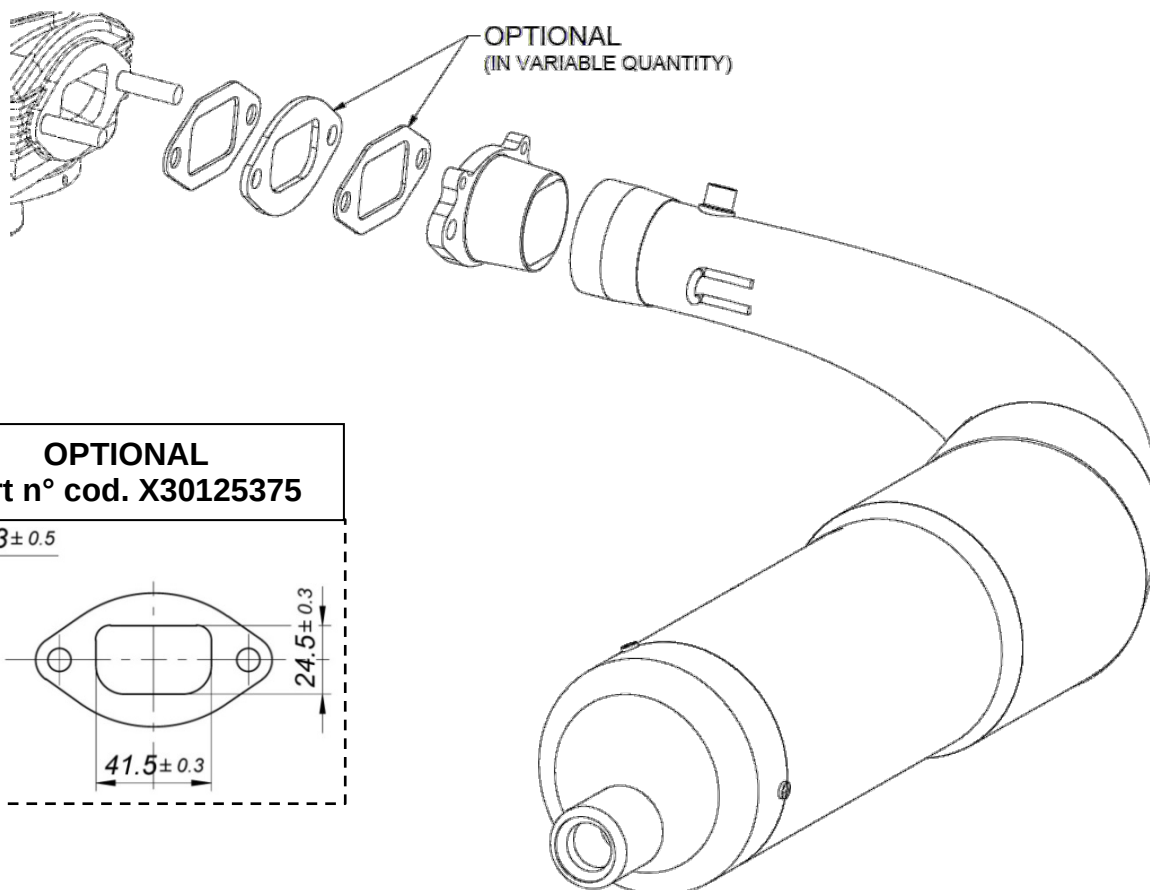
A1: <u>110 ±1.5</u>	B1: <u>59 ±3</u>	D1: <u>89.5 ±3</u>	F: <u>36 ±2</u>	I: <u>21 ±1</u>	M: <u>435 ±3</u>	P: <u>50 ±10</u>
A2: <u>102 ±1.5</u>	B2: <u>59 ±3</u>	D2: <u>109 ±3</u>	G: <u>35 ±1</u>	K: <u>170 ±3</u>	N: <u>340 ±3</u>	T: <u>690 ±5</u>
A3: <u>100 ±1.5</u>	C: <u>219 ±3</u>	E: <u>23 ±2</u>	H: <u>132 ±2</u>	L: <u>42.5 ±1.5</u>	O: <u>21 ±1</u>	

