X30 WATERSWIFT 60CC - TAG

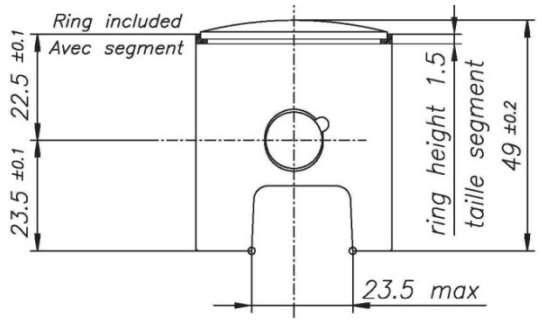
FEATURES - *CARACTERISTIQUES*	
Cylinder volume *Volume du cylindre*	59.17 cm³ (60.00 cm³ max)
Bore *Alésage*	41.81 mm
Max. bore *Alésage max.*	42.10 mm
Stroke *Course*	43mm
Cooling system *Système de refroidissement*	Water *Eau*
Inlet system *Système d'admission*	Piston valve *Jupe de piston*
Number of carbs *Nombre de carburateurs*	1
Cylinder / crankcase transfers n° *N° de canaux cylindre / carter*	2
Inlet / exhaust ports number *N° lumières admiss / échapp.*	1 / 1
Combustion chamber shape Forme chambre de combustion	Spherical *Sphérique*
Selettra ignition (adjustable) *Allumage Selettra (réglable)*	2 poles 2 pôles
Distance between Conrod centres *Longueur (entre axe) de la bielle*	88 mm

Tillotson Carburettor *Carburateur Tillotson*	HW-31A
Number of piston rings *Nombre de segments*	1
Big end conrod bearing diam. *Diamètre palier tête de bielle*	18x24x15
Crankshaft ball-bearing diam. *Diamètre palier du vilebrequin*	20x47x14
Small end conr. bearing diam. *Diamètre palier pied de bielle*	12x16x16

AC SPORT
2023

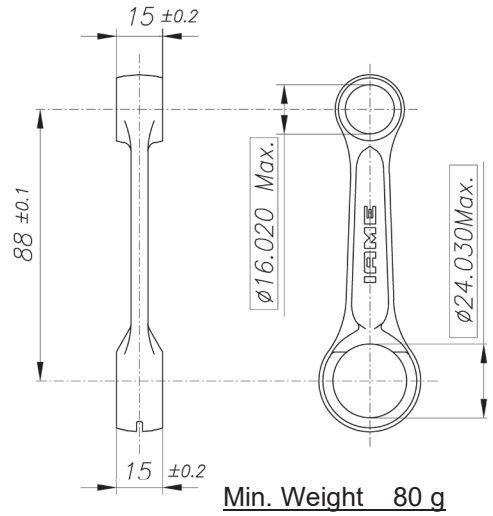
DESCRIPTION OF THE MATERIAL *DESCRIPTION DES MATERIAUX*	
Conrod material *Matériel de la bielle*	Steel *Acier*
Crankshaft material *Matériel du vilebrequin*	Steel *Acier*
Head Material *Matériel de la culasse*	Aluminium
Cylinder Material *Matériel du cylindre*	Aluminium
Liner material *Matériel de la chemise*	Cast Iron *Fonte*
Crankcase material *Matériel du carter*	Aluminium
Piston material *Matériel du piston*	Aluminium
Piston rings material *Matériel des segments*	Cast Iron *Fonte*
Exhaust muffler material *Matériel du pot d'échappement*	Sheet-steel *Tôle acier*
Ball-bearings *Roulements*	6204 type

PISTON



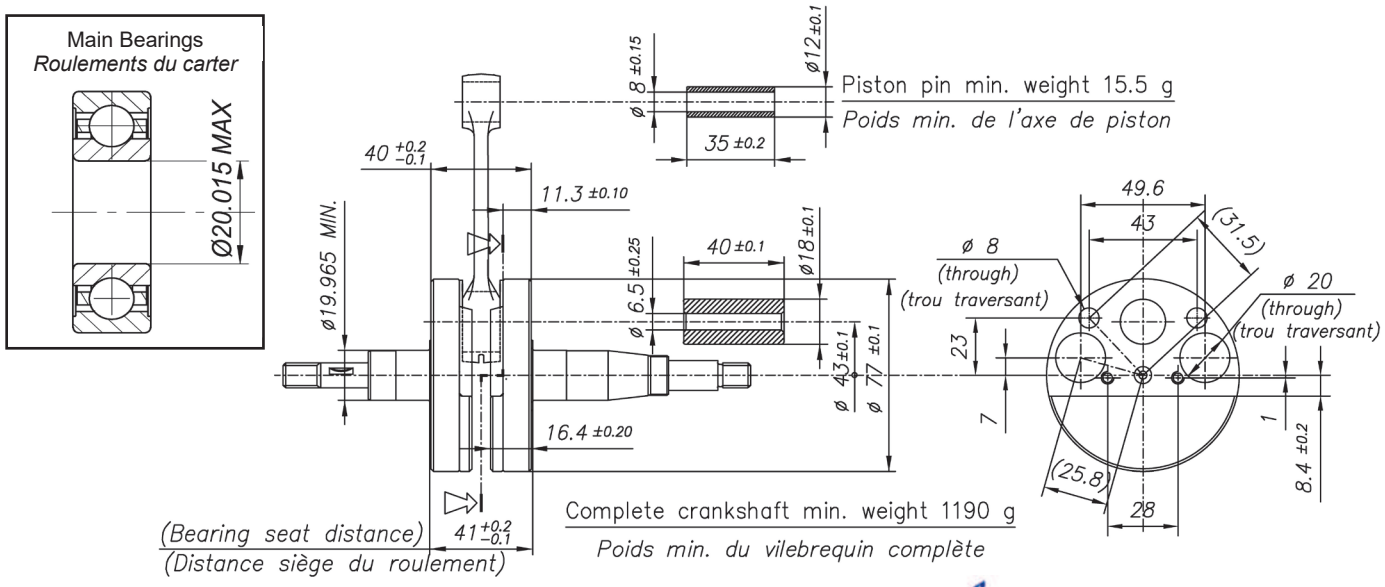
Min. Weight Piston included ring = 60 g
Poids Min. Piston avec segment = 60 g

DISTANCE BETWEEN CONROD CENTERS
ENTRE AXE DE LA BIELLE

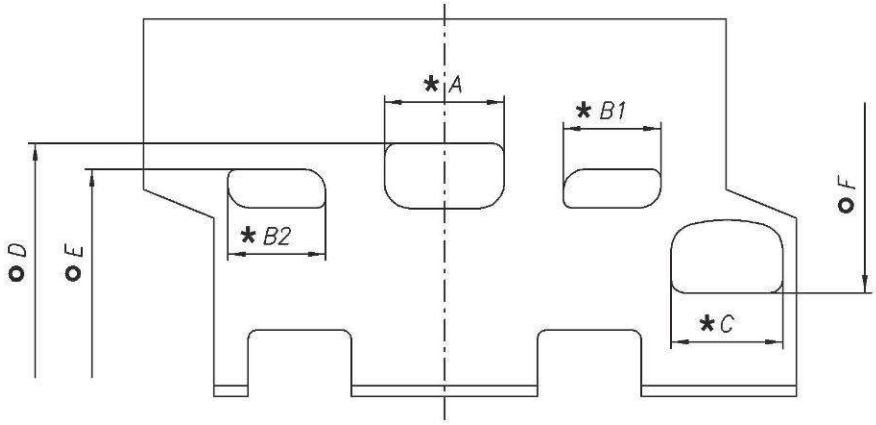


Min. Weight 80 g
Poids min.

CRANKSHAFT - *VILEBREQUIN*



CYLINDER DEVELOPMENT – *DEVELOPPEMENT DU CYLINDRE*

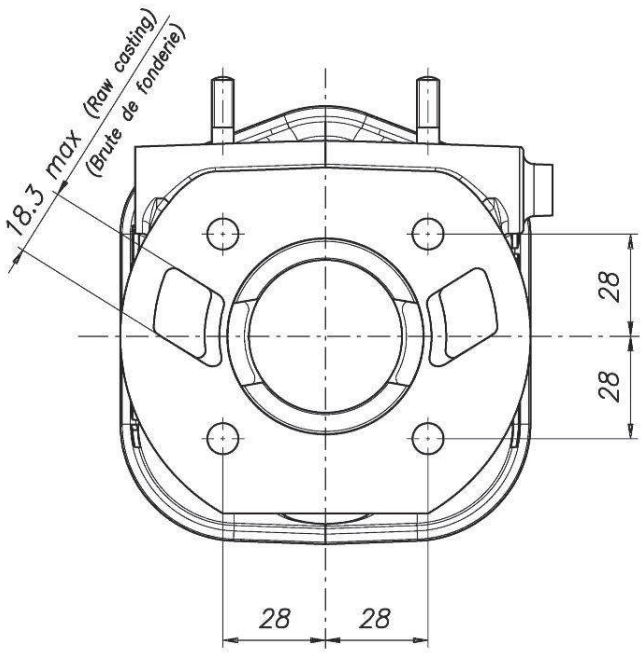
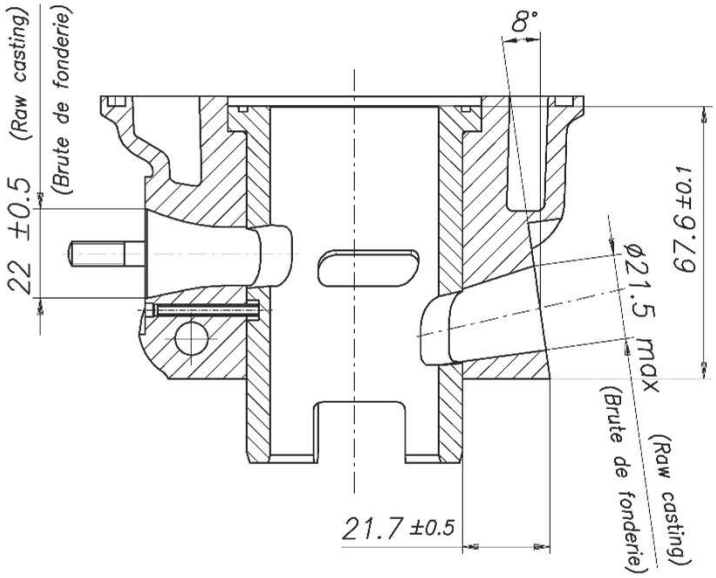


A	28±0.2 mm
B1 = B2	21.8±0.2 mm
C	26±0.2 mm
D	157° max
E	116° ±2°
F	145° max

CHORDAL READING - *LECTURE CORDALE*

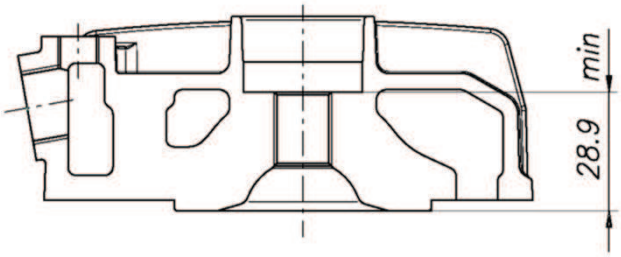
ANGULAR READING BY INSERT A 0.2 mm x 5 mm GAUGE -
LECTURE ANGULAIRE PAR INSERTION D'UNE CALE DE 0.2 mm x 5 mm