Min. Weight 1,78 kg
Poids min. 1,78 kg

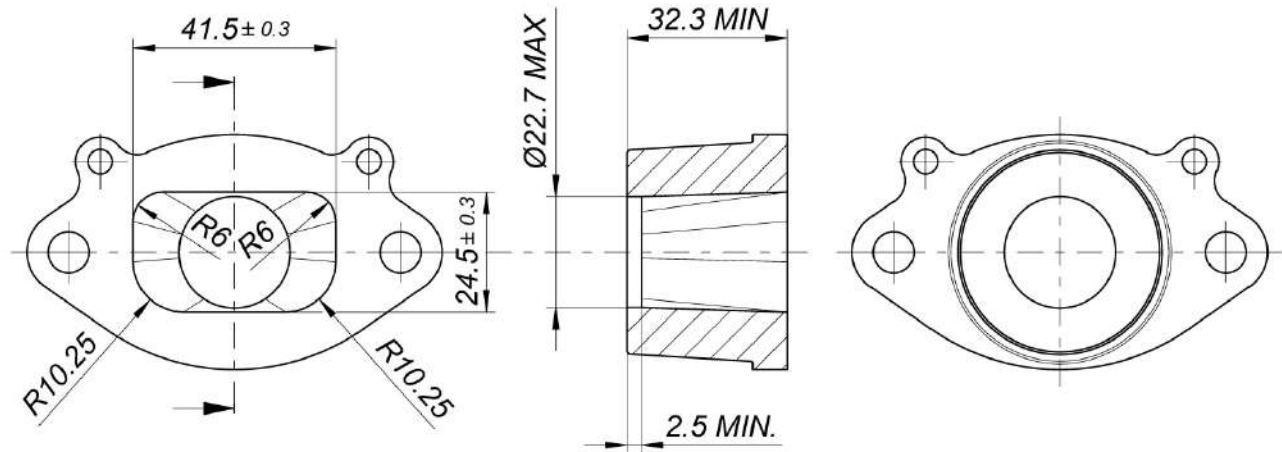
SENIOR EXHAUST FITTING
RACCORD D'ÉCHAPPEMENT SENIOR



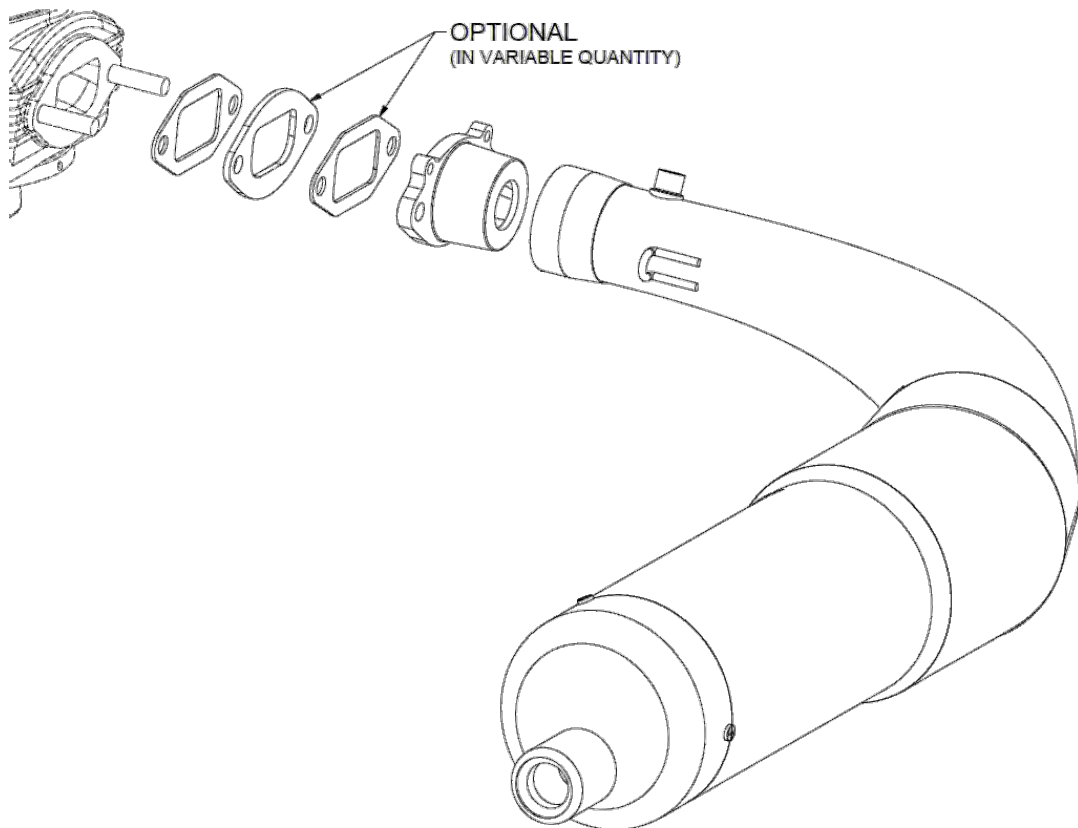
SENIOR MUFFLER INSTALLATION
INSTALLATION DU SILENCIEUX D'ÉCHAPPEMENT SENIOR



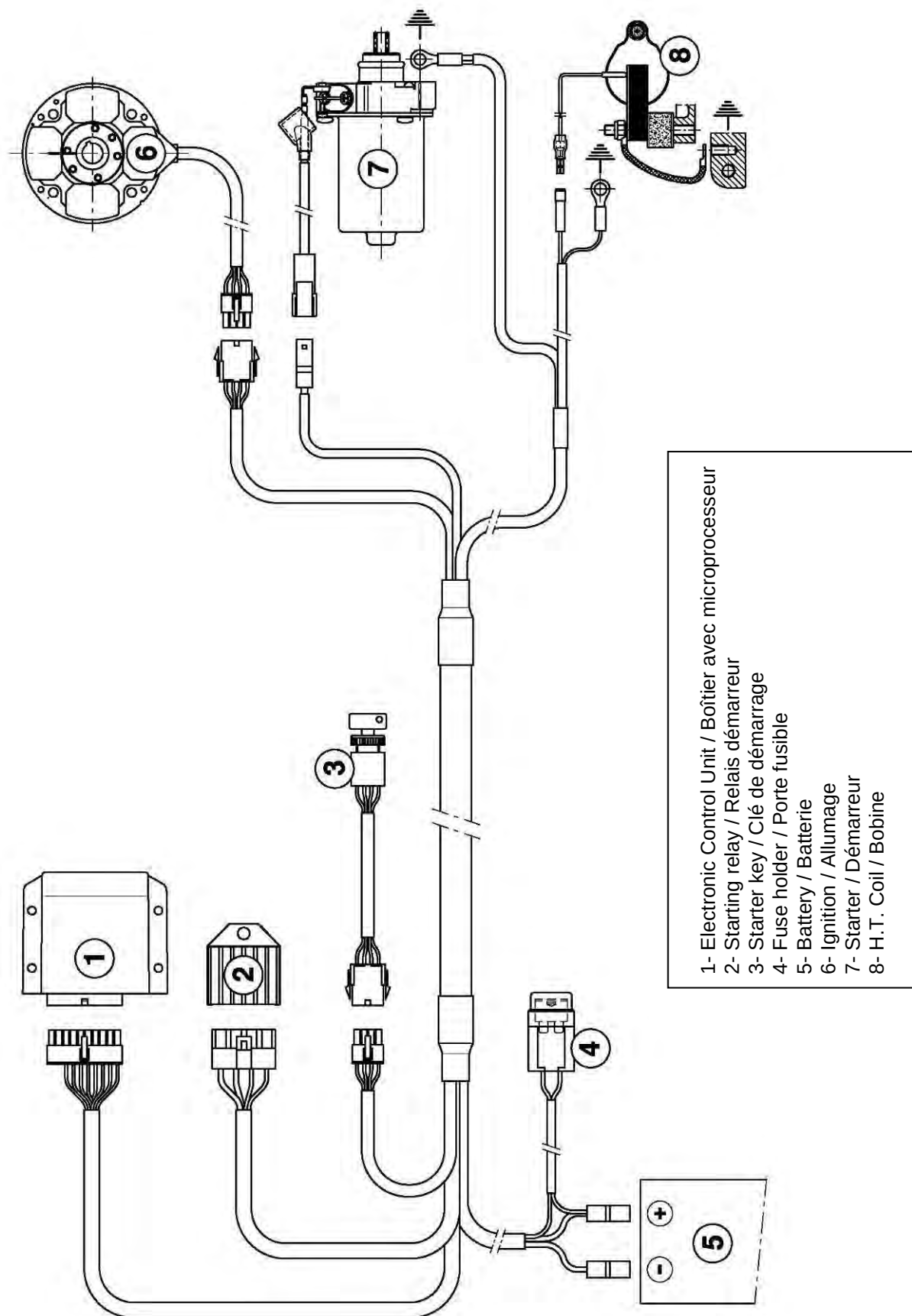
JUNIOR EXHAUST FITTING
RACCORD D'ÉCHAPPEMENT JUNIOR



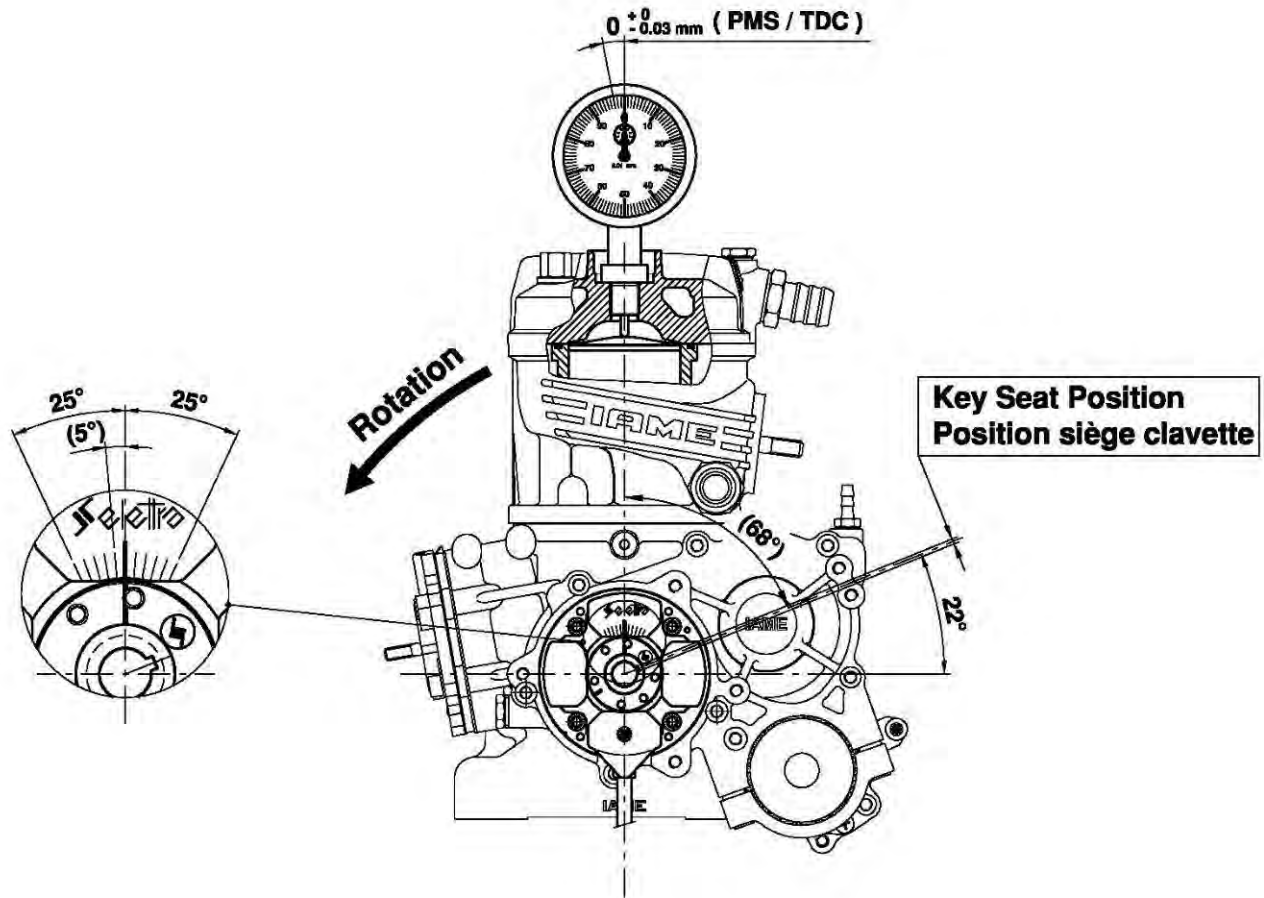
JUNIOR MUFFLER INSTALLATION
INSTALLATION DU SILENCIEUX D'ÉCHAPPEMENT JUNIOR



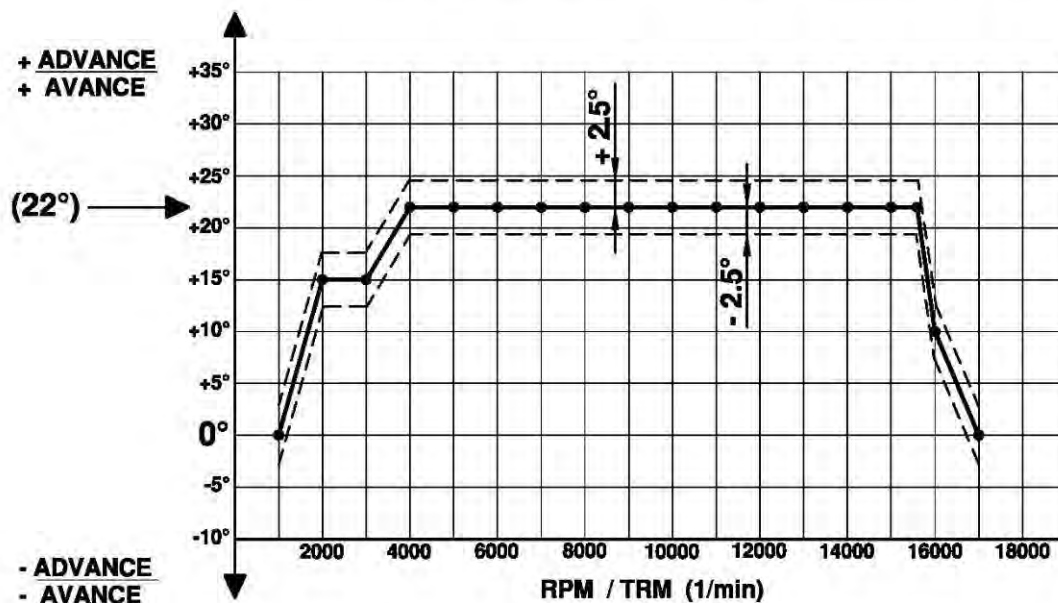
WIRING DIAGRAM (SELETTA DIGITAL "K" IGNITION)
SCHEMA CIRCUIT ELECTRIQUE (ALLUMAGE SELETTA DIGITAL "K")