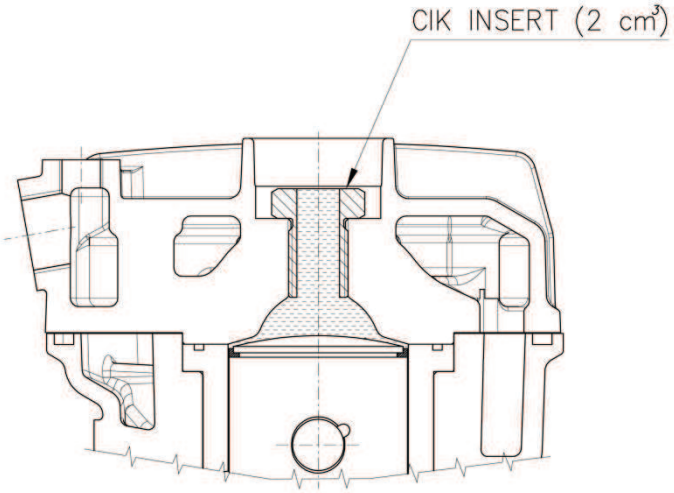
USING IAME TOOL Cod. 10194 – *UTILISER OUTIL*

CYLINDER BASE VIEW *VUE DE LA BASE DU CYLINDRE*	CYLINDER SECTION VIEW *VUE EN SECTION DU CYLINDRE*
	

2023

COMBUSTION CHAMBER VIEW
VUE DE LA CHAMBRE DE COMBUSTION



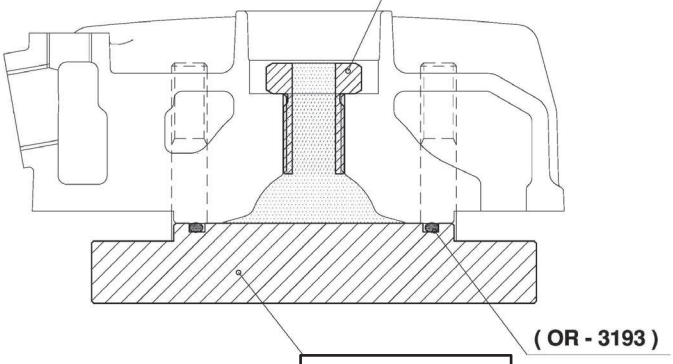


COMBUSTION CHAMBER VOLUME = 6.5 cm³ min.
VOLUME CHAMBRE COMBUSTION

CIK INSERT

SQUISH MIN. = 0.75 mm

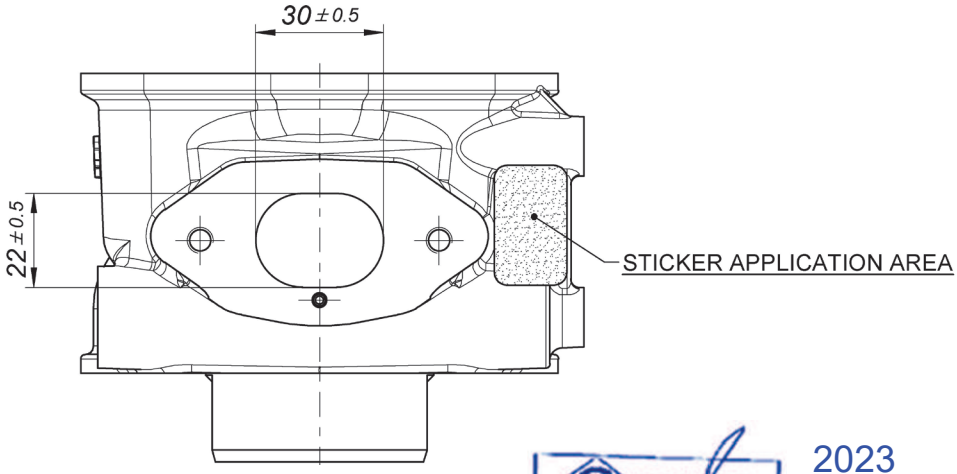
measured with Ø1.5mm TIN
mesurée avec de l'étain Ø1.5mm



VOLUMETER

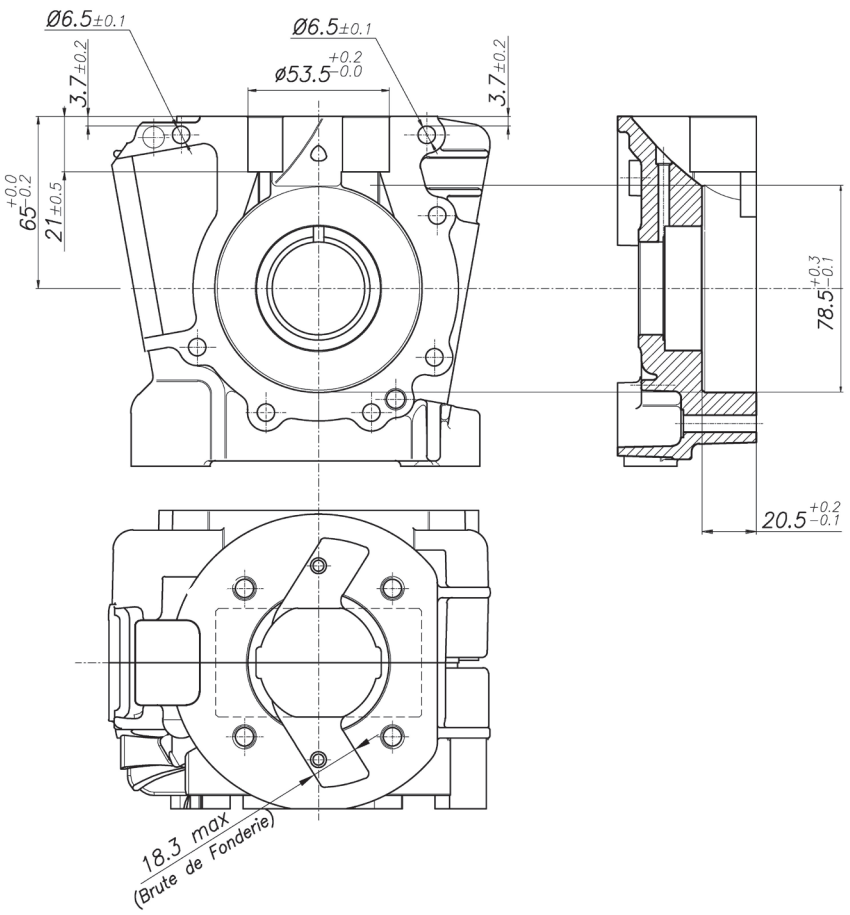
MIN. TOT. VOLUME OF CHAMBER IN THE CYLINDER HEAD = 7,4 cm³
VOLUME MIN. CHAMBRE DE COMBUSTION DANS LA CULASSE

REAR VIEW AND DIMENSION
ARRIERE VUE ET DIMENSION

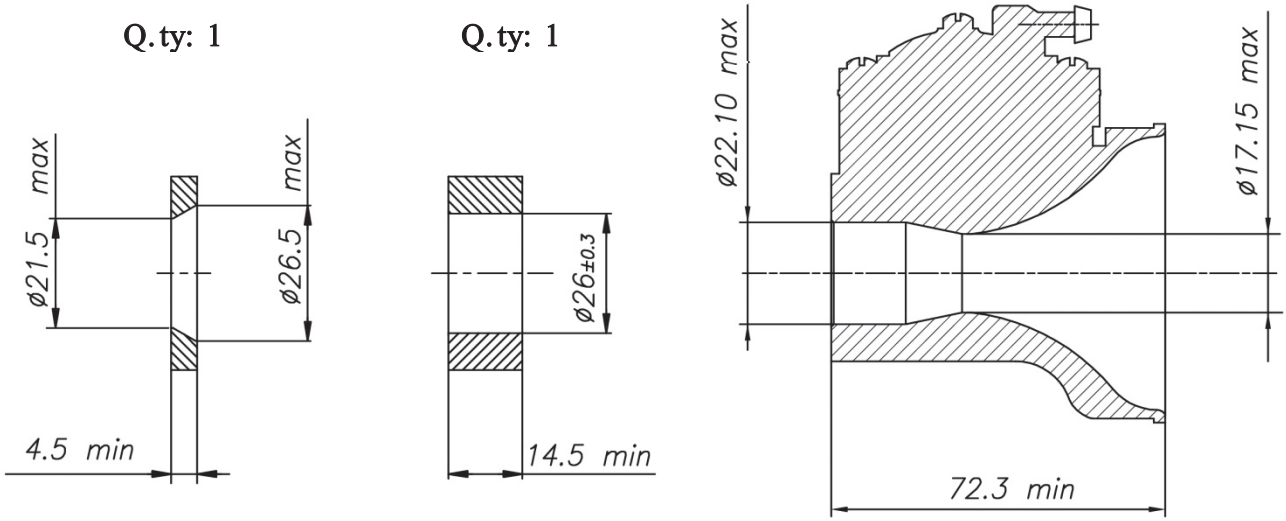


2023

CRANKCASE INSIDE VIEW
VUE A' L'INTERIEUR DU CARTER



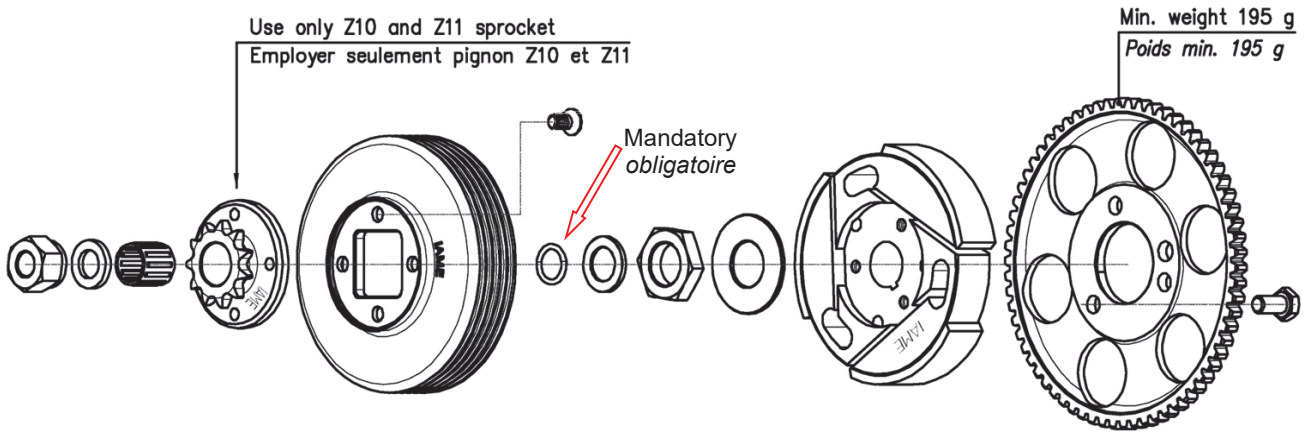
VENTURI CARB. DIMENSIONS and THERMAL SPACERS
CARBURATEUR ET SONS ENTRETOISES



TILLOTSON MOD. HW-31A

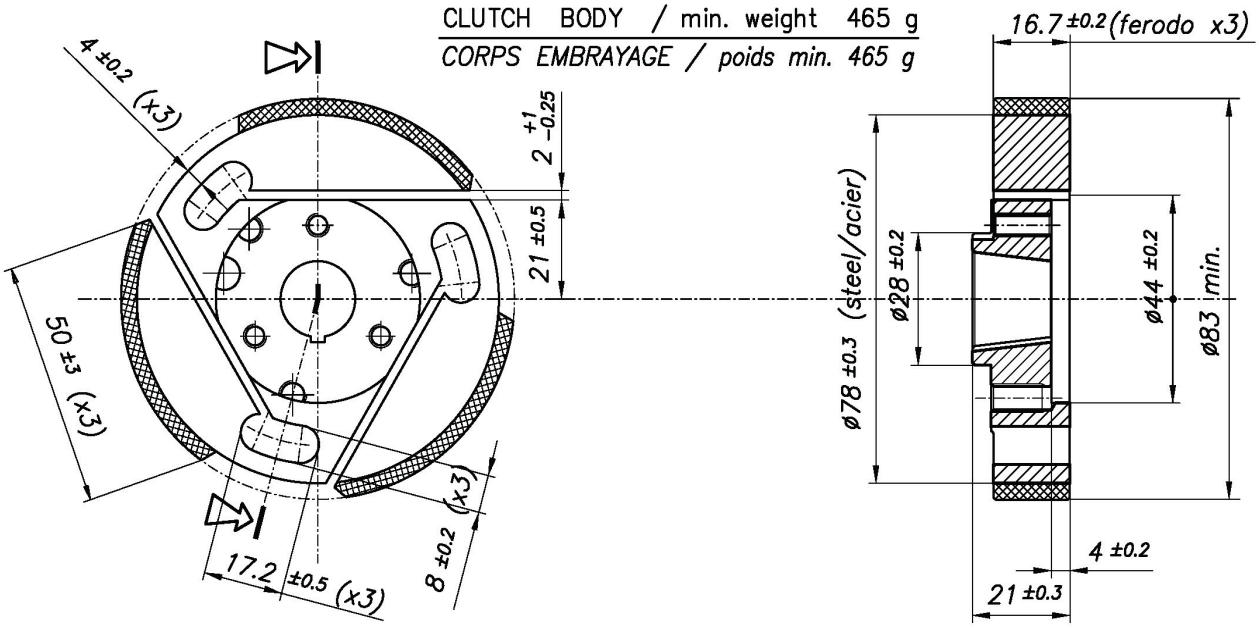
2023

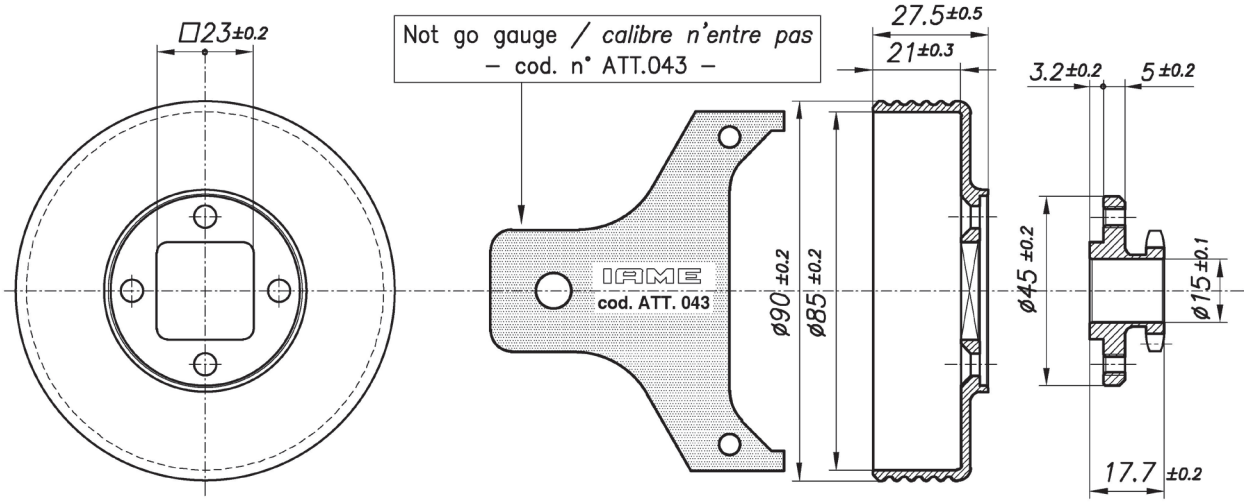
DESCRIPTION OF THE CLUTCH – *DESCRIPTION DE L'EMBRAYAGE*



CLUTCH BODY / min. weight 465 g

CORPS EMBRAYAGE / poids min. 465 g





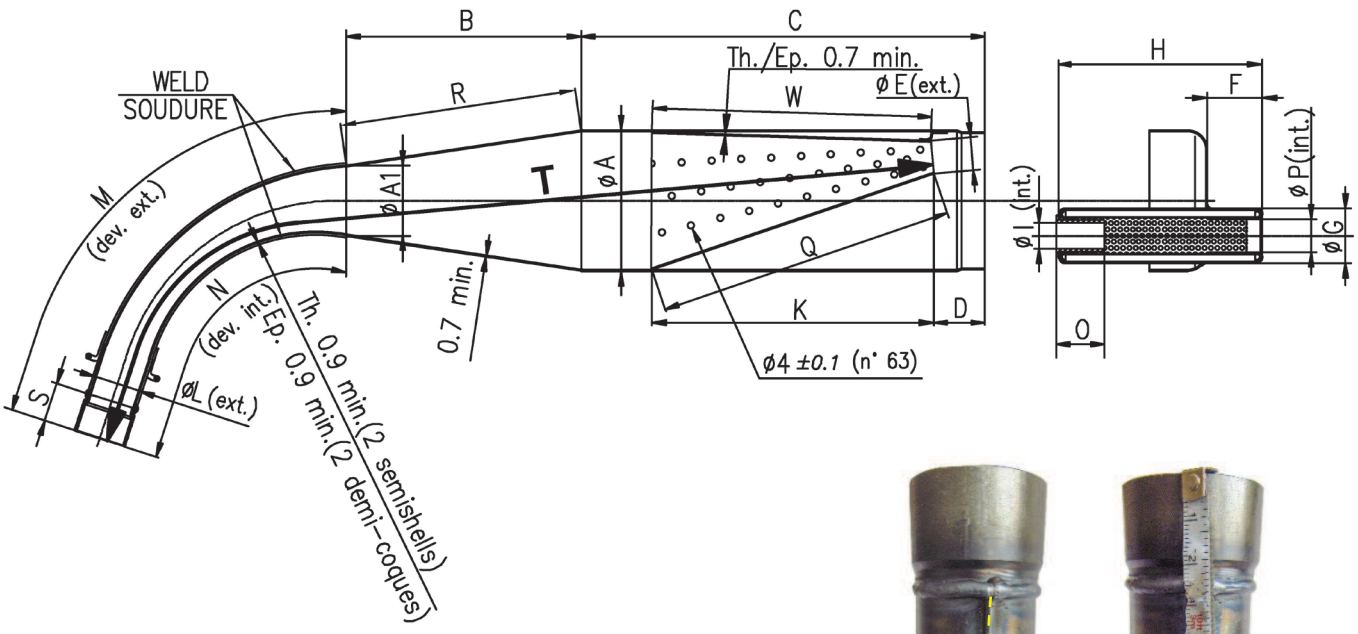
CLUTCH DRUM / min. weight 175 g

CLOCHE D'EMBRAYAGE / poids min. 175 g

DRIVE SPROCKET / min. weight 68 g

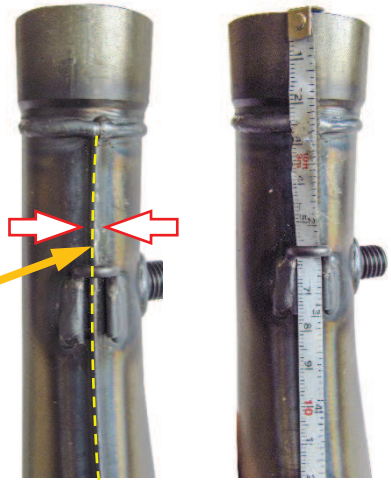
PIGNON / poids min. 68 g

EXHAUST VIEW AND DIMENSIONS (with and without embossed logo)
VUE ET DIMENSIONS DE L'ECHAPPEMENT (avec et sans logo en relief)



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

Le ruban doit suivre l'axe de la soudure en tous points



Min. weight 1250 g
Poids min.

ØA: 90 ±1.5 Øext.	**D:** 30 ±2	**H:** 132 ±2	**M:** 265 ±3	**R:** 152 ±3	**T:** 601 ±3
ØA1: 45 ±1 Øext.	**ØE:** 20 ±1 Øext.	**ØI:** 17 max Øint.	**N:** 215 ±3	**S:** 25 ±1	
B: 150 ±3	**F:** 35 ±2	**K:** 181 ±3	**O:** 30 min.	**Q:** 192 ±3	
C: 260 ±3	**ØG:** 35 ±1 Øext.	**ØL:** 31 ±1.5 Øext.	**ØP:** 21 ±1 Øint.	**W:** 181 ±3	

ATTENTION:

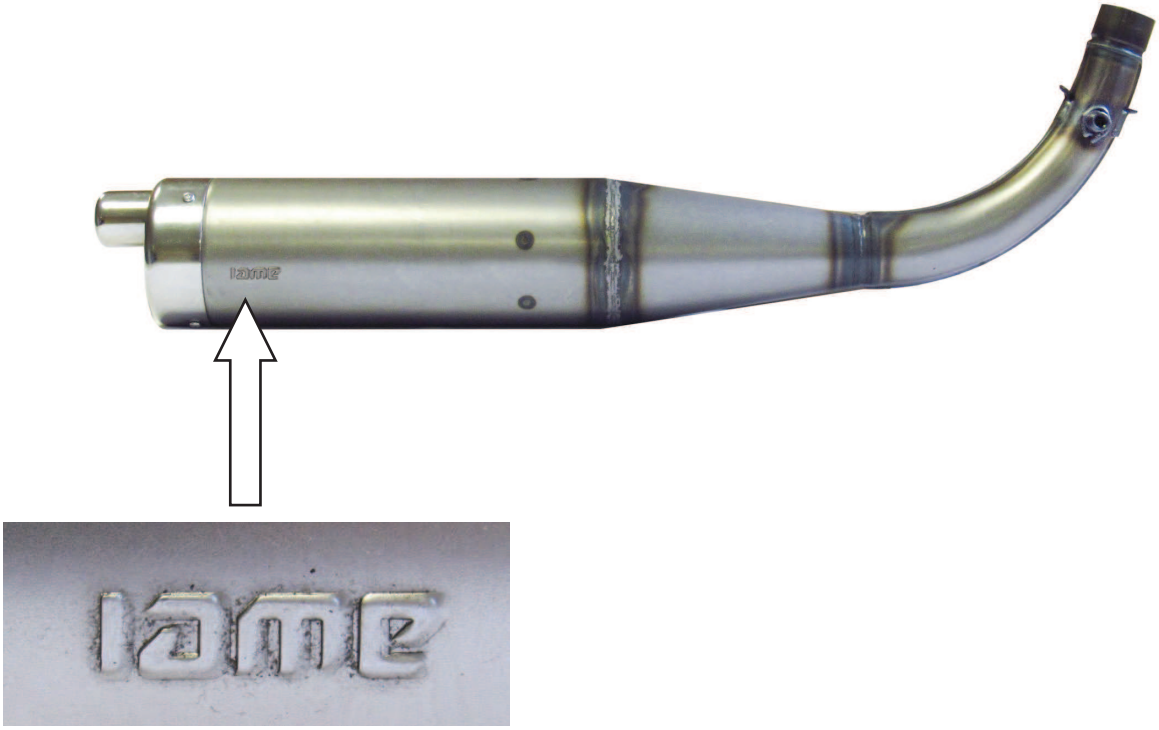
The dimensions "**M**", "**N**" and "**T**" must be taken by steel tape measure 6mm wide.
*Les dimensions « **M** », « **N** » et « **T** » doivent être à l'aide d'un ruban à mesurer en acier 6 mm de large.*