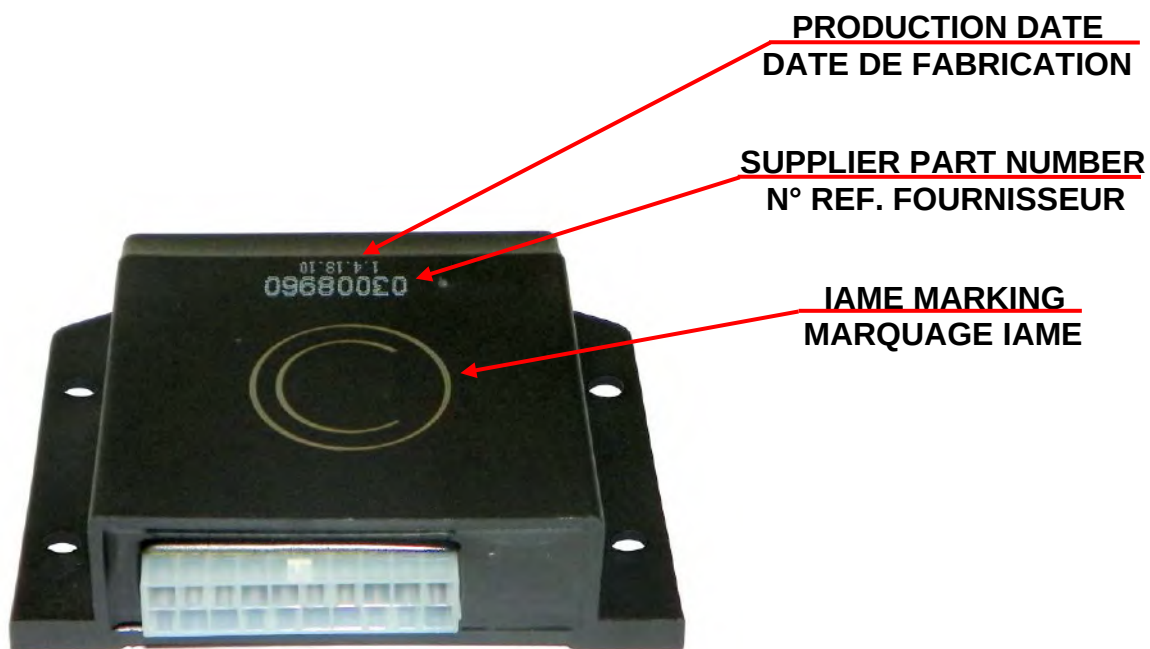
SCHEME FOR ADVANCE CONTROL SCHEMA DE CONTROLE POUR L'AVANCE



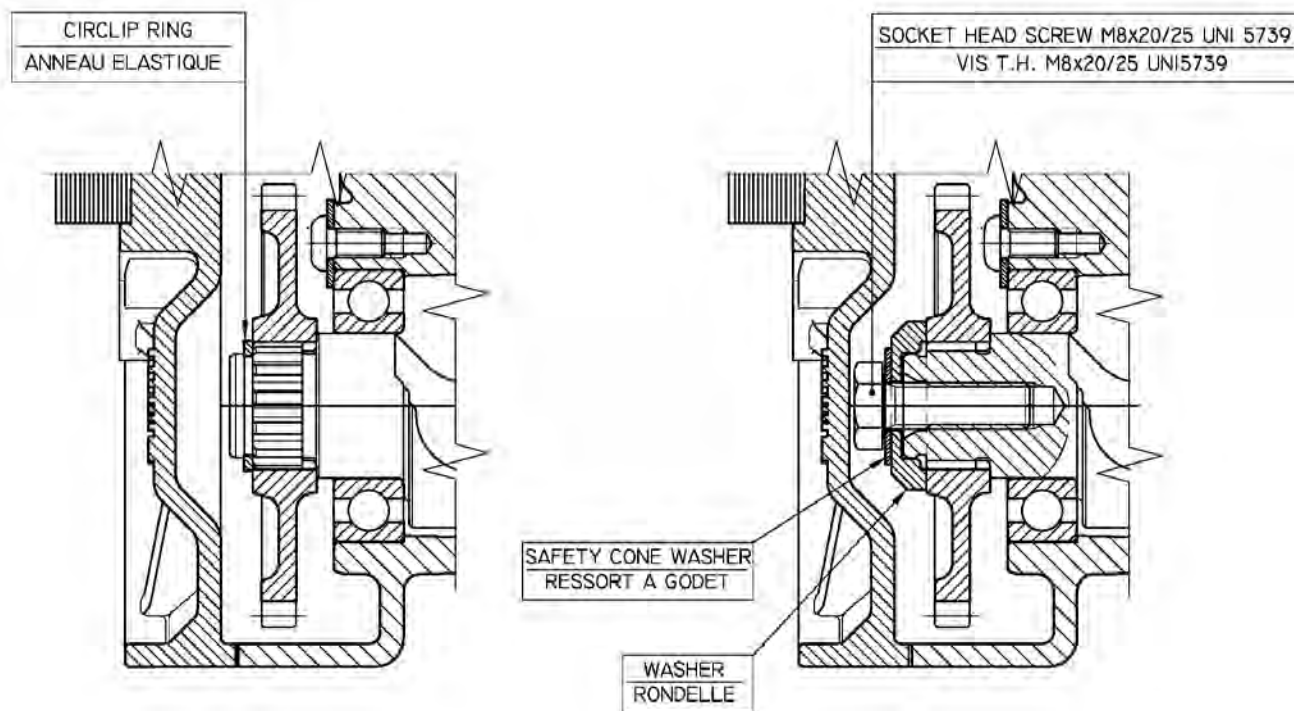
ADVANCE CURVE GRAPHS / GRAPHIQUES DE LA COURBE D'AVANCE



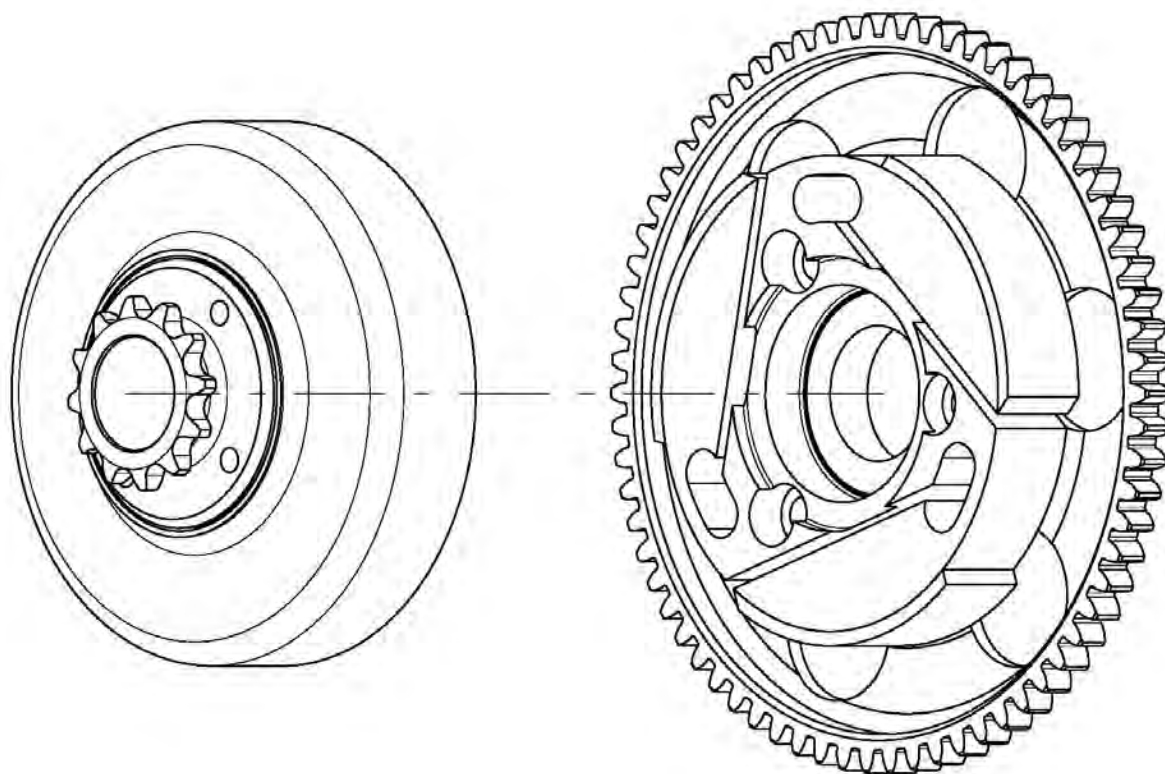
ELECTRONIC BOX MARKING MARQUAGE DU BOITIER ELECTRONIQUE



GEAR ALTERNATIVE FIXING FIXATION ALTERNATIVE DE L' ENGRANAGE



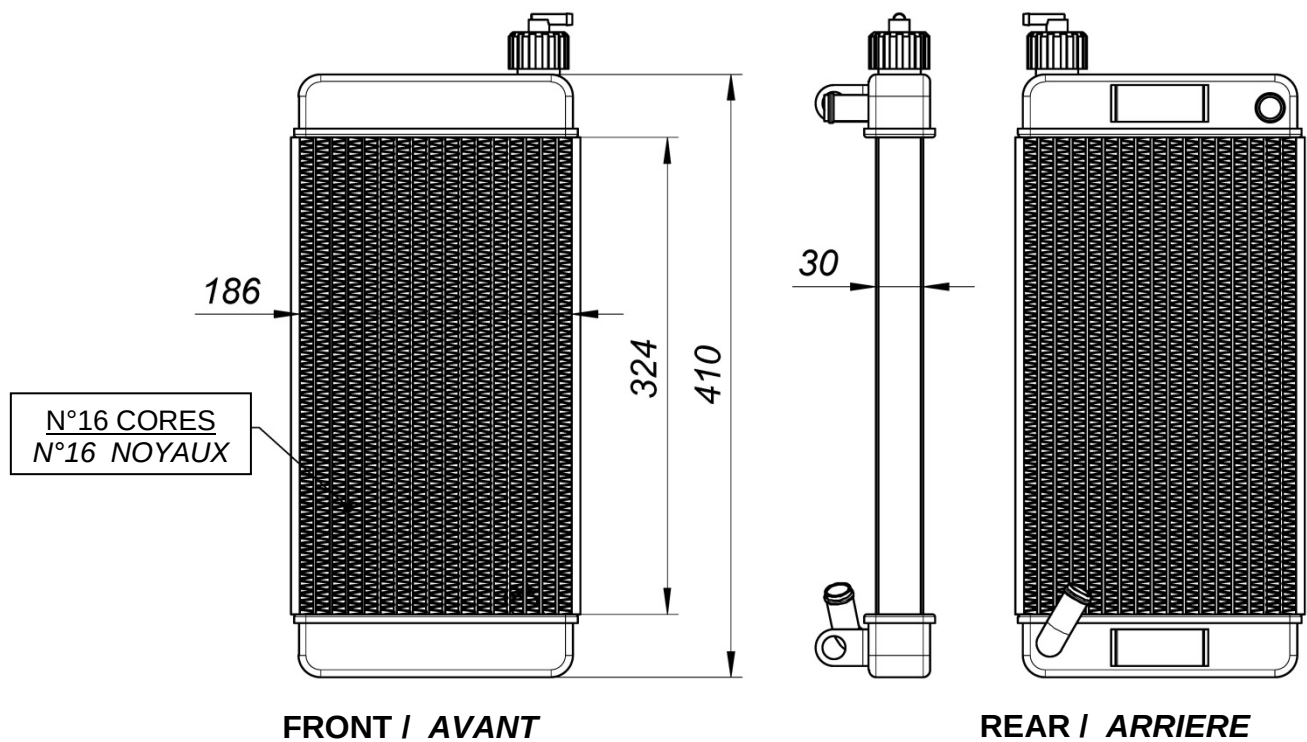
DESCRIPTION OF THE CLUTCH - *DESCRIPTION DE L' EMBRAYAGE*



Min. weight 300 g
Poids min. 300 g

Min. weight 680 g
Poids min. 680 g

RADIATOR DESCRIPTION AND SKETCH OF PARTS
DESCRIPTION DU RADIATEUR ET SCHEMA ILLUSTRANT LES ELEMENTS



PAINTED AND NOT PAINTED
 PEINT ET PAS PEINT

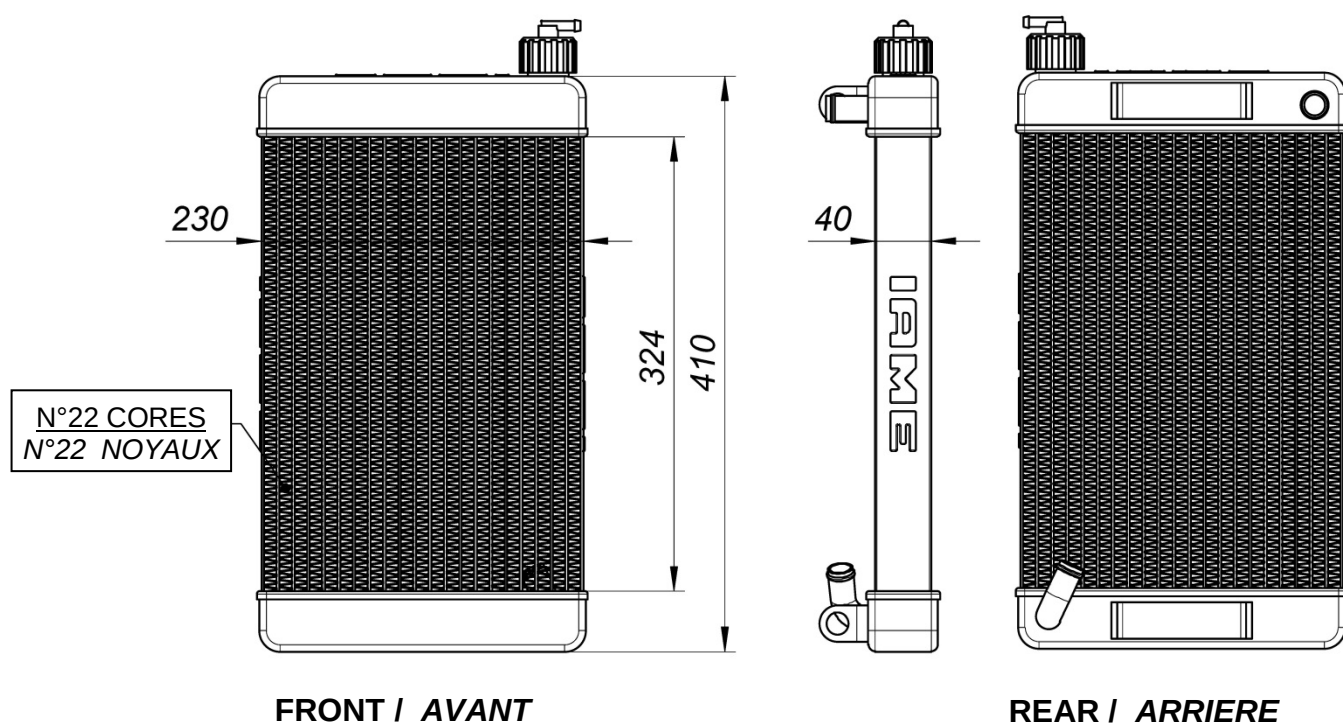


FRONT / AVANT

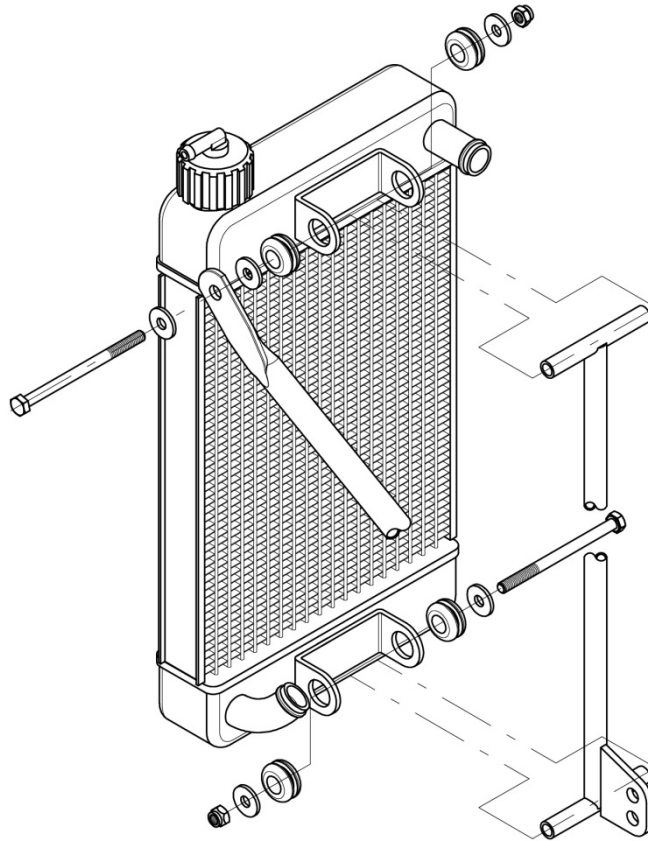
REAR / ARRIERE



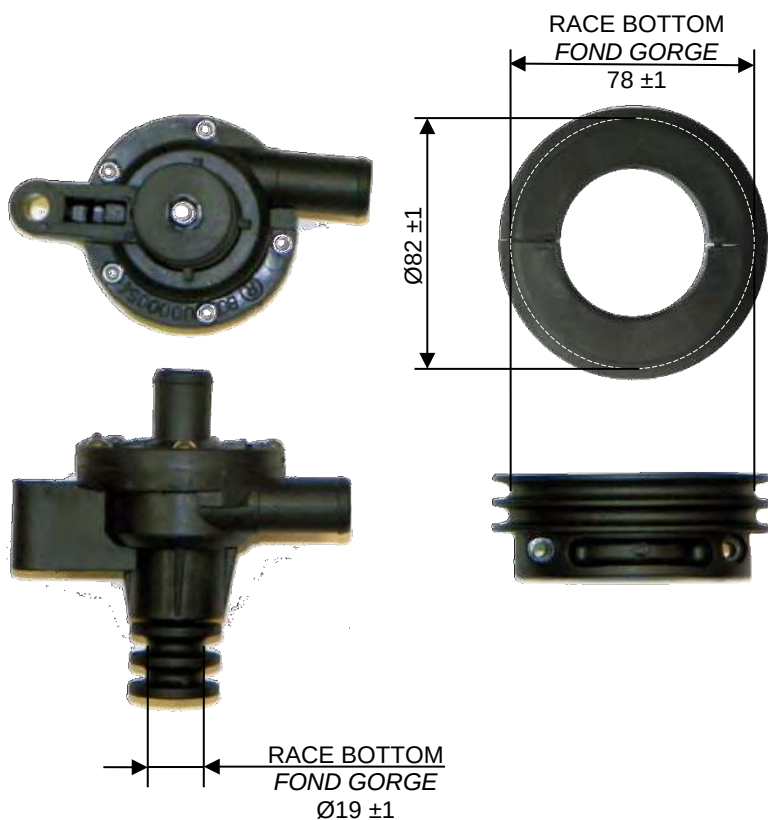
RADIATOR ALTERNATIVE DESCRIPTION AND SKETCH DESCRIPTION DU RADIATEUR ALTERNATIVE



RADIATOR AND ITS SUPPORTS RADIATEUR ET SES SUI TIEN



WATER PUMP GROUP GROUPE POMPE A' EAU



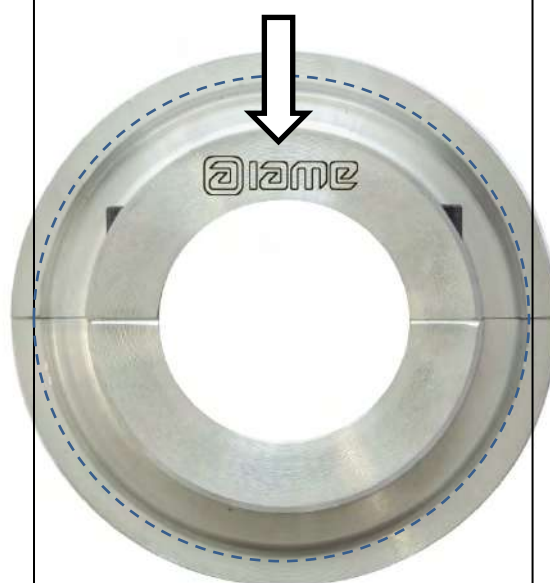
THERMOSTAT



ALTERNATIVE

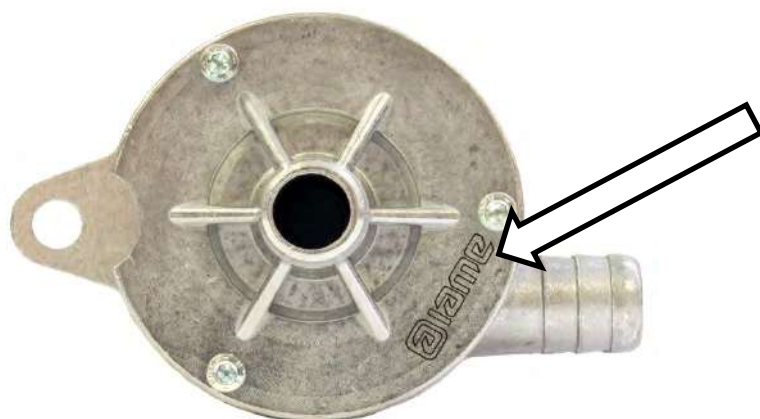


ALTERNATIVE WATER PUMP & PULLEY
ALTERNATIVE GROUPE POMPE A' EAU ET POULIE



RACE BOTTOM - FOND GORGE $\varnothing 82.5 \pm 1$

RACE BOTTOM - FOND GORGE
 $\varnothing 20 \pm 1$



PISTON IDENTIFICATION MARKING
MARQUAGE D'IDENTIFICATION PISTON

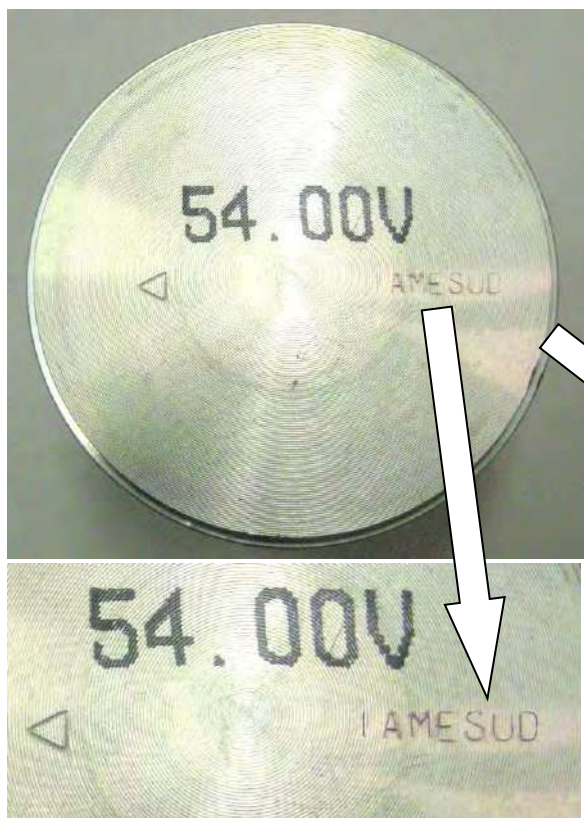
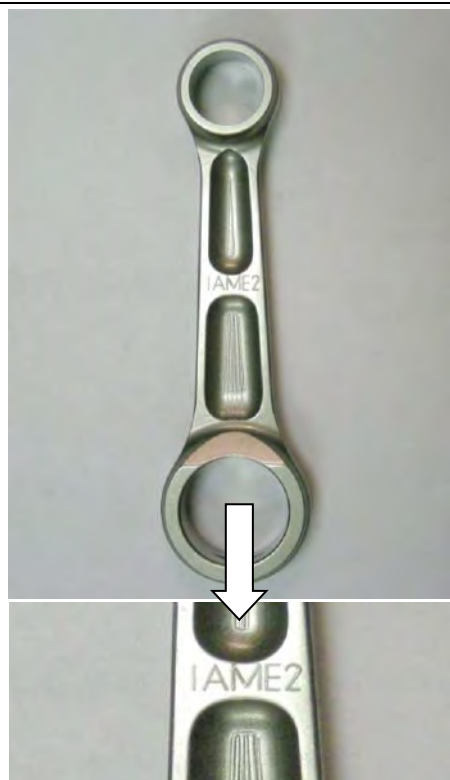
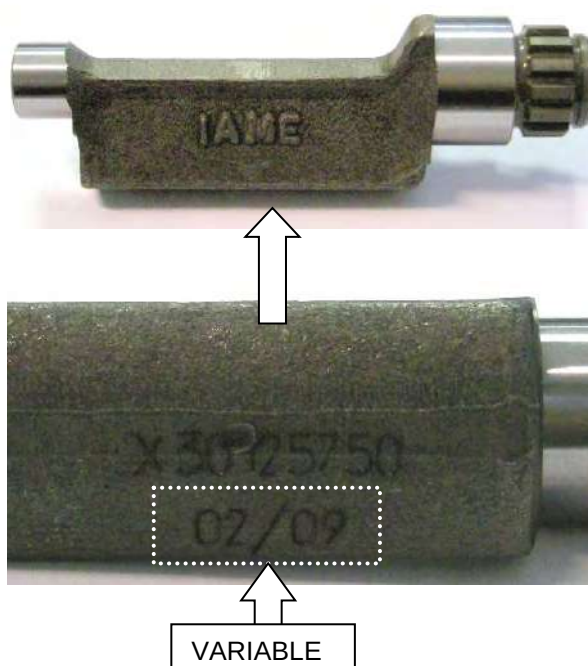


PHOTO IDENTIFICATION CONROD
MARQUAGE D'IDENTIFICATION BIELLE



IDENTIFICATION BALANCING SHAFT
MARKING
MARQUAGE D'IDENTIFICATION ARBRE
D'EQUILIBRAGE

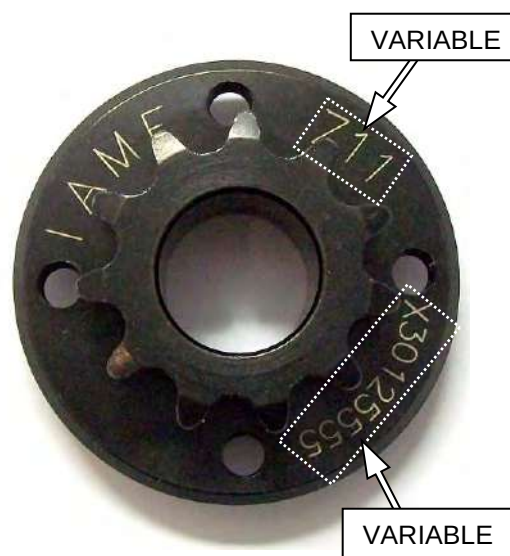
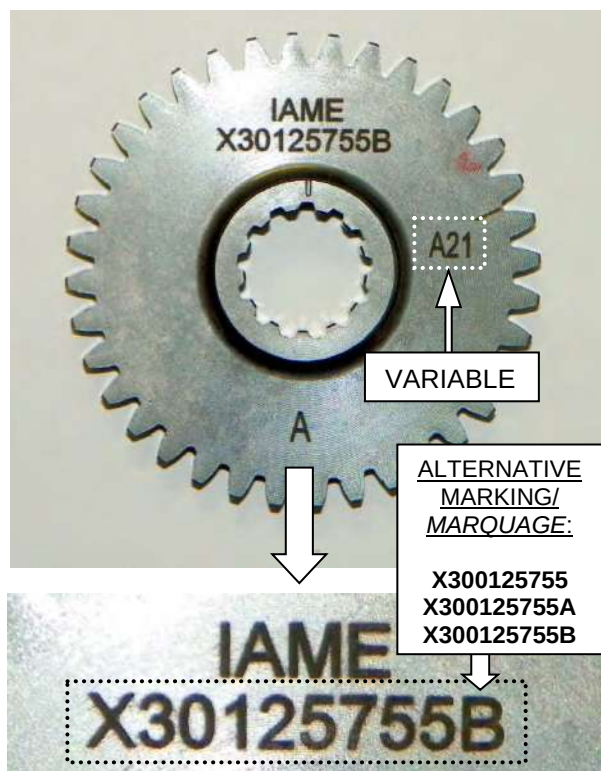