The dimensions "**M**" and "**N**" must be taken on the weld centerline.
*Les dimensions « **M** », « **N** » doivent être prises sur l'axe de la soudure.*

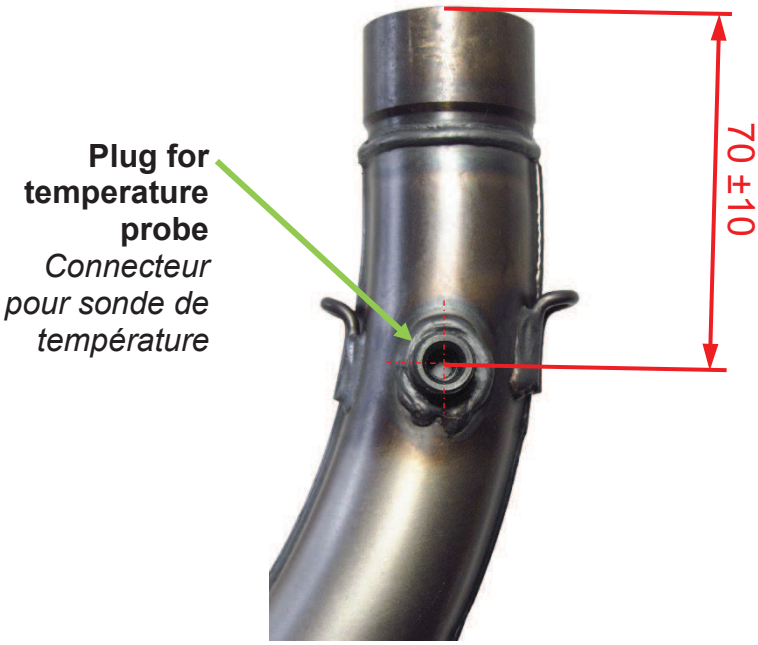
The dimensions "**Q**" and "**W**" must be taken by steel tape measure 12mm wide.
*Les dimensions « **Q** » et « **W** » doivent être prises à l'aide d'un ruban à mesurer en acier 12 mm de large.*

2023

ALTERNATIVE EXHAUST MUFFLER with embossed logo
ECHAPPEMENT ALTERNATIVE avec logo en relief



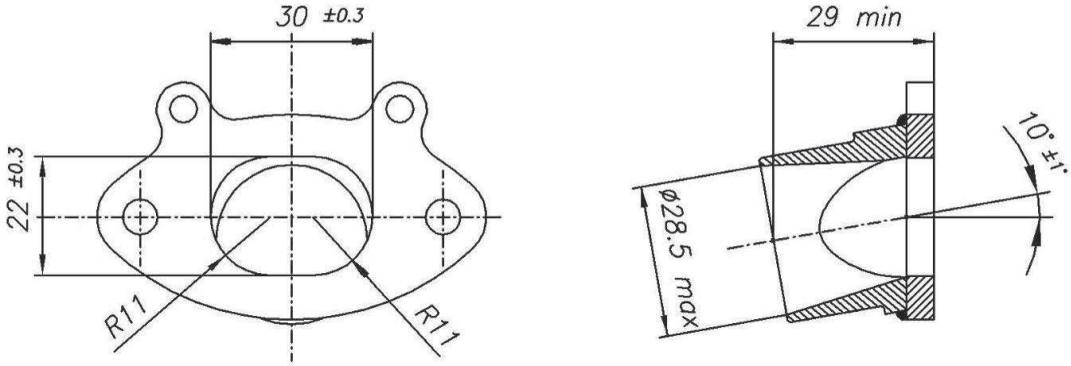
MARKING / MARQUAGE



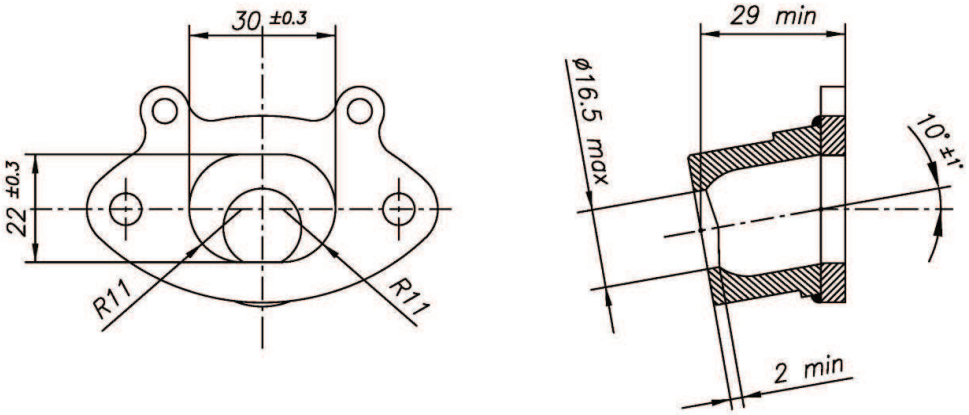
Plug for temperature probe
Connecteur pour sonde de température

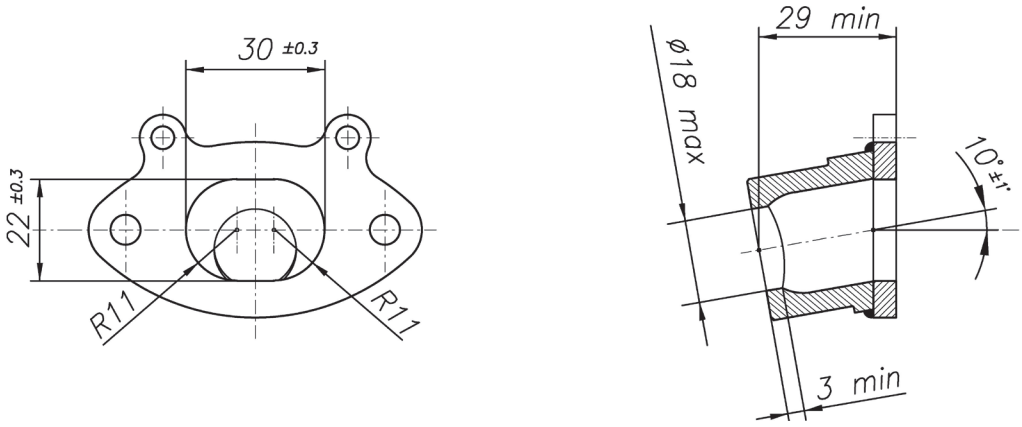
2023

EXHAUST MANIFOLD
RACCORD D'ÉCHAPPEMENT



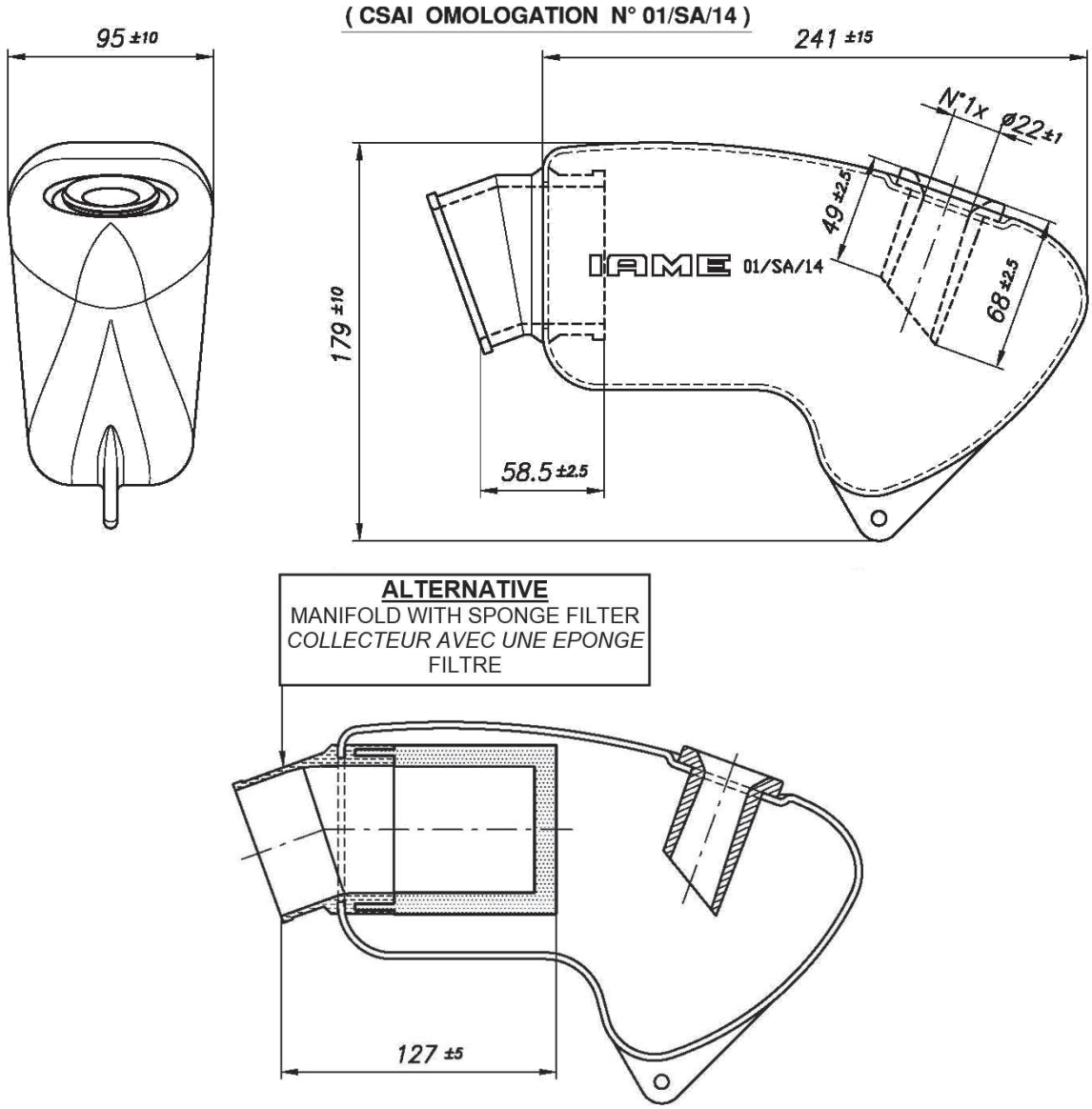
EXHAUST MANIFOLDS WITH RESTRICTED
RACCORDS AVEC RECSTRICTEUR D'ÉCHAPPEMENT





SPORT 2023

INLET SILENCER – *SILENCIEUX D'ASPIRATION*



INLET SILENCER - PHOTO
PHOTO - SILENCIEUX D'ASPIRATION

2023

WIRING DIAGRAM
SCHÉMA CIRCUIT ÉLECTRIQUE

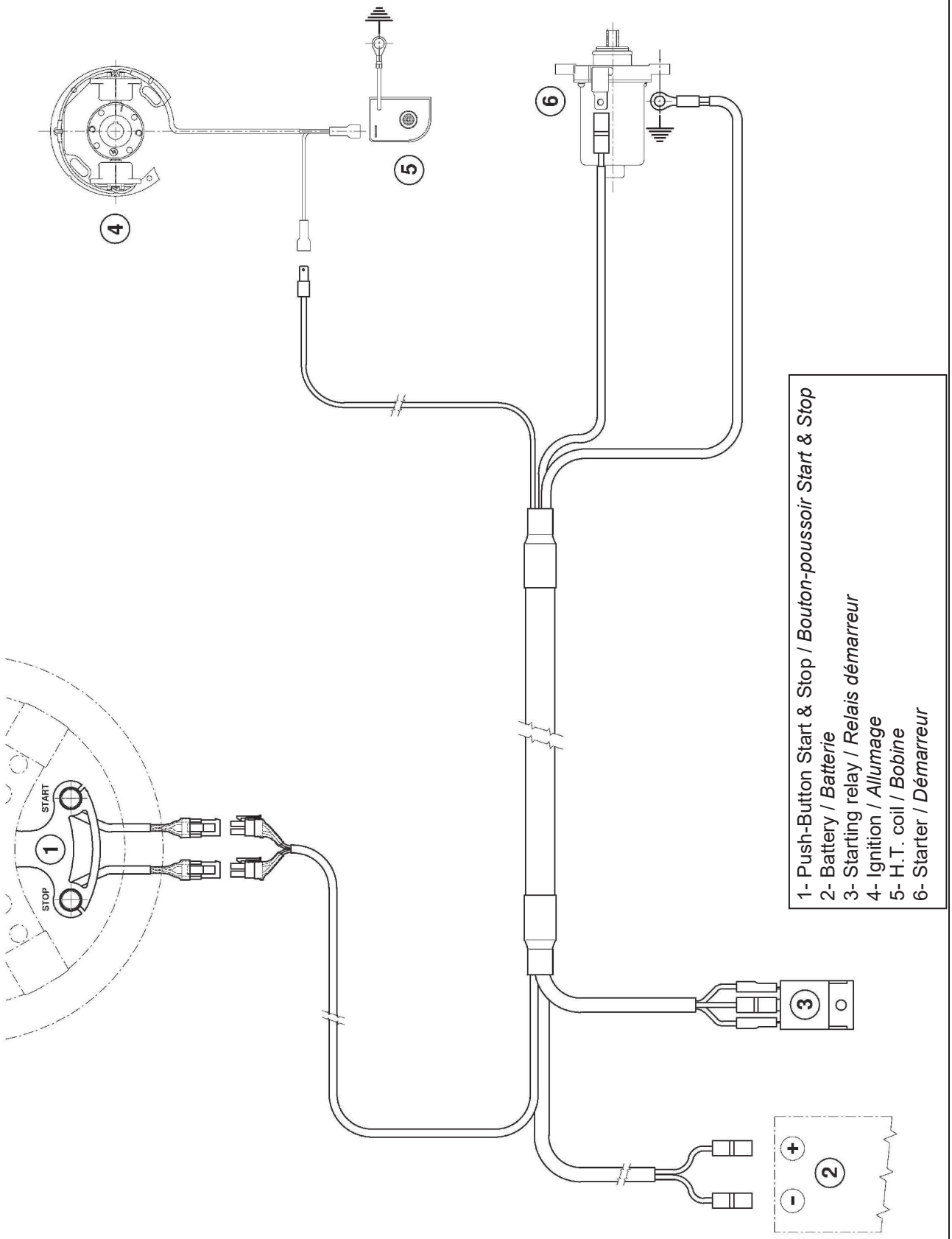


PHOTO COMPLETE WIRING
PHOTO DU CÂBLAGE ÉLECTRIQUE COMPLÈTE

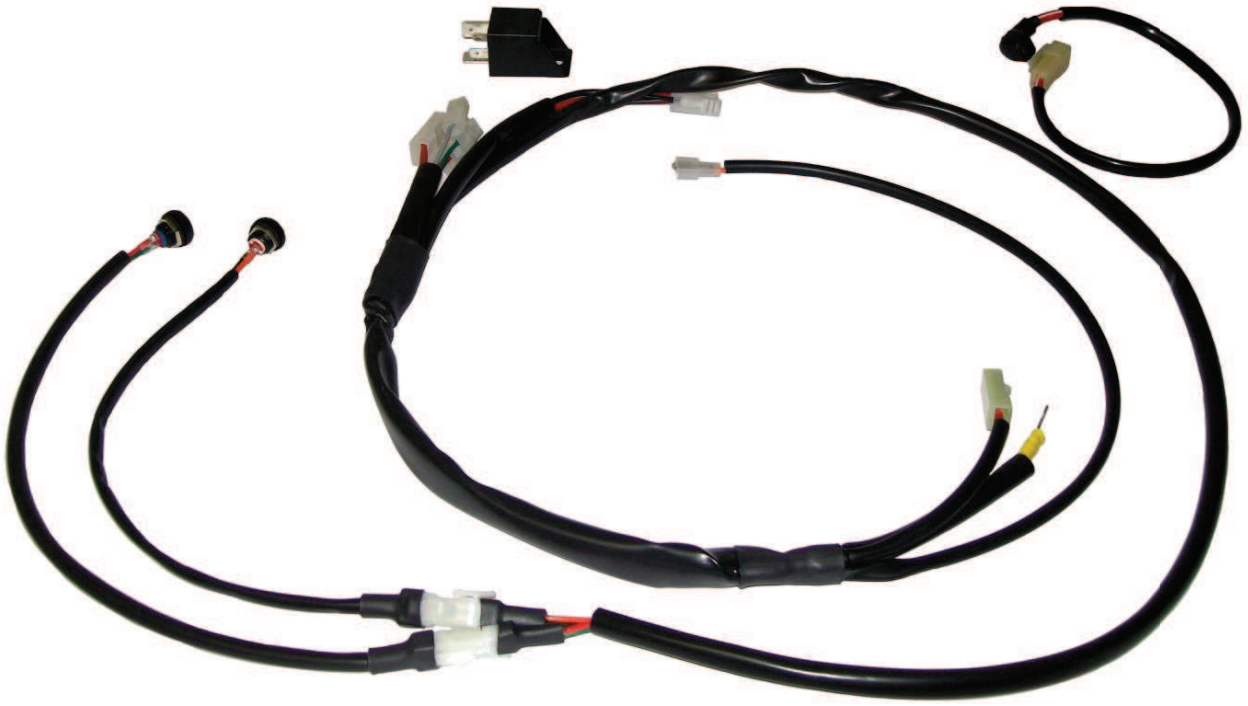
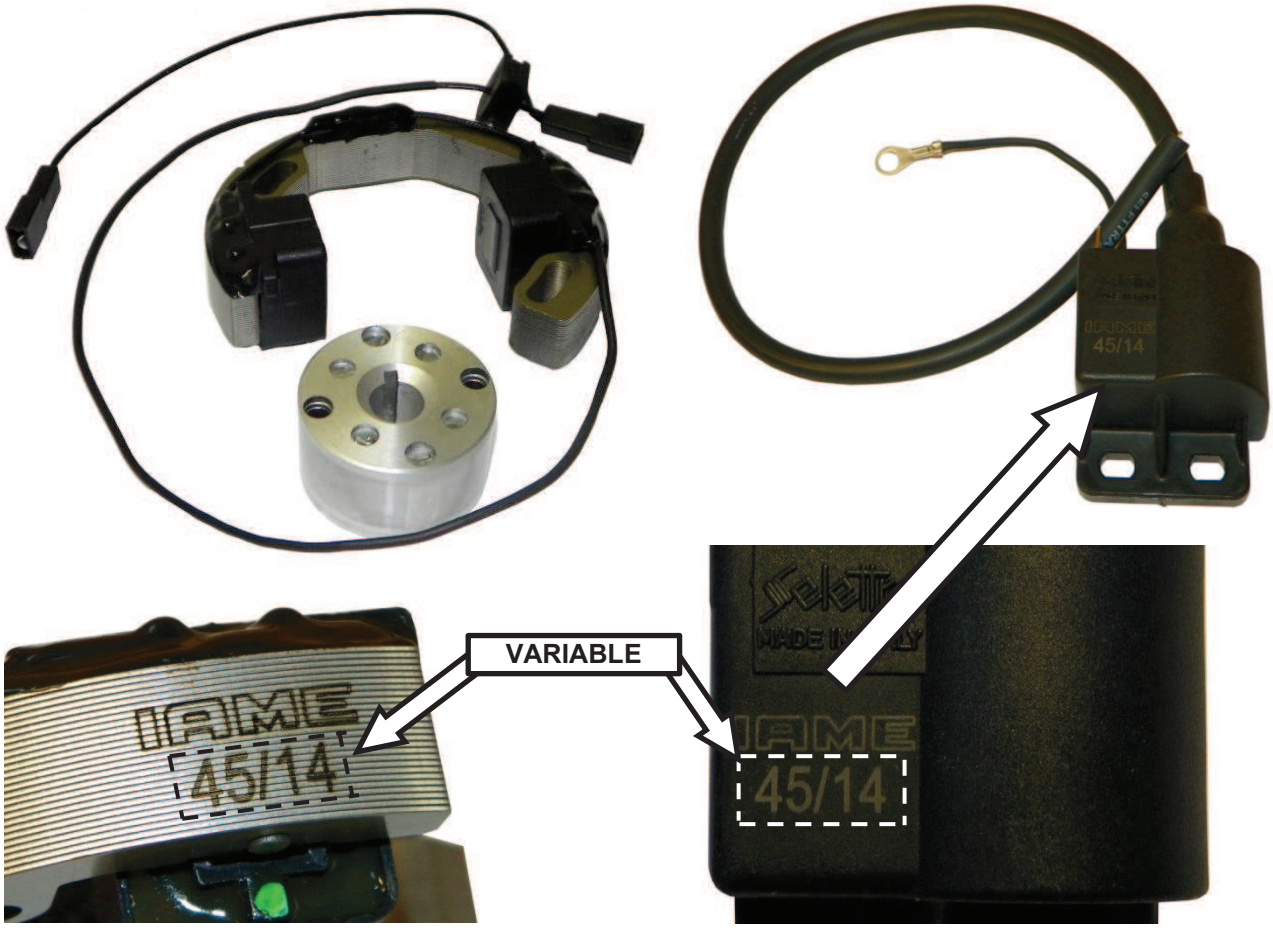


PHOTO IGNITION / PHOTO H.T. COIL (SELETTRA ANALOGUE 2 POLES)
PHOTO ALLUMAGE / PHOTO BOBINE (SELETTRA ANALOGIQUE 2 POLES)