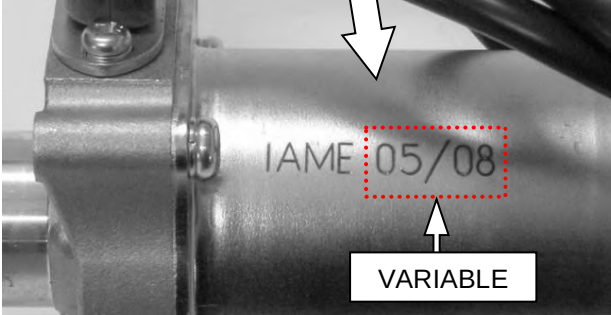
CRANKSHAFT IDENTIFICATION MARKING
MARQUAGE D'IDENTIFICATION DU VILEBREQUIN



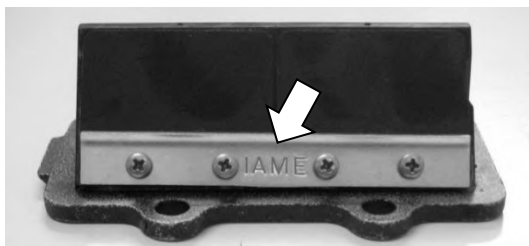
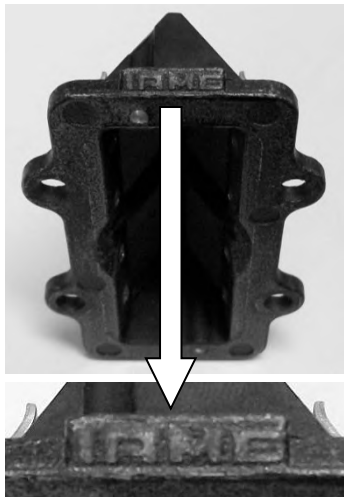
GEAR COMMAND BALANCING SHAFT
IDENTIFICATION MARKING
MARQUAGE D'IDENTIFICATION
ENGRENAGE ARBRE D'EQUILIBRAGE

SPROCKET IDENTIFICATION MARKING
MARQUAGE D'IDENTIFICATION DU PIGNON

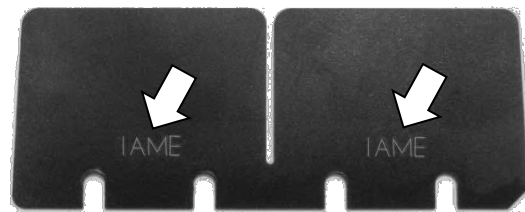


CLUTCH BODY IDENTIFICATION MARKING MARQUAGE D'IDENTIFICATION CORPS DE EMBRAYAGE	CLUTCH DRUM IDENTIFICATION MARKING MARQUAGE D'IDENTIFICATION DE LA CALOTTE
MATERIAL COLOUR IDENTIFICATION  VARIABLE 	 
STARTER RING IDENTIFICATION MARKING MARQUAGE D'IDENTIFICATION DE LA COURONNE DE DEMARRAGE	STARTER IDENTIFICATION MARKING MARQUAGE D'IDENTIFICATION DU MOTEUR DEMARREUR
 VARIABLE 	  VARIABLE

REED GROUP & PETALS IDENTIFICATION MARKING
 MARQUAGE D'IDENTIFICATION DE LA PYRAMIDE DE CLAPETS & CLAPETS

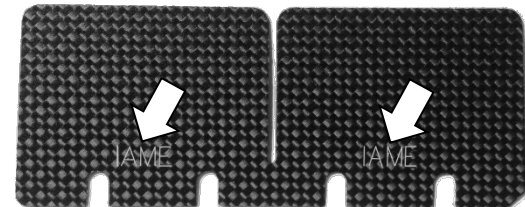


VETRONITE



CARBON FIBER

FRONT SIDE



REAR SIDE

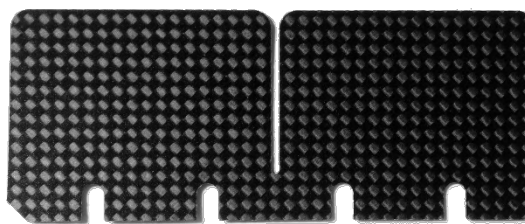
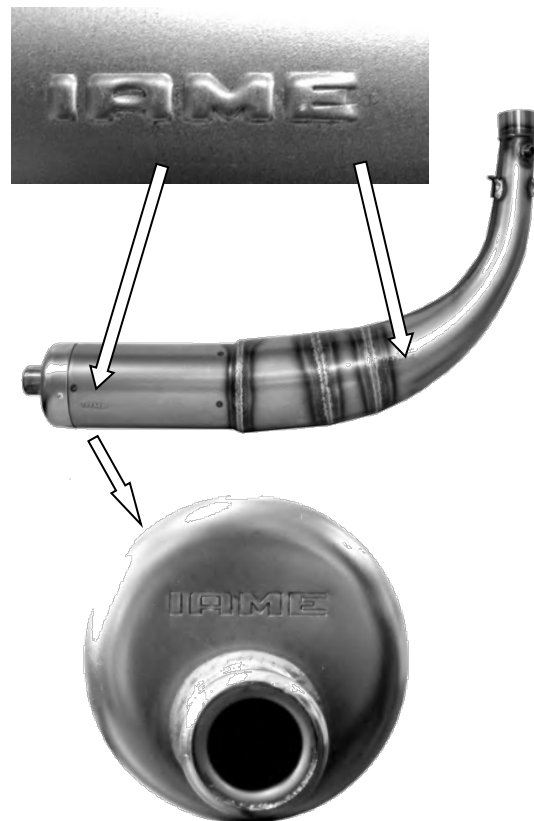


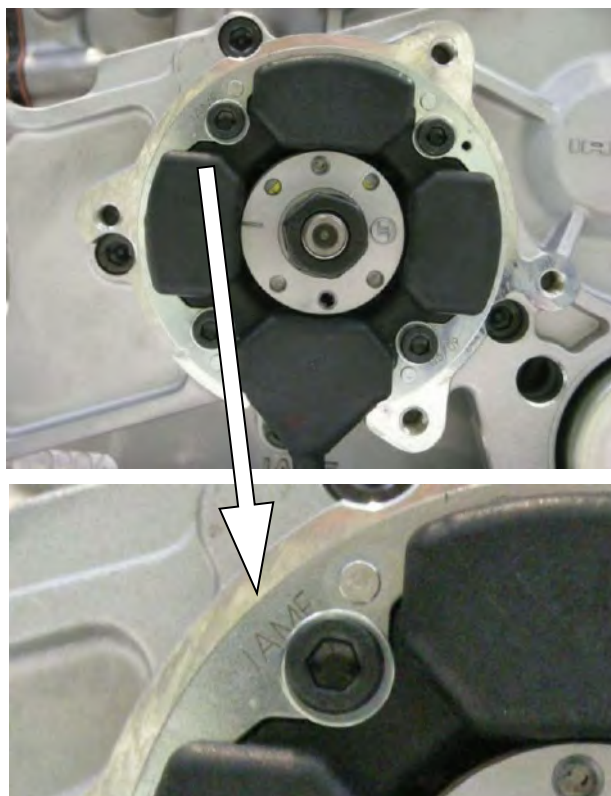
PHOTO IDENTIFICATION CARBURETOR
 INLET CONVEYOR
 MARQUAGE D'IDENTIFICATION DU
 COLLECTEUR D'ASPIRATION



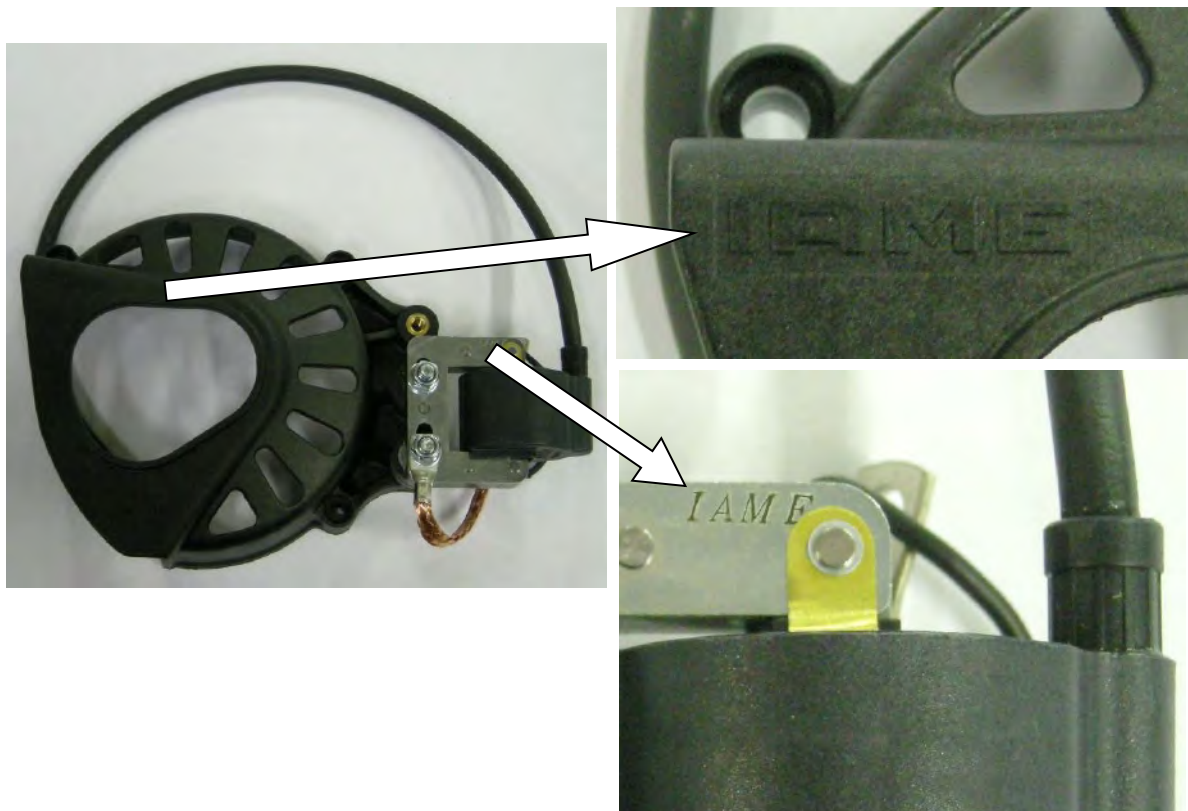
EXHAUST SILENCER IDENTIFICATION
 MARKING
 MARQUAGE D'IDENTIFICATION
 ECHAPPEMENT



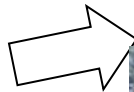
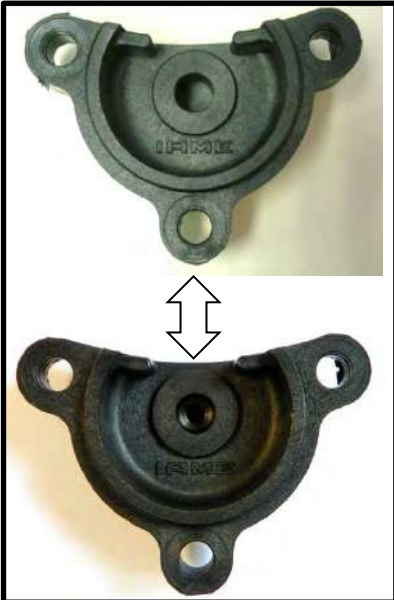
STATOR IDENTIFICATION MARKING
MARQUAGE D'IDENTIFICATION DU STATOR



CLUTCH COVER AND H.T. COIL IDENTIFICATION MARKING
MARQUAGE DU COUVERCLE D'EMBRAYAGE ET DE LA BOBINE



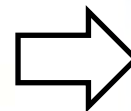
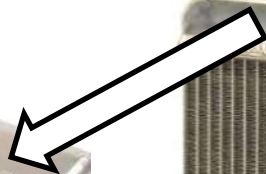
BENDIX COVER IDENTIFICATION MARKING
MARQUAGE D'IDENTIFICATION DU COUVERCLE
DU CONTRE-ARBRE DE DEMARRAGE



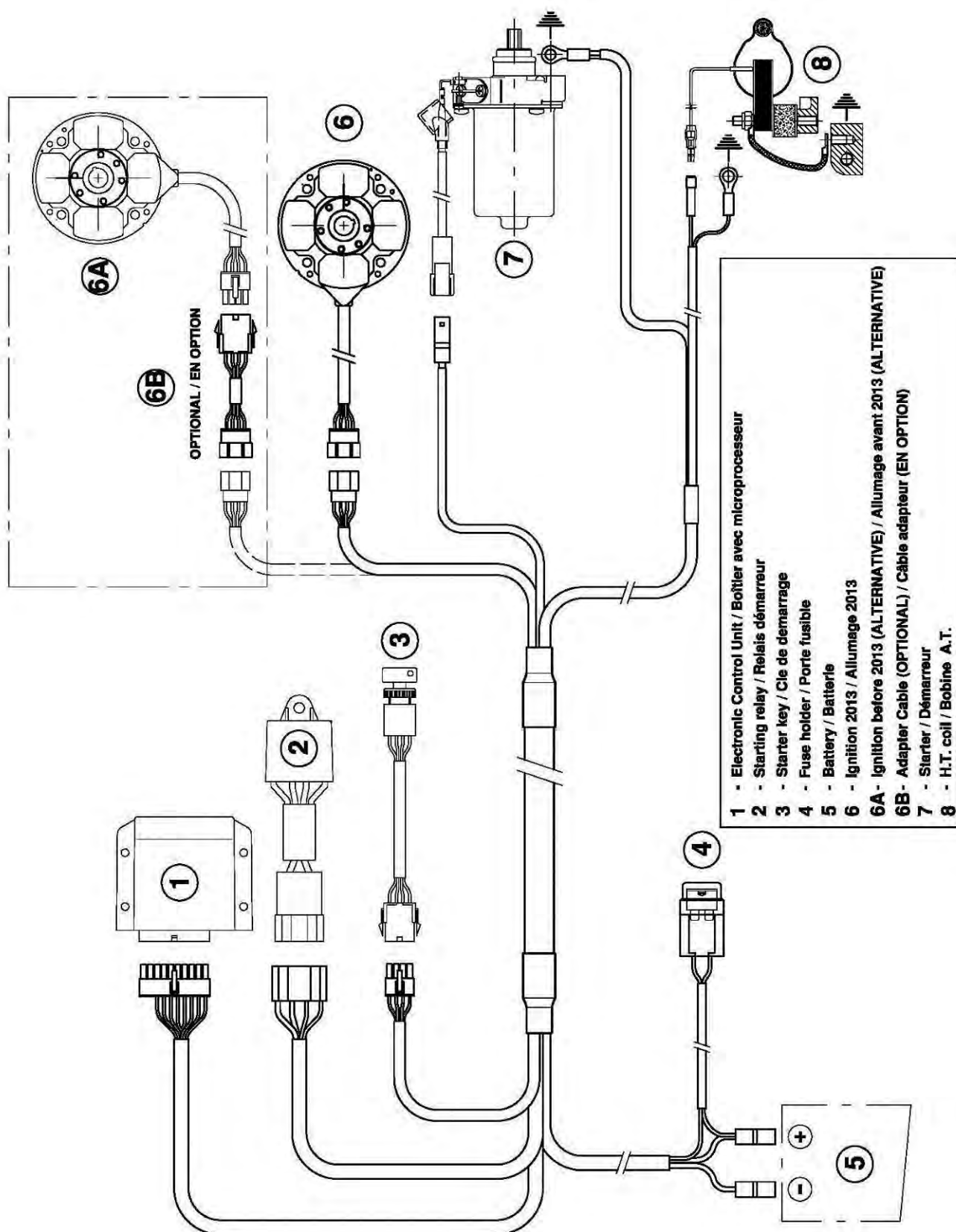
ALTERNATIVE



ALTERNATIVE RADIATOR IAME IDENTIFICATION MARKING
MARQUAGE D'IDENTIFICATION DU RADIATEUR ALTERNATIVE



WIRING DIAGRAM (SELETTRA DIGITAL "K" IGNITION 2013)
 SCHEMA CIRCUIT ELECTRIQUE (ALLUMAGE SELETTRA DIGITAL "K" 2013)