ALTERNATIVE WIRING LOOM DIAGRAM
SCHÉMA CIRCUIT ÉLECTRIQUE ALTERNATIF

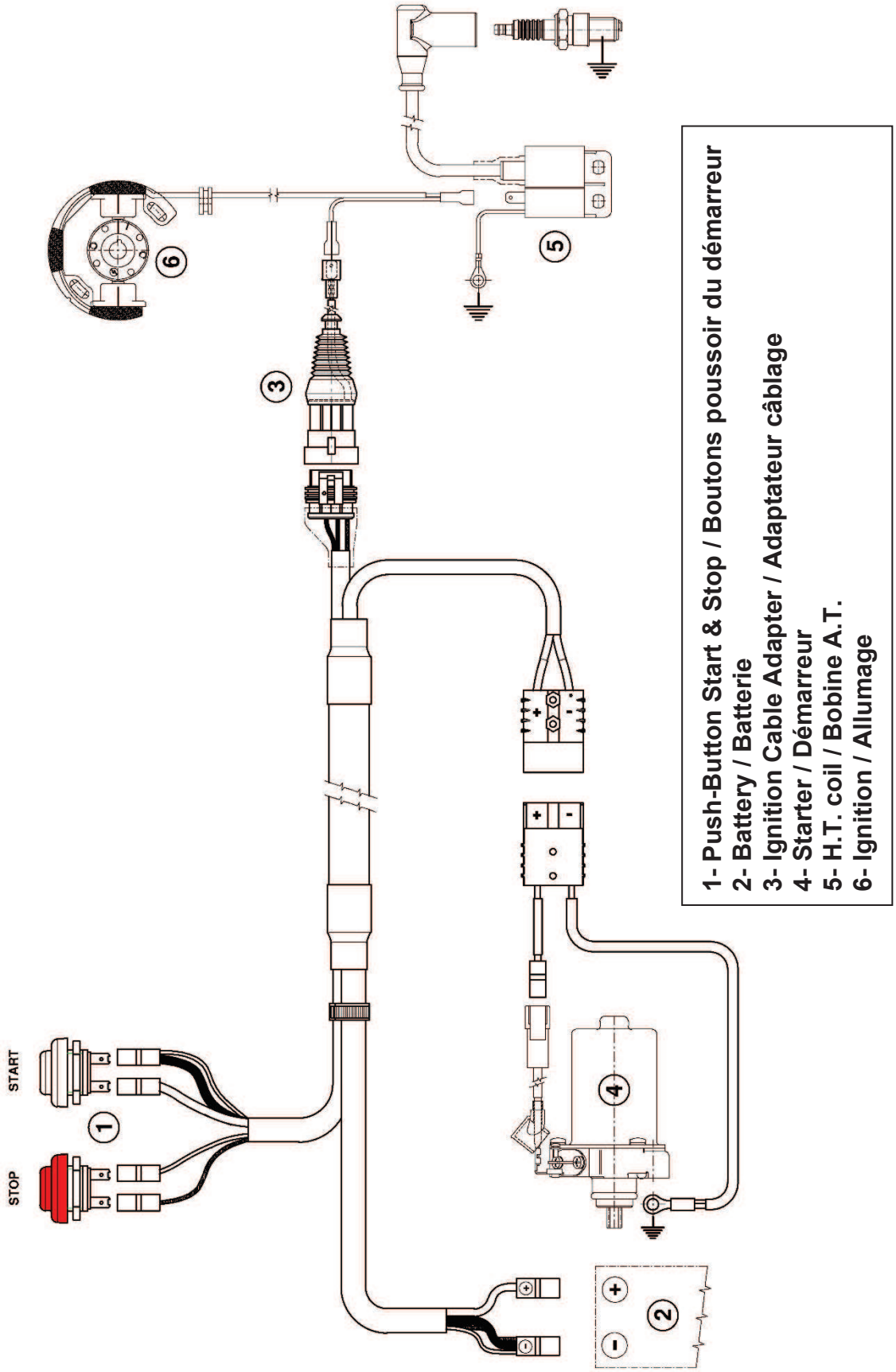
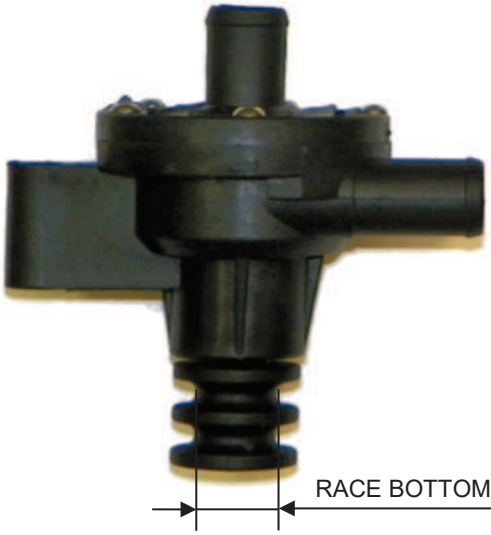


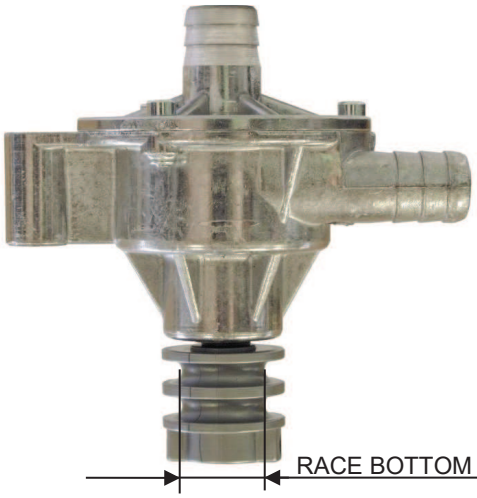
PHOTO OF ALTERNATIVE COMPLETE WIRING LOOM
PHOTO DU CÂBLAGE ÉLECTRIQUE COMPLÈTE ALTERNATIF