FROM 2014 ON - A PARTIR DE 2014

STICKER APPLICATION AREA - ESPACE POUR L'APPLICATION DE ADHÉSIFS

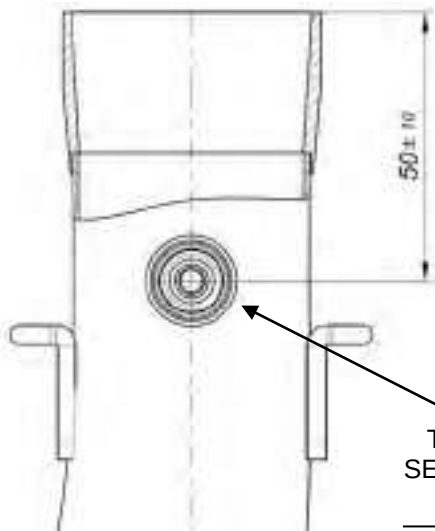


ALTERNATIVE AREA



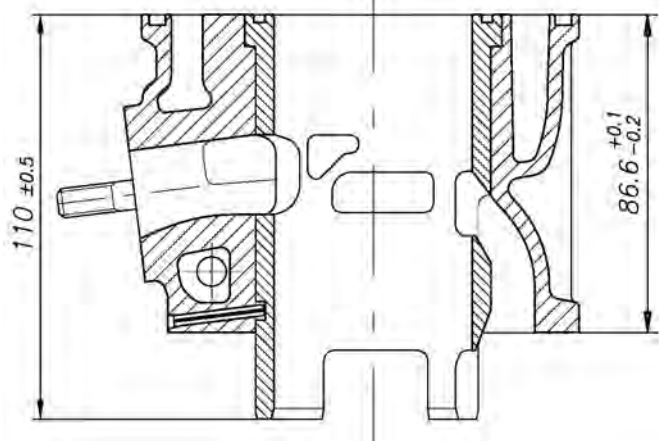
EXHAUST TEMPERATURE SENSOR
CAPTEUR DE TEMPERATURE D'ÉCHAPPEMENT

CYLINDER CROSS SECTION VIEW
VUE EN SECTION DU CYLINDRE

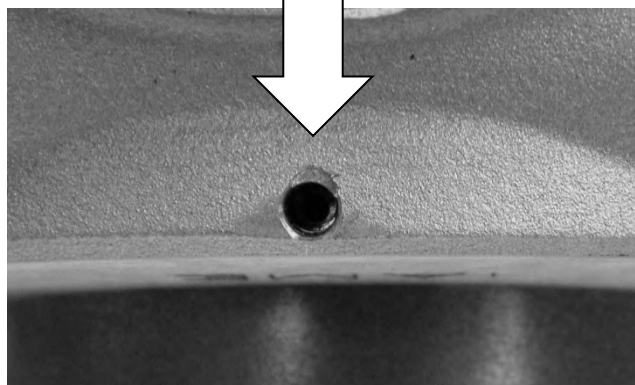
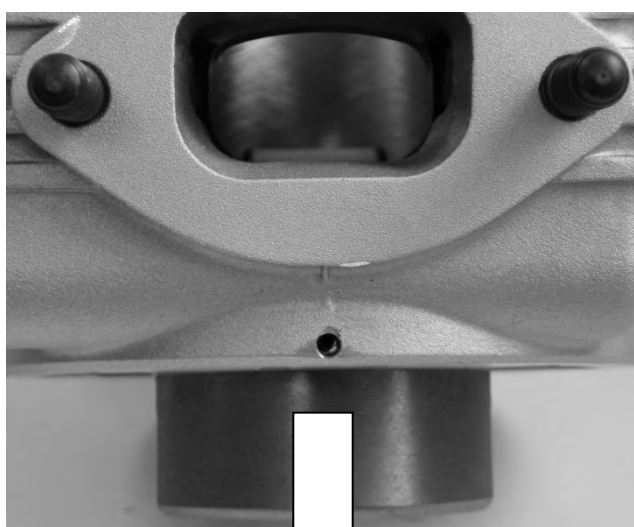
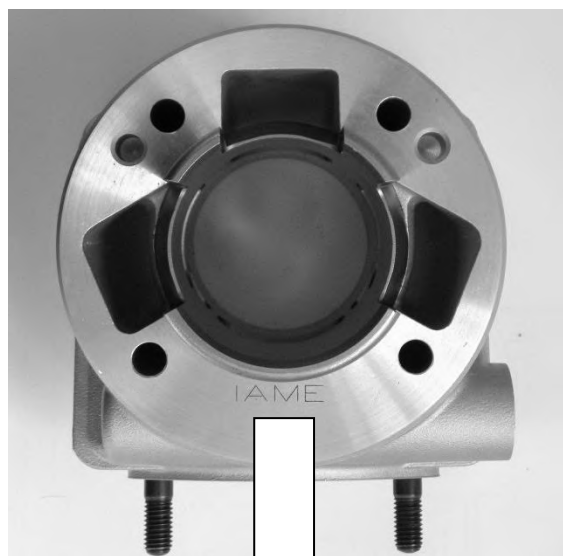
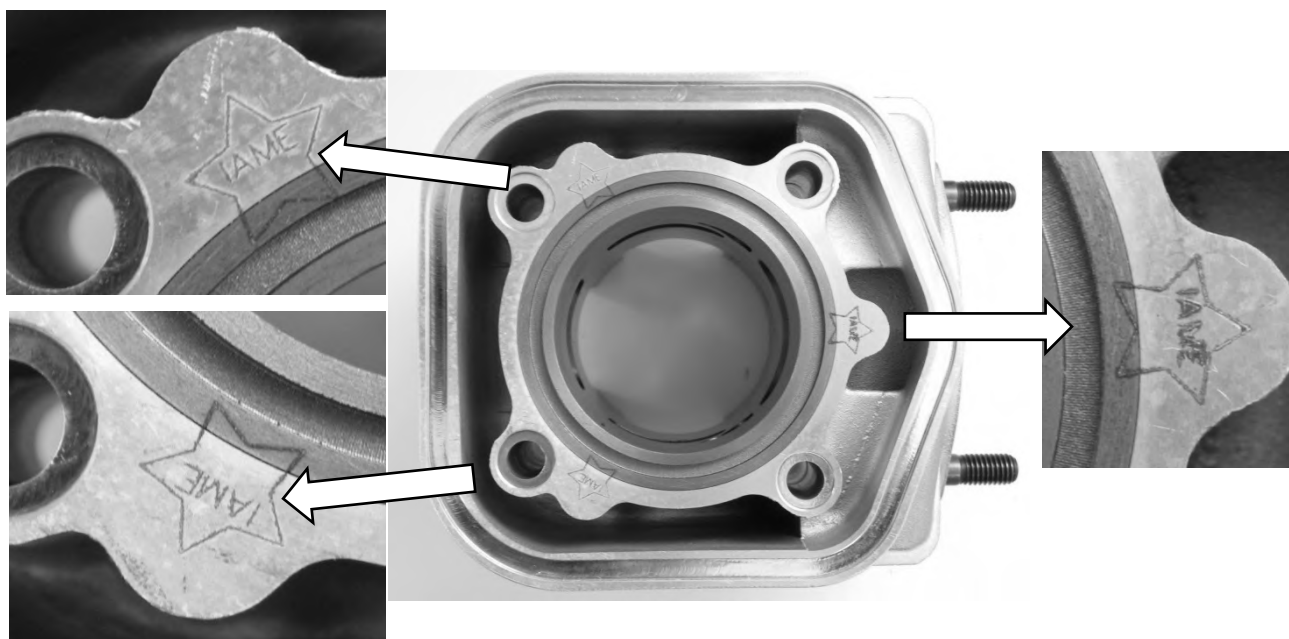


EXHAUST
TEMPERATURE
SENSOR POSITION
(OPTIONAL)

POSITION DU
CAPTEUR
DE TEMPERATURE
D'ÉCHAPPEMENT
(EN OPTION)



CYLINDER IDENTIFICATION MARKING
MARQUAGE D'IDENTIFICATION DU CYLINDRE



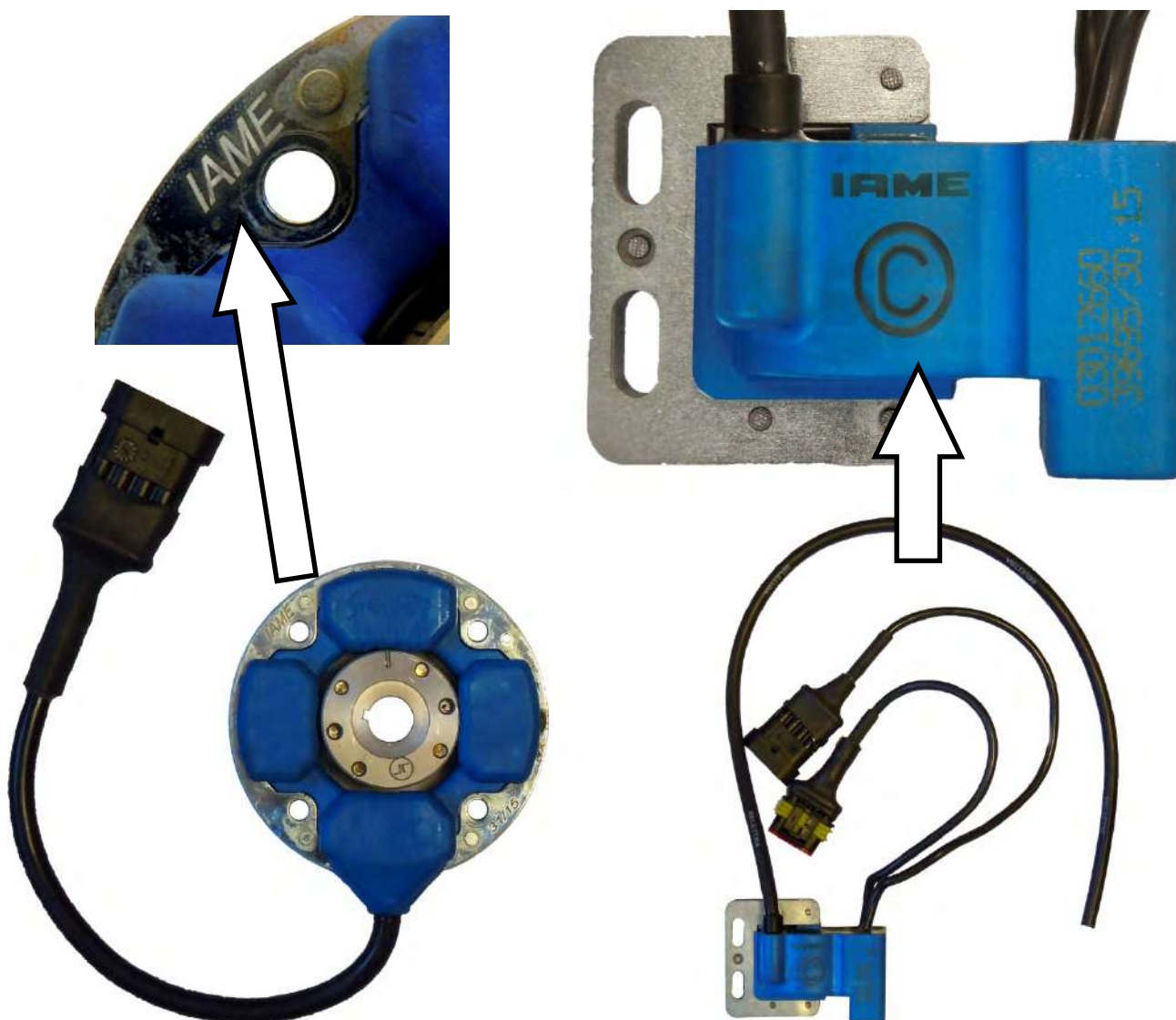
ALTERNATIVE PUSH BUTTONS – START & STOP
BOUTONS “START & STOP” DU DEMARREUR ALTERNATIVE



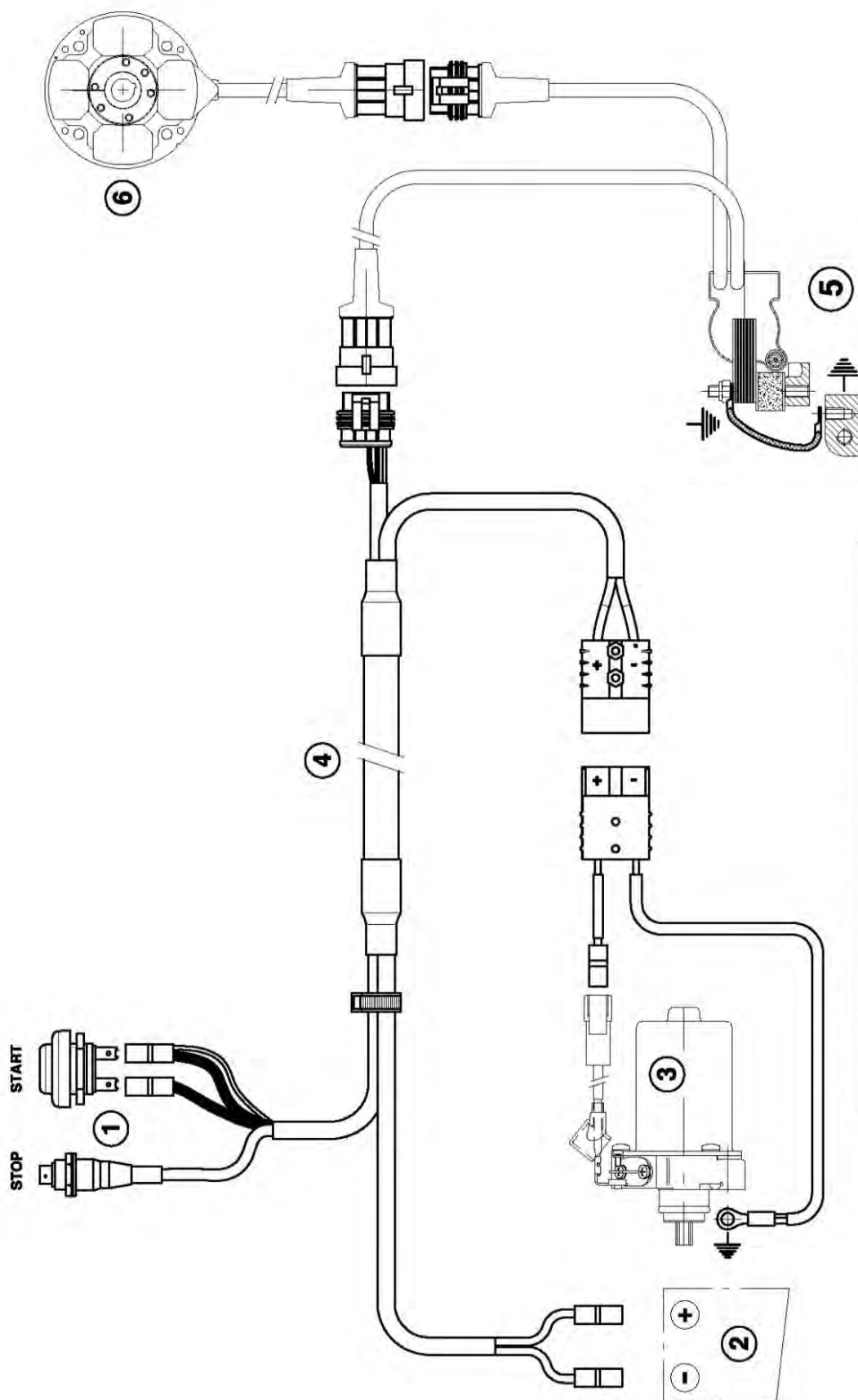
PHOTO COMPLETE ALTERNATIVE WIRING LOOM
 PHOTO DU CABLAGE ELECTRONIQUE COMPLETE



PHOTO OF SELETTRA ALTERNATIVE DIGITAL "S" IGNITION, WITH IAME MARKING
 PHOTO DU SELETTRA DIGITAL "S" ALLUMAGE, AVEC MARQUAGE IAME



WIRING DIAGRAM (SELETTRA DIGITAL "S" IGNITION)
SCHEMA CIRCUIT ELECTRIQUE (ALLUMAGE SELETTRA DIGITAL "S")



1 - Push buttons Start & Stop / Bouton poussoir du démarreur

2 - Battery / Batterie

3 - Starter / Démarreur

4 - Wiring cable / Cablage électrique

5 - H.T. coil and Electronic Control Unit
/ Bobine A.T. et boîtier avec microprocesseur

6 - Ignition / Allumage

ALTERNATIVE WIRING LOOM
CABLAGE ELECTRONIQUE COMPLET ALTERNATIVE



ALTERNATIVE WIRING LOOM DIAGRAM
SCHEMA CIRCUIT ELECTRIQUE ALTERNATIVE

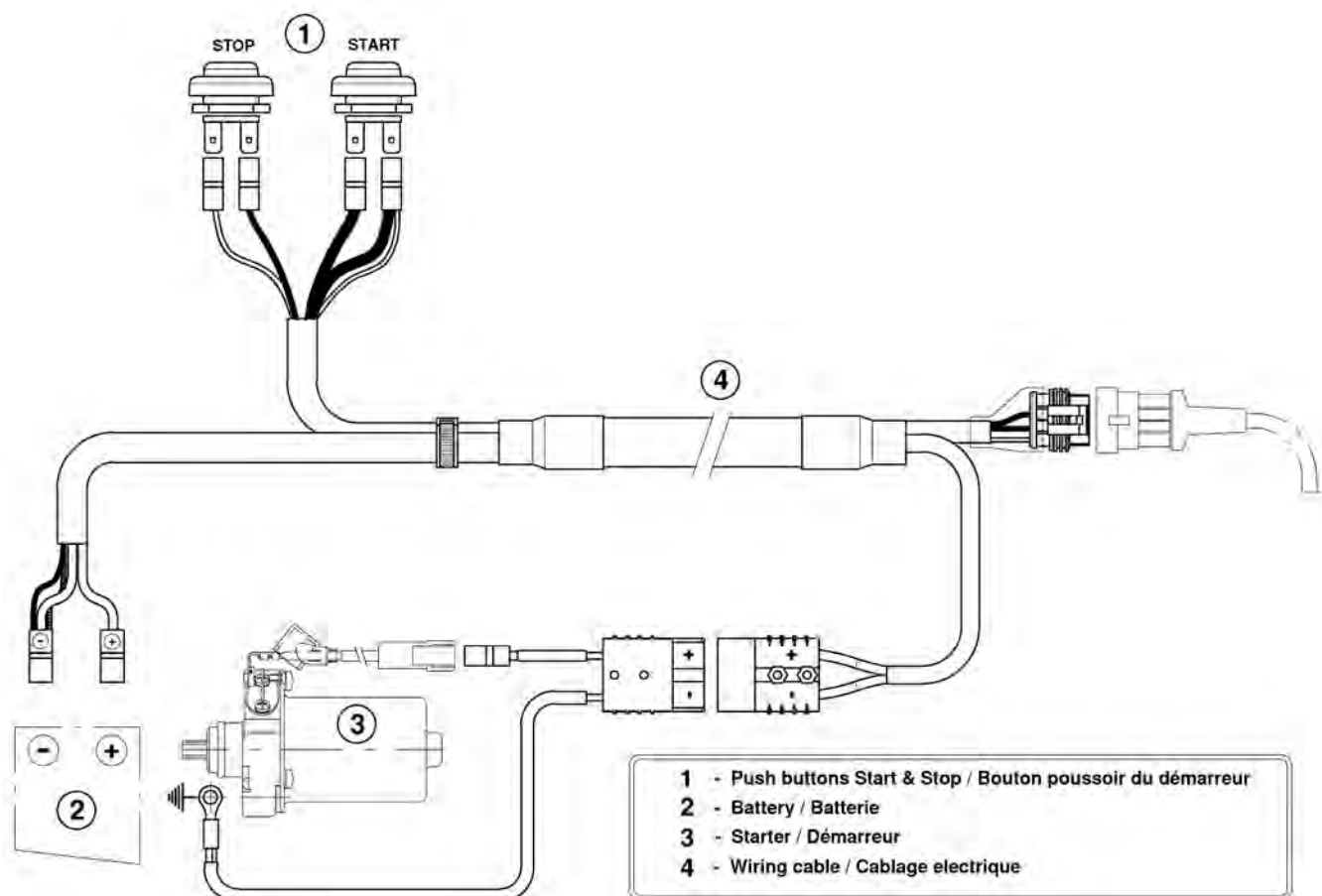
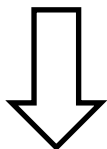
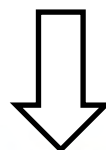


PHOTO IDENTIFICATION REED GROUP
 PHOTO IDENTIFICATION PYRAMIDE DE CLAPETS

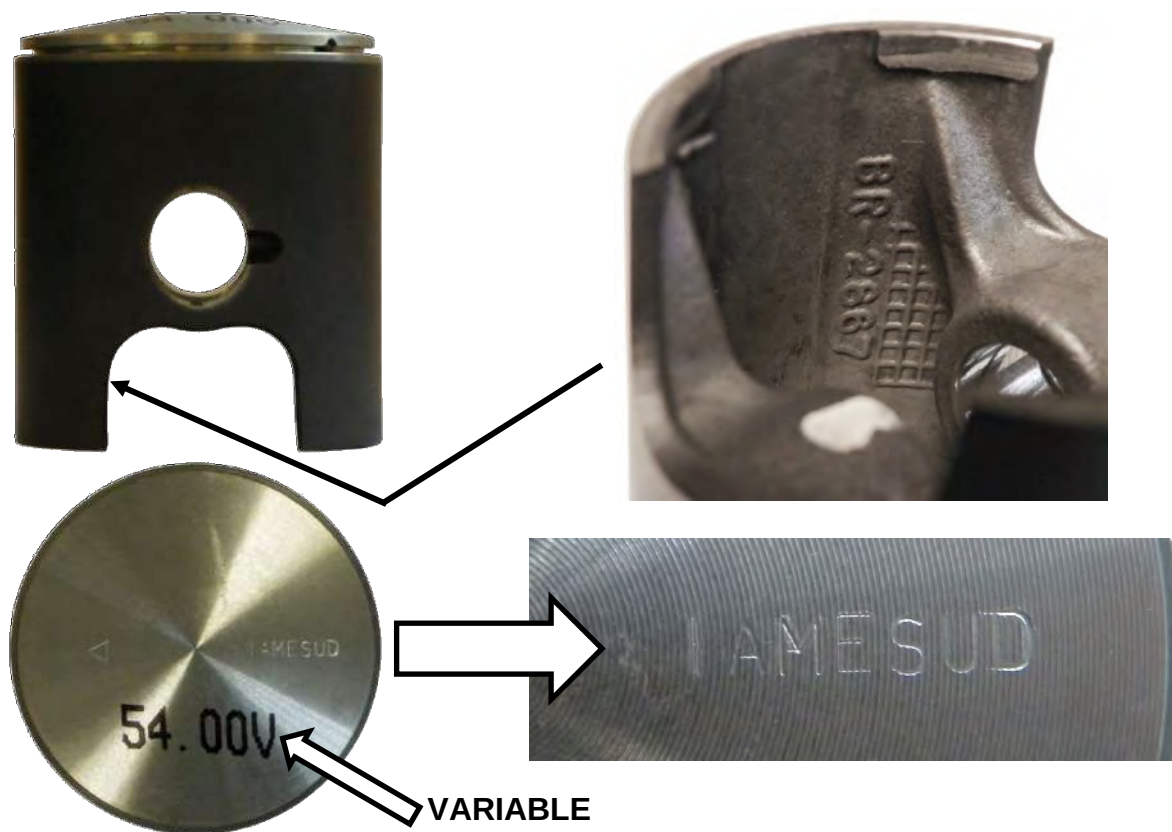
ACTUAL VERSION
 COURANT VERSION



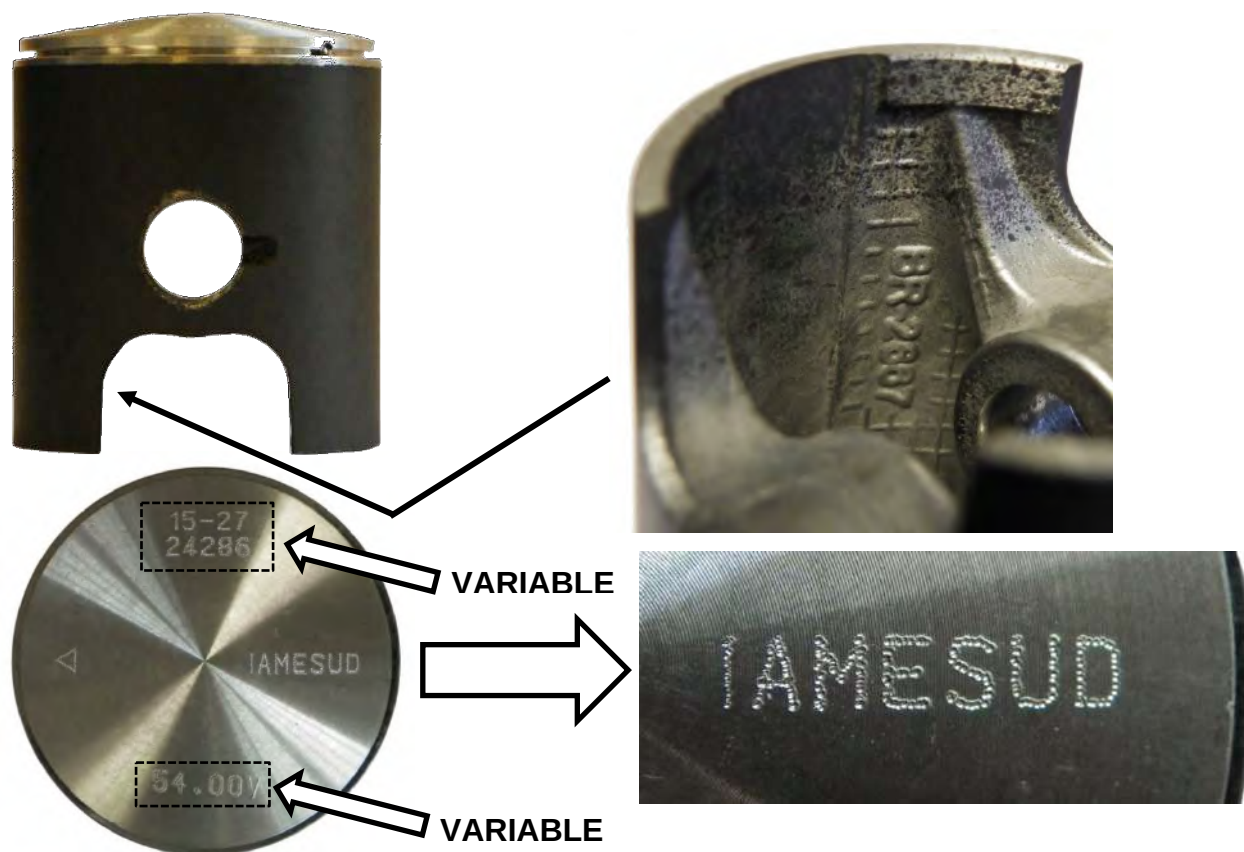
ALTERNATIVE VERSION
 VERSION ALTERNATIVE



ACTUAL PISTON
PISTON COURANT



ALTERNATIVE PISTON
PISTON ALTERNATIVE



ALTERNATIVE CONROD
 BIELLE ALTERNATIF

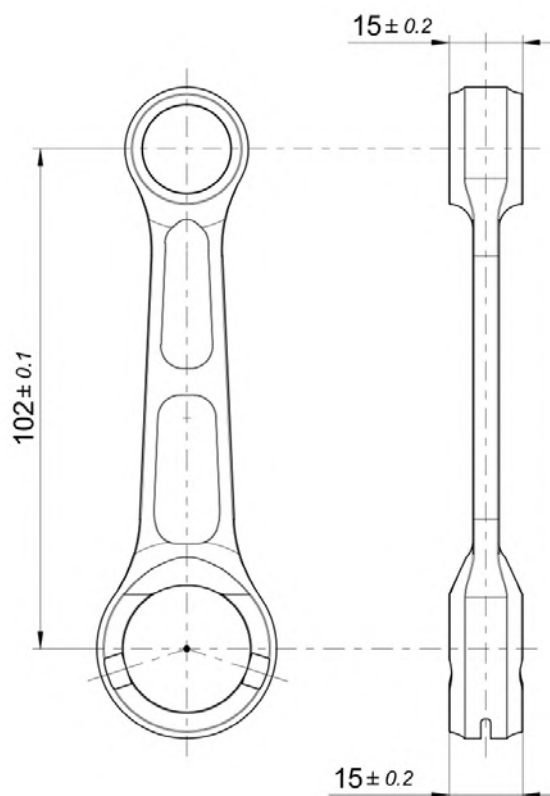
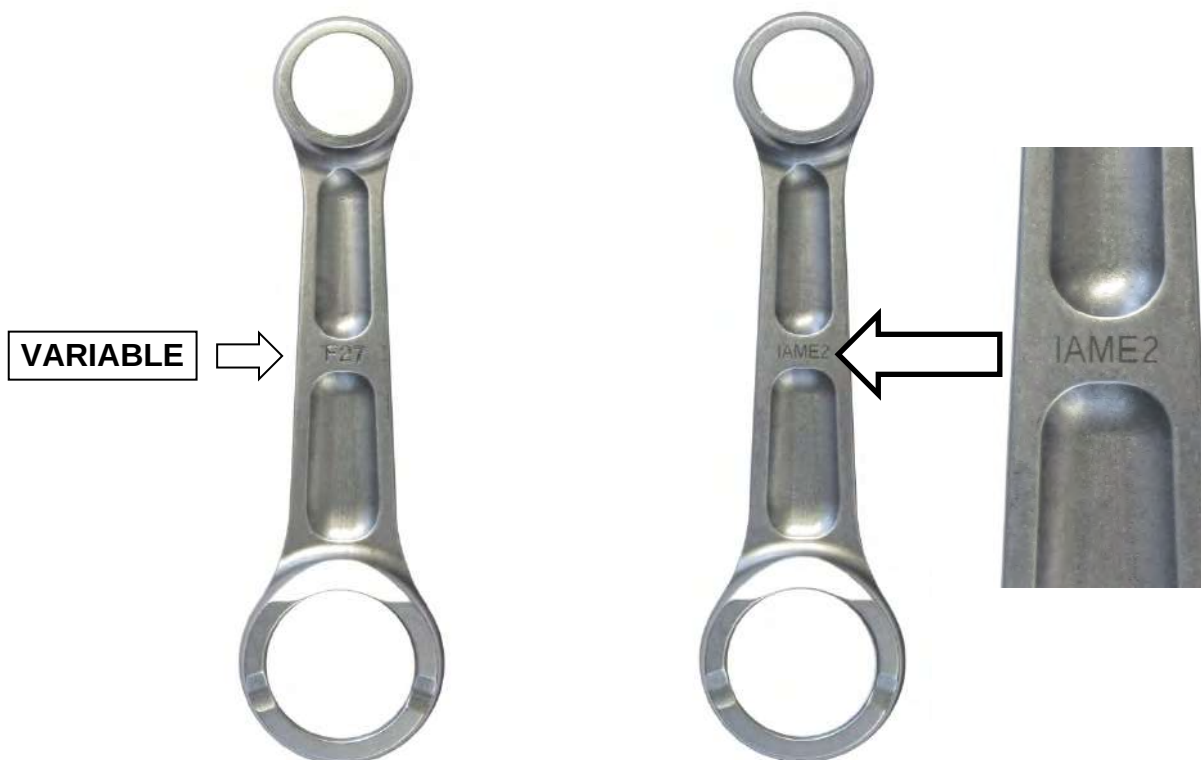