2023

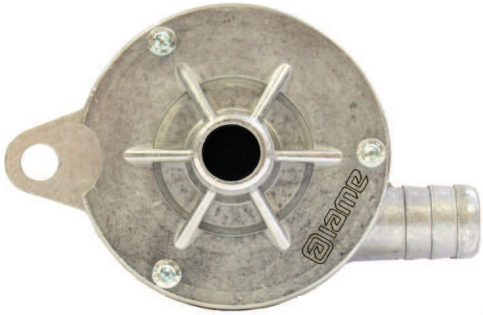


PLASTIC

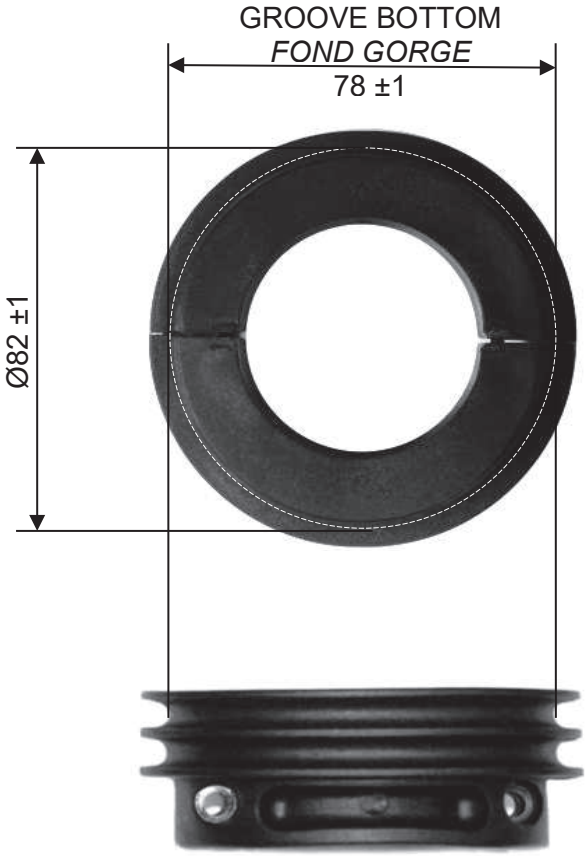
ALTERNATIVE



ALUMINUM



PULLEY ALTERNATIVE – ALTERNATIVE DU POULIE



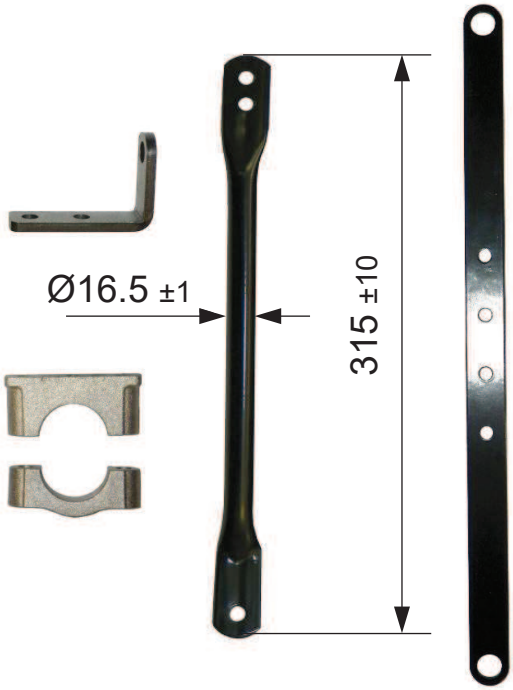
PLASTIC

ALTERNATIVE

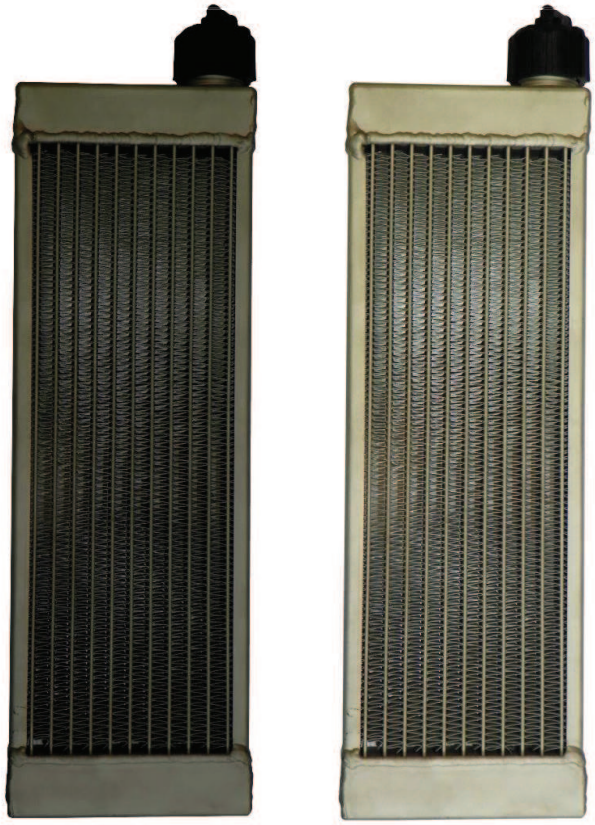
ALUMINUM

2023

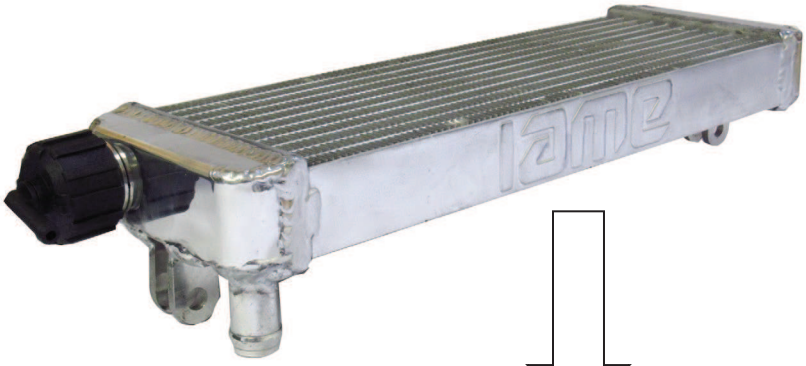
RADIATOR AND ITS SUPPORTS
RADIATEUR ET SES SUITIEN



PAINTED AND NOT PAINTED
PEINT ET PAS PEINT

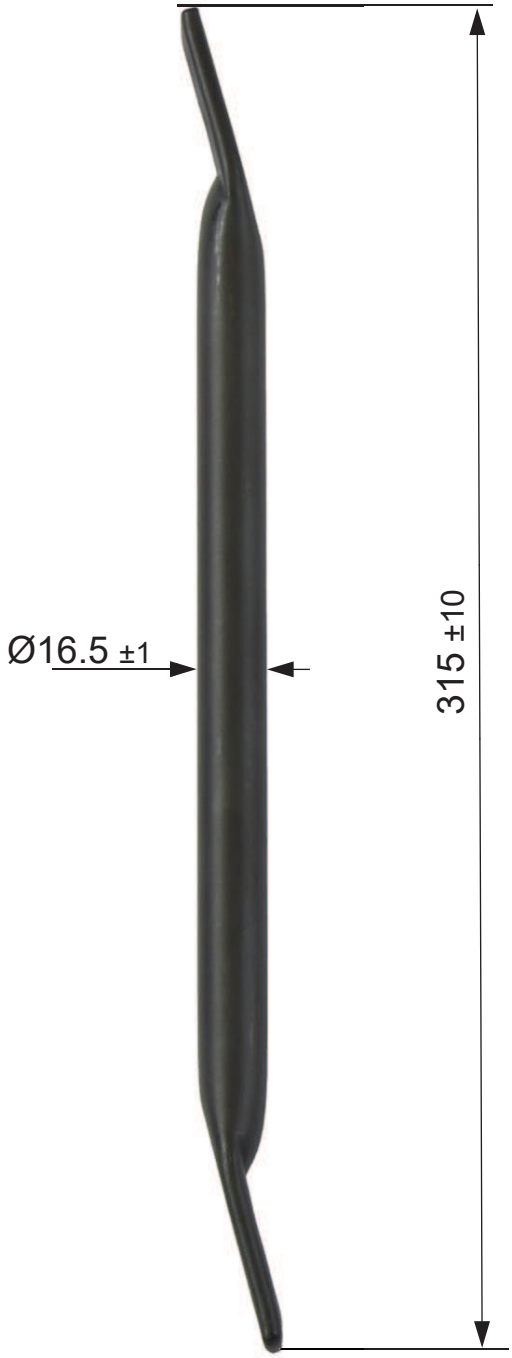


ALTERNATIVE RADIATOR
RADIATEUR ALTERNATIF

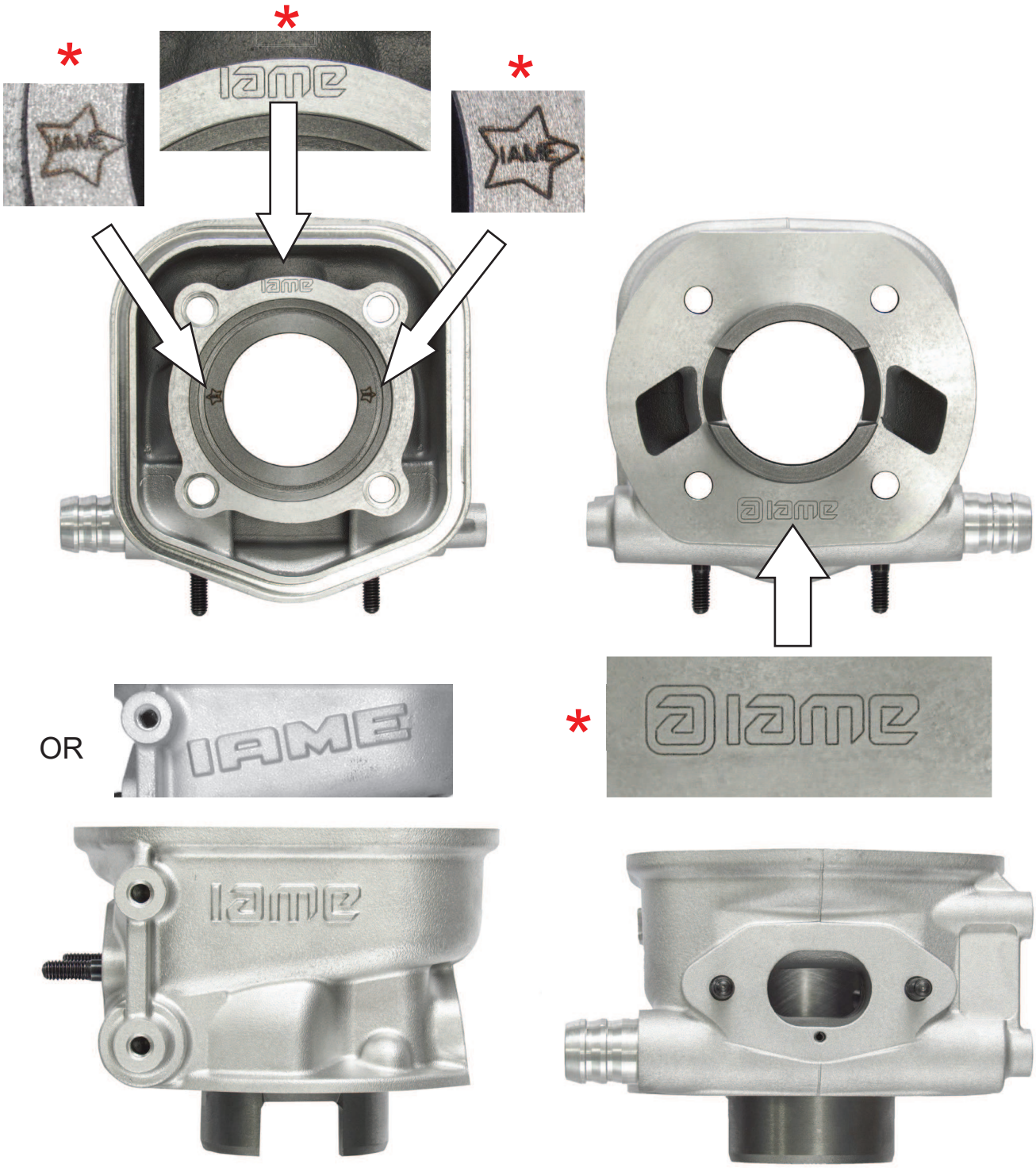


2023

ALTERNATIVE RADIATOR SUPPORT
ALTERNATIVE SUITIEN DU RADIATEUR

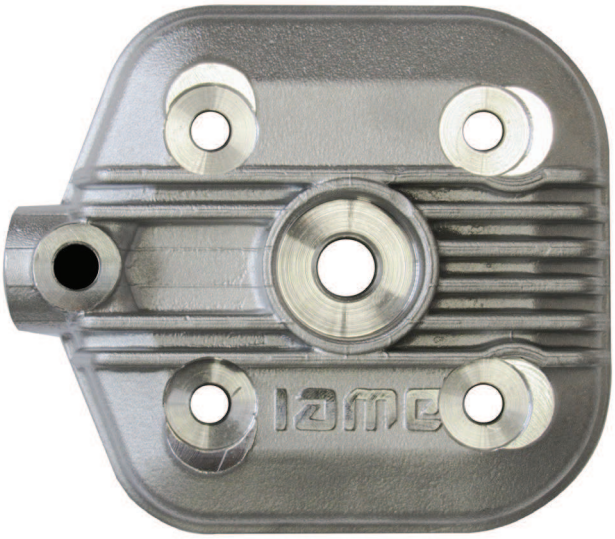


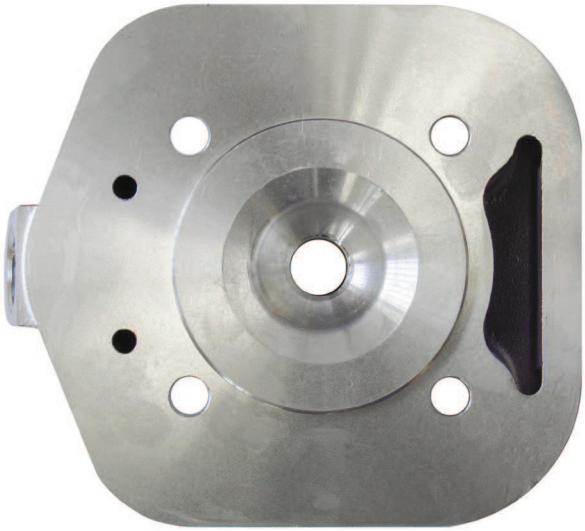
CYLINDER IDENTIFICATION MARKING
MARQUAGE D'IDENTIFICATION DU CYLINDRE



* Compulsory from engine n. 011150
Obligatoire à partir du moteur no. 011150

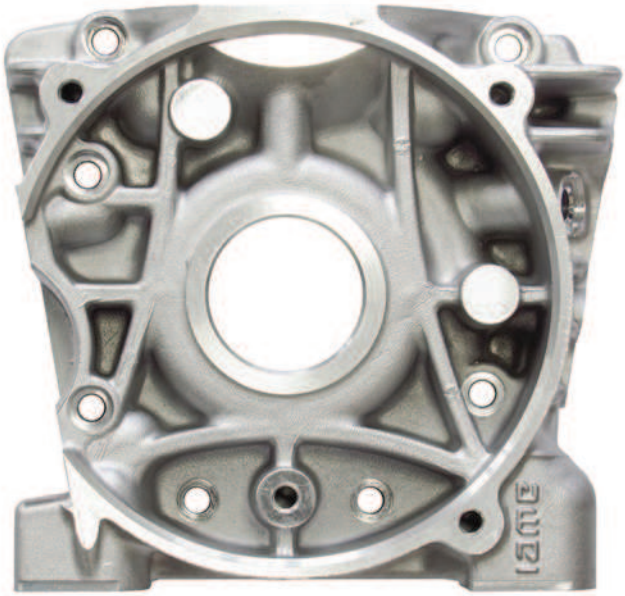
CYLINDER HEAD MARKING
MARQUAGE D'IDENTIFICATION DU CULASSE



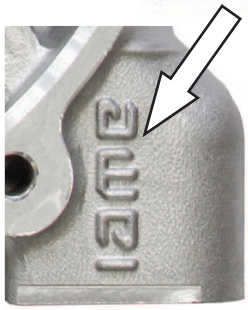


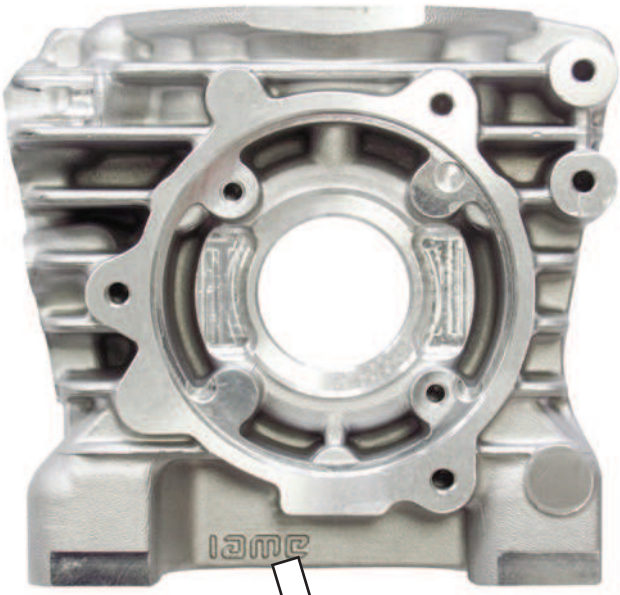
OR

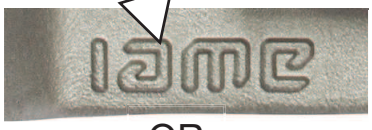
SEMICARTER TRANSMISSION SIDE *SEMICARTER CÔTÉ PIGNON*	SEMICARTER IGNITION SIDE *SEMICARTER CÔTÉ ALLUMAGE*