PHOTO OF THE CONROD BOTH SIDE – ALTERNATIVE
 PHOTO DEUX COTES DE LA BIELLE - ALTERNATIF



BOTH TYPES OF CONROD CAN BE USED WITH BOTH TYPES OF WASHERS (IN COUPLE)
LES DEUX TYPES DE BIELLE PEUVENT ÊTRE UTILISÉS AVEC LES DEUX TYPES DE
RONDELLES (EN COUPLE)

PHOTO IDENTIFICATION OF SMALL END CONROD BEARING – TYPES ALTERNATIVE
PHOTO D'IDENTIFICATION DU PALIER PIED DE BIELLE – TYPES ALTERNATIFS

TYPE 1



TYPE 2



PHOTO IDENTIFICATION OF CONROD WASHER – TYPES ALTERNATIVE
PHOTO D'IDENTIFICATION RONDELLE BIELLE – TYPES ALTERNATIFS

TYPE 1



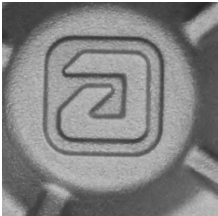
TYPE 2



PARTS WITH ALTERNATIVE NEW LOGO "IAME"
COMPOSANTS AVEC UN NOUVEAU LOGO ALTERNATIF «IAME»

CYLINDER HEAD <i>CULASSE</i>  NEW / NOUVEAU LOGO 	CYLINDER <i>CILINDRE</i>  NEW / NOUVEAU LOGO 
SEMICARTER TRANSMISSION SIDE <i>SEMICARTER CÔTÉ PIGNON</i>  NEW / NOUVEAU LOGO 	SEMICARTER IGNITION SIDE <i>SEMICARTER CÔTÉ ALLUMAGE</i>  NEW / NOUVEAU LOGO 

PARTS WITH ALTERNATIVE NEW LOGO "IAME"
COMPOSANTS AVEC UN NOUVEAU LOGO ALTERNATIF «IAME»

IGNITION COVER COUVERCLE DU ALLUMAGE  NEW / NOUVEAU LOGO 	CLUTCH COVER COUVERCLE D'EMBRAYAGE  NEW / NOUVEAU LOGO 
REED GROUP GROUPE CLAPETS  NEW / NOUVEAU LOGO 	CARBURETTOR INLET CONVEYOR CONVOYEUR D'ADMISSION  NEW / NOUVEAU LOGO 

PARTS WITH ALTERNATIVE NEW LOGO "IAME"
COMPOSANTS AVEC UN NOUVEAU LOGO ALTERNATIF «IAME»

RADIATOR RADIATEUR	EXHAUST SILENCER ECHAPPEMENT
NEW / NOUVEAU LOGO 	 NEW / NOUVEAU LOGO  NEW / NOUVEAU LOGO

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

LES AUTRES COMPOSANTS DU MOTEUR AVEC MARQUAGE (LASER OU POINÇONNEUSE) AUJOURD'HUI AVEC LE LOGO OU ÉCRIT «IAME»

IAME

or

IAME

NOW COULD BE MARKED WITH NEW LOGO "IAME"

MAINTENANT POURRAIT EST MARQUEES AVEC UN NOUVEAU LOGO "IAME"

IAME

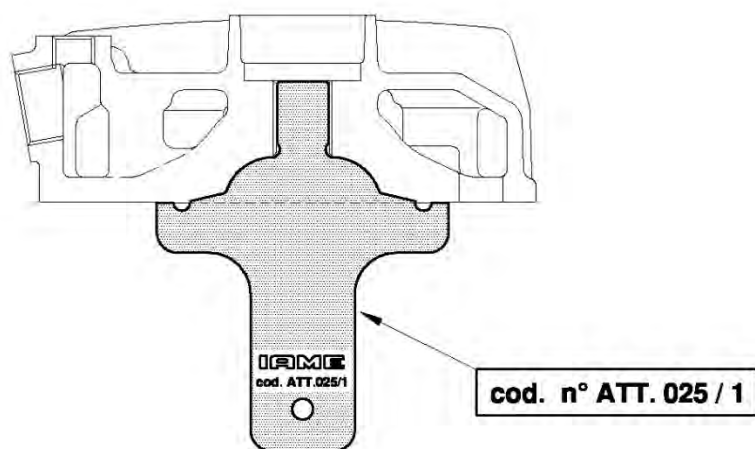
or

IAME

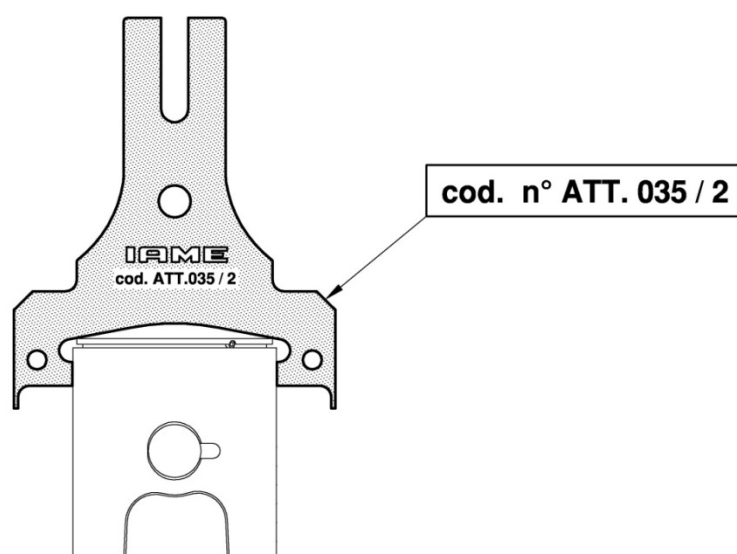
or



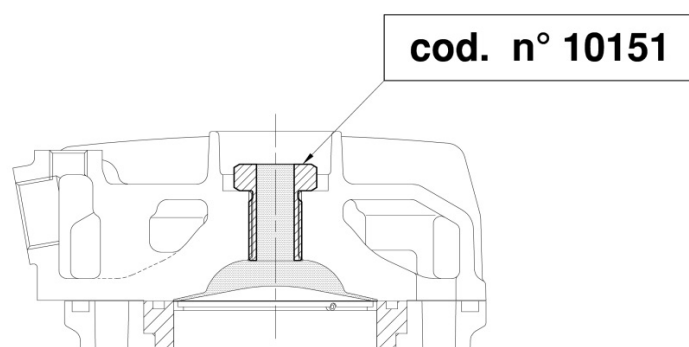
CHECKING THE SHAPE OF THE COMBUSTION CHAMBER
CONTRÔLE DE LA FORME DE LA CHAMBRE DE COMBUSTION



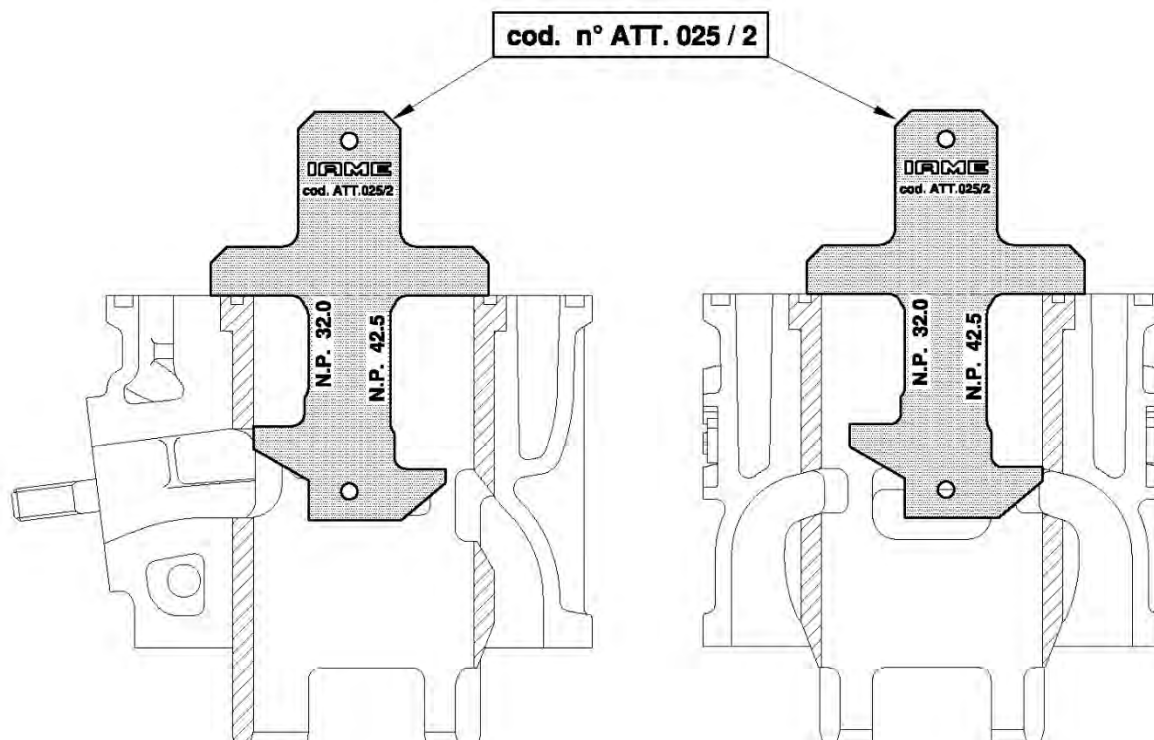
CONTROL OF THE PISTON DOME
CONTRÔLE DU DÔME DE PISTON



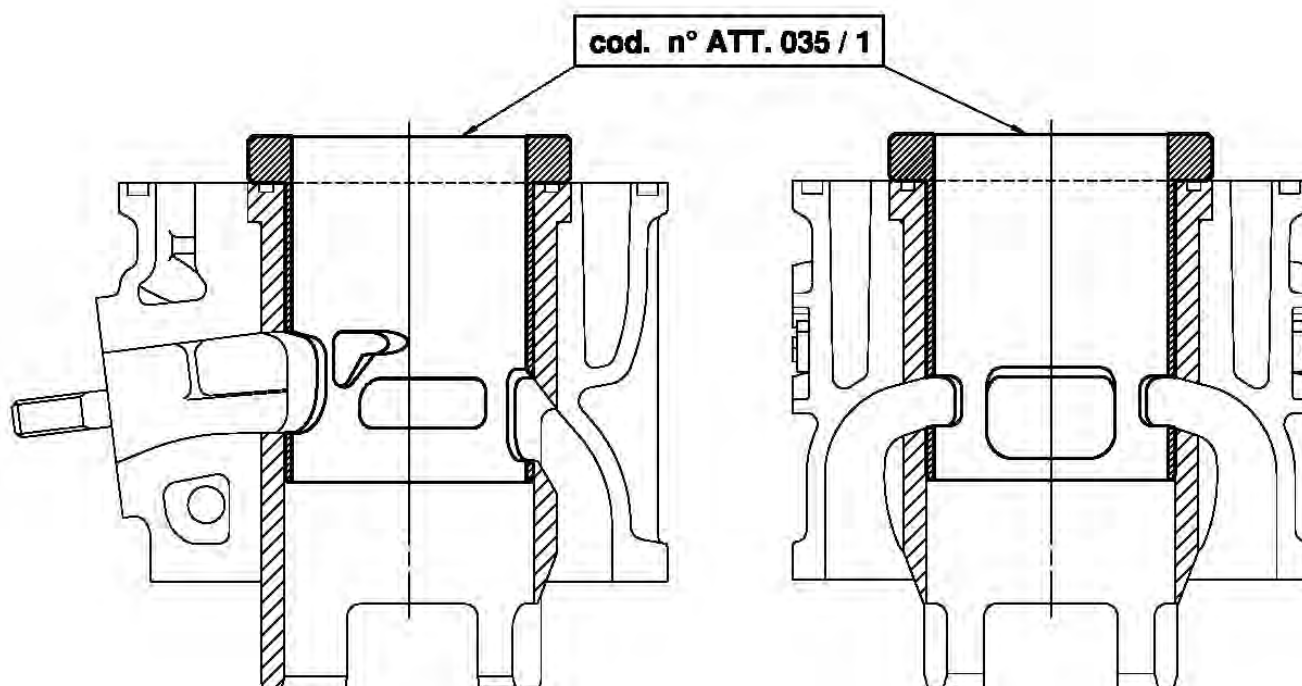
CONTROL OF THE VOLUME OF THE COMBUSTION CHAMBER
CONTRÔLE DU VOLUME DE LA CHAMBRE DE COMBUSTION



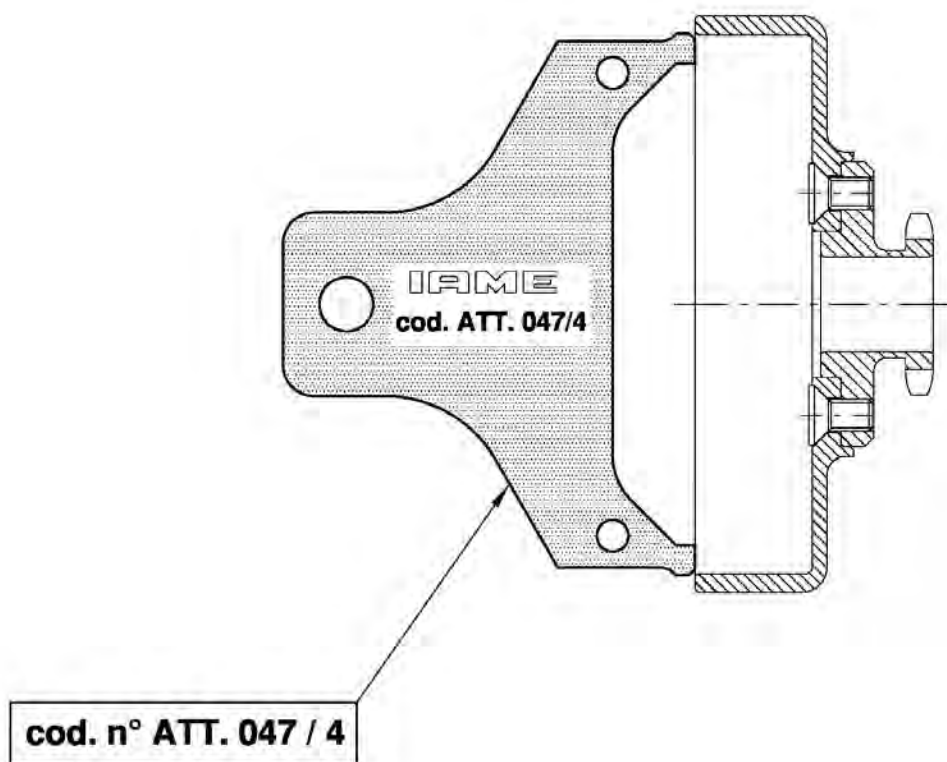
CYLINDER CHECK - CONTRÔLE DU CYLINDRE
CHECK OF EXHAUST DUCT AND LATERAL TRANSFERS
CONTRÔLE DE LA LUMIÈRE D'ÉCHAPPEMENT ET DES TRANSFERTS LATÉRAUX



CYLINDER LINER DUCTS AND TRANSFERS CHECK TOOL
OUTIL DE VÉRIFICATION DES LUMIÈRES DE LA CHEMISE DU CYLINDRE

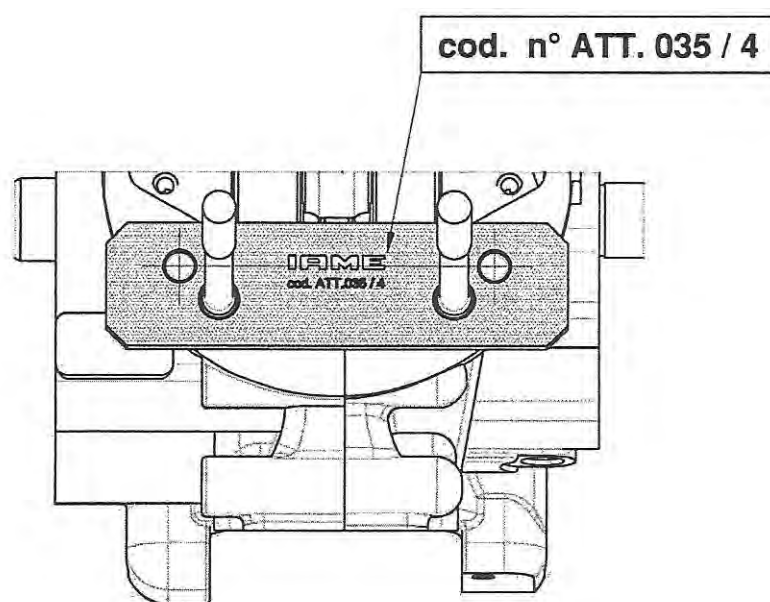


CLUTCH DRUM CHECK TOOL
CONTRÔLE DE LA CLOCHE D'EMBRAYAGE

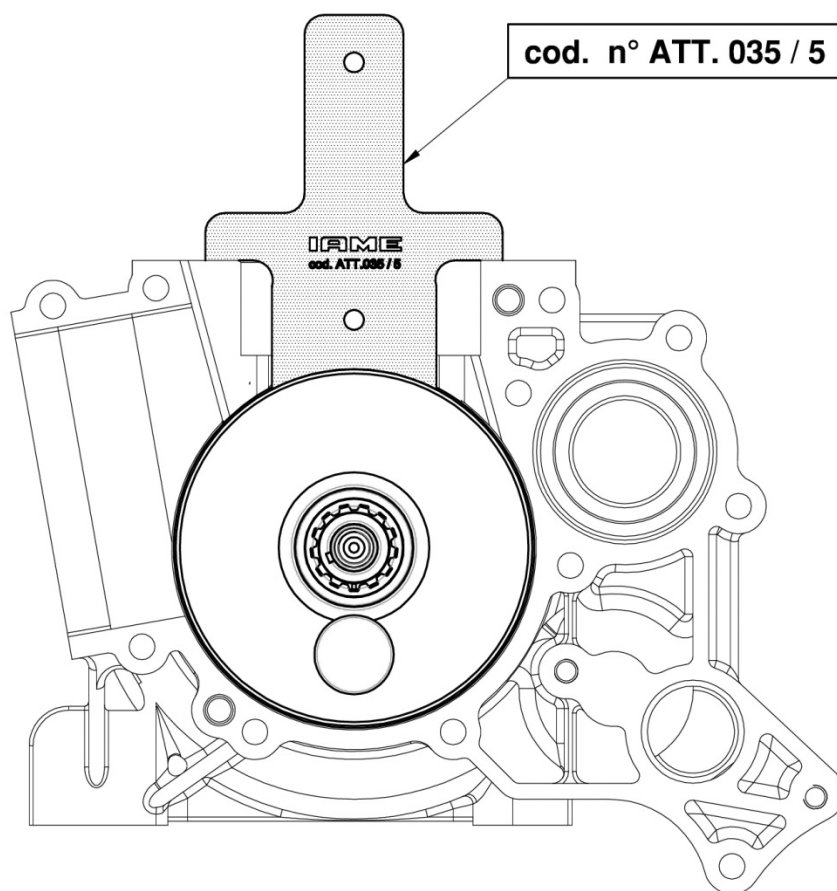


CRANKCASE CHECK TOOLS - CONTRÔLE DU CARTER

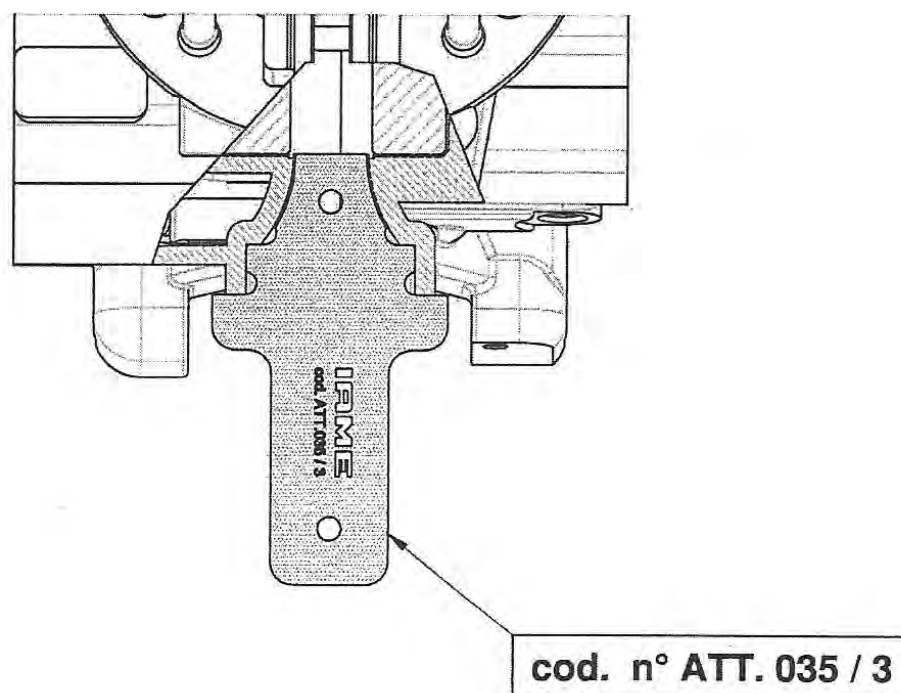
CHECKING THE DISTANCE BETWEEN THE CILYNDER PINS
CONTRÔLE DE L'ENTRAXE DES PINNULES D'INDEXATION DU CYLINDRE



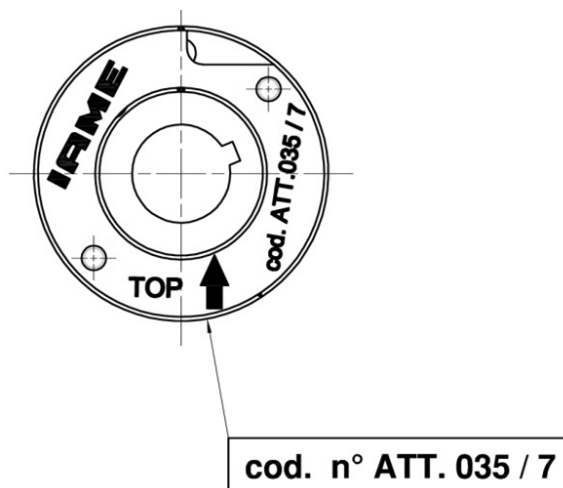
CONTROL OF THE HEIGHT OF THE JOINT PLANE
CONTRÔLE DE LA HAUTEUR DU PLAN DE JOINT



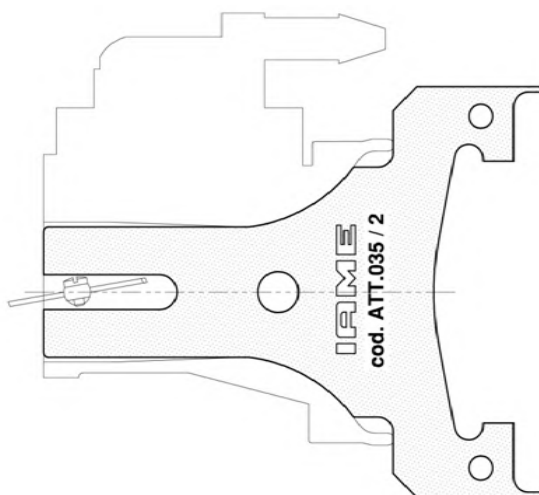
CHECKING OF THE REEDS VALVE SEAL PLANE
CONTRÔLE DU PLAN DE JOINT DE LOGEMENT DE BOITE À CLAPETS



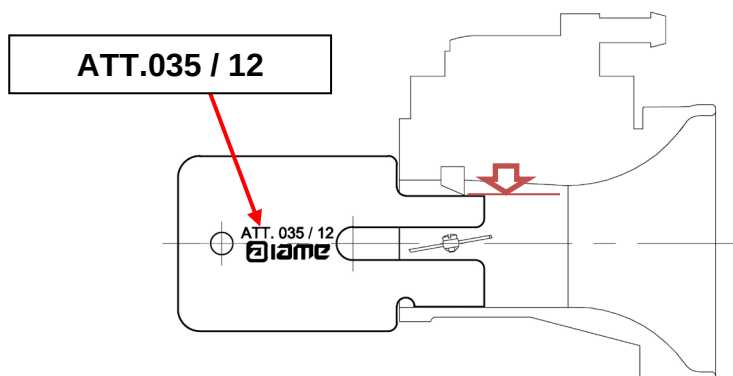
CONTROL OF THE POSITION OF SELETTA DIGITAL "S" PHASE MARKING
CONTROLE DU POSITION REGULA DU MARQUAGE DU PHASE SELETTA DIGITAL "S"



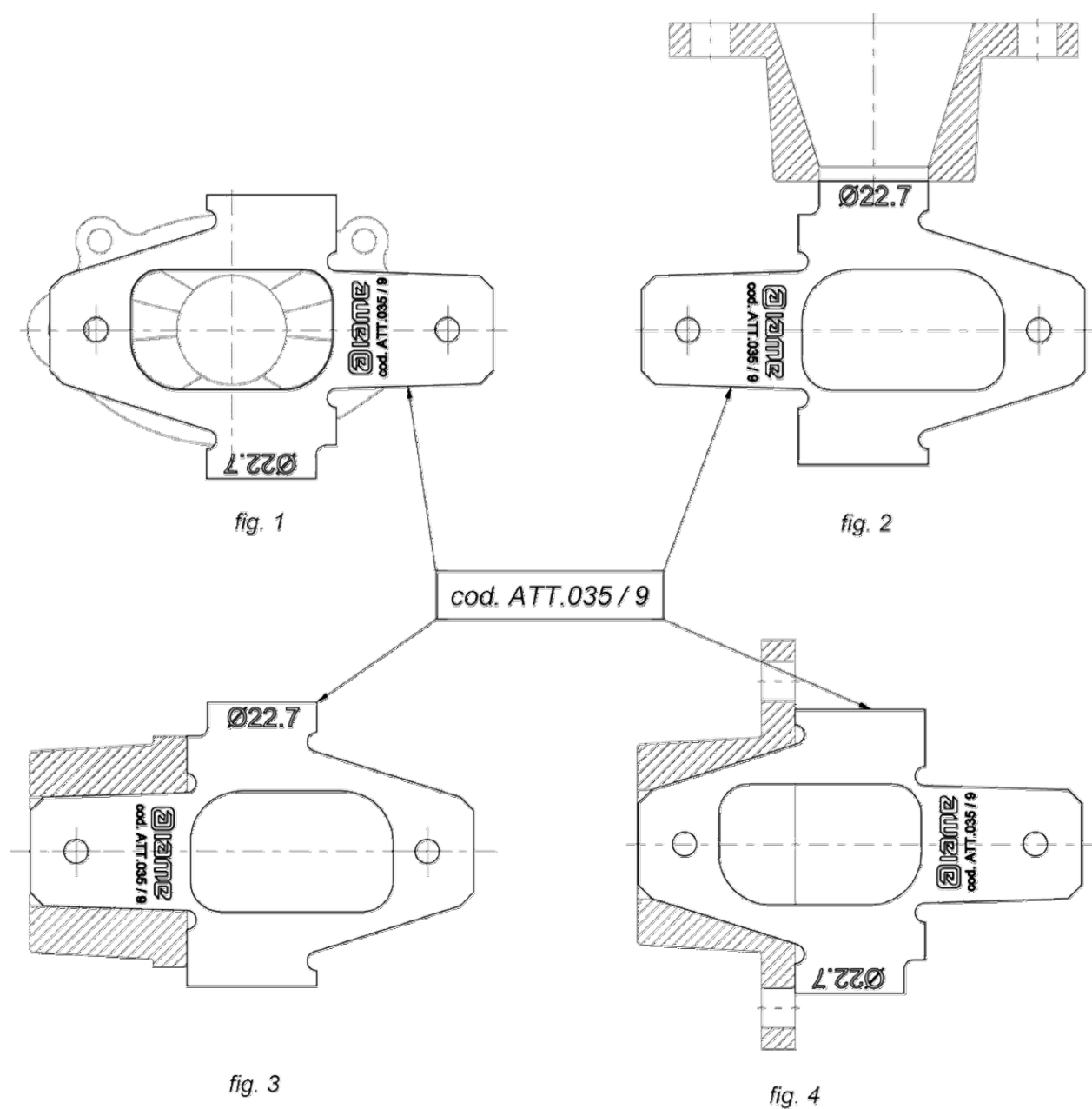
VENTURI SHAPE CONTROL OF TILLOTSON HW-27A CARBURETTOR
CONTROLE DU VENTURI DU CARBURATEUR TILLOTSON HW-27A



CHECK THE HEIGHT OF ATOMIZER – PASS IF IT'S OK
CONTROLE HAUTER DU PULVERIZATEUR – PASS S'IL EST REGULIER



EXHAUST MANIFOLD CHECK TOOL - CONTRÔLE DU RACCORD D'ÉCHAPPEMENT



CHECK THAT THE NO-GO GAUGE DOES NOT ENTER INTO THE EXHAUST RESTRICTOR, (FIG.2):
VERIFIEZ QUE LE CALIBRE N'ENTRE PAS DANS LE TROU DU RESTRICTEUR D'ÉCHAPPEMENT.

CHECK THAT THE TOOL MATCHES THE SHAPE OF THE EXHAUST MANIFOLD, (FIG.1,3 AND 4).
VERIFIEZ QUE L'OUTIL ADAPTE LA MEME FORME DU RESTRICTEUR D'ÉCHAPPEMENT.