OR







OR

PISTON IDENTIFICATION MARKING
MARQUAGE D'IDENTIFICATION PISTON

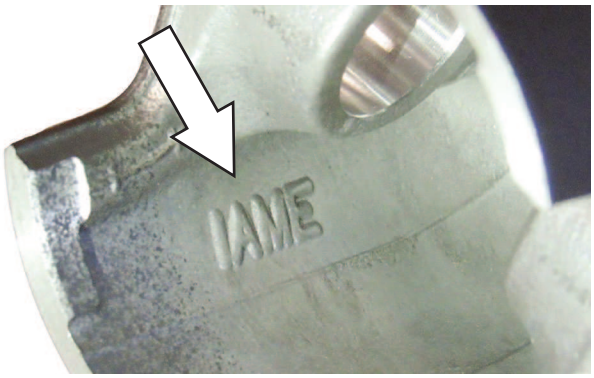
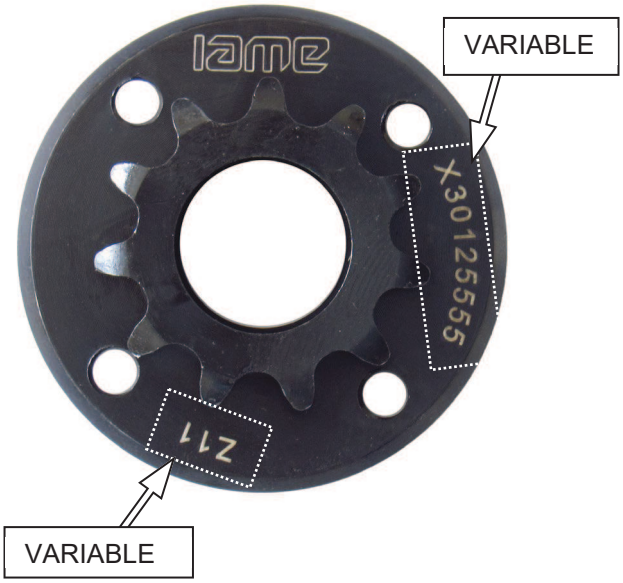
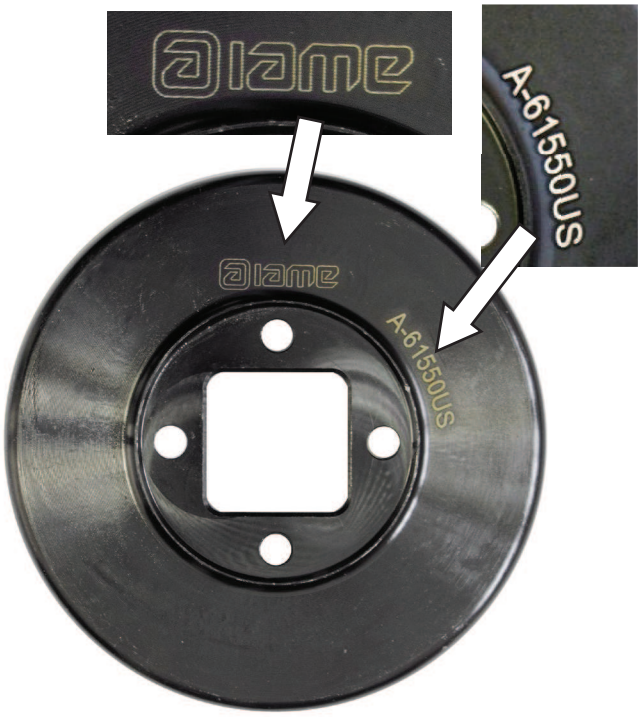


PHOTO IDENTIFICATION OF CONROD – TYPES ALTERNATIVE
PHOTO D' IDENTIFICATION DE LA BIELLE – TYPES ALTERNATIFS

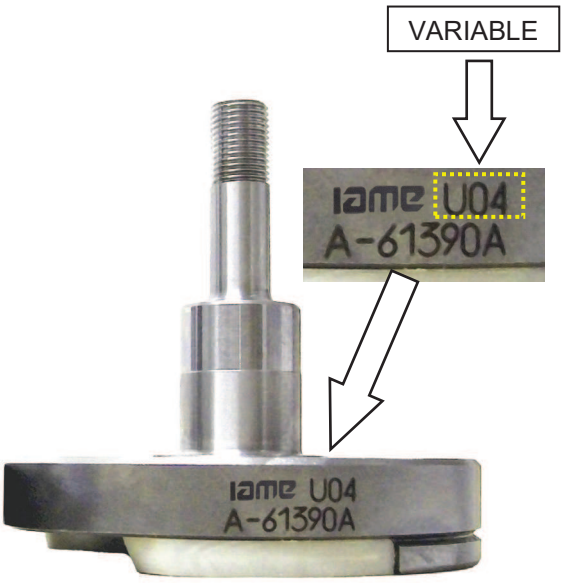
TYPE 1

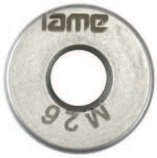
TYPE 2

2023

SPROCKET IDENTIFICATION MARKING *MARQUAGE D'IDENTIFICATION DU PIGNON*	CLUTCH DRUM IDENTIFICATION MARKING *MARQUAGE D'IDENTIFICATION DE LA CALOTTE*
	
CLUTCH BODY IDENTIFICATION MARKING *MARQUAGE D'IDENTIFICATION DU CORPS DE L'EMBRAYAGE*	STARTER RING IDENTIFICATION MARKING *MARQUAGE D'IDENTIFICATION DE LA COURONNE DE DEMARRAGE*

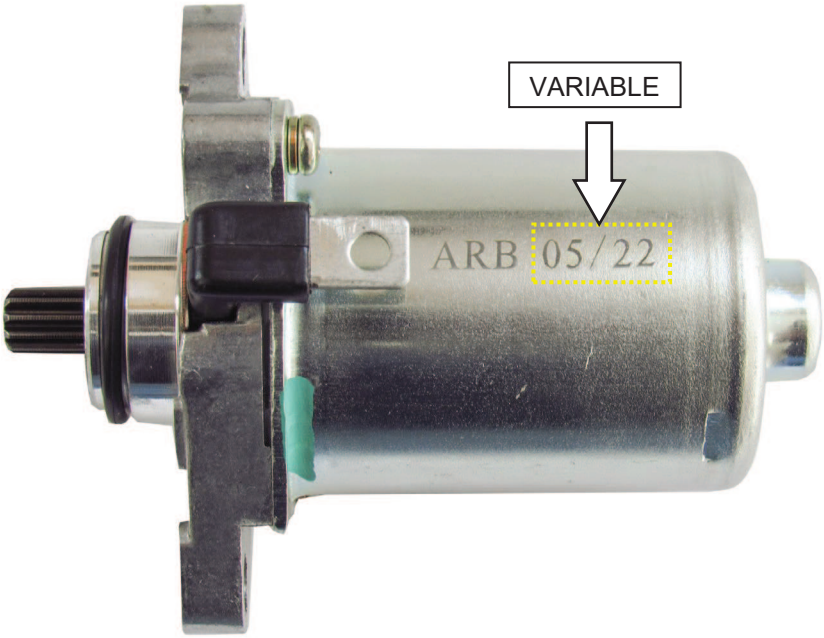
CRANKSHAFT AND HIS COMPONENTS IDENTIFICATION MARKING
MARQUAGE D'IDENTIFICATION DU VILEBREQUIN ET SES COMPOSANTS





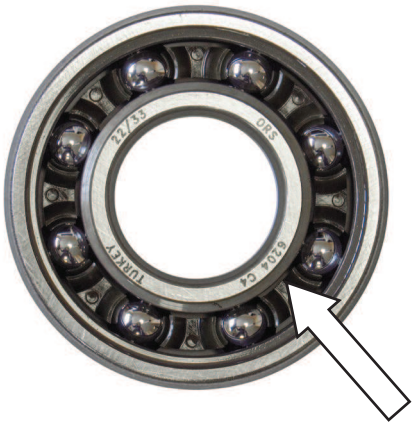
BENDIX COVER IDENTIFICATION MARKING
MARQUAGE D'IDENTIFICATION DU COUVERCLE DU CONTRE-ARBRE DE DEMARRAGE

STARTER IDENTIFICATION MARKING
MARQUAGE D'IDENTIFICATION DU DEMARREUR



2023

PHOTO IDENTIFICATION: SMALL & BIG END CONROD BEARING AND MAIN BEARING
PHOTO D'IDENTIFICATION DU ROULEMENT PIED/TÊTE DE BIELLE ET PRINCIPAUX



EXHAUST IDENTIFICATION MARKING without embossed logo
MARQUAGE D'IDENTIFICATION ECHAPPEMENT sans logo en relief

2023

IGNITION COVER *COUVERCLE DU ALLUMAGE*	CLUTCH COVER *COUVERCLE D'EMBRAYAGE*
OR	OR

INLET FILTER
SILENCIEUX D'ASPIRATION

OR

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»

or

IAME

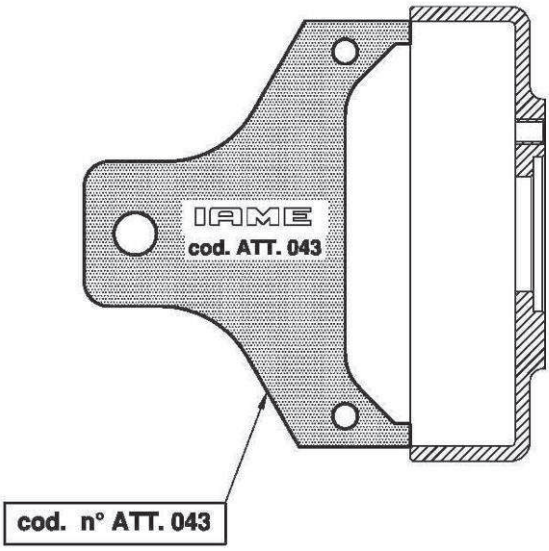
NOW COULD BE MARKED WITH NEW LOGO "IAME"
MAINTENANT POURRAIT EST MARQUAGE AVEC UN NOUVEAU LOGO "IAME"

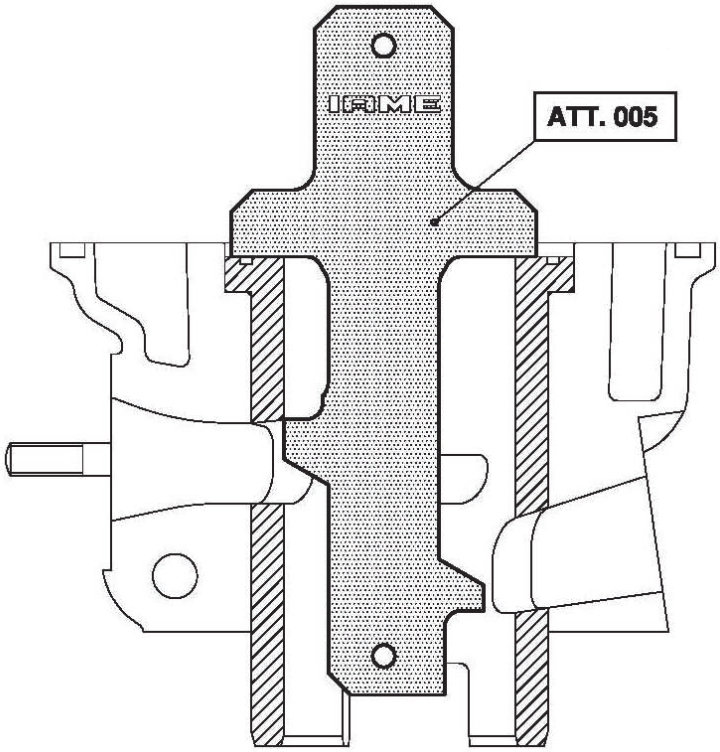
or

or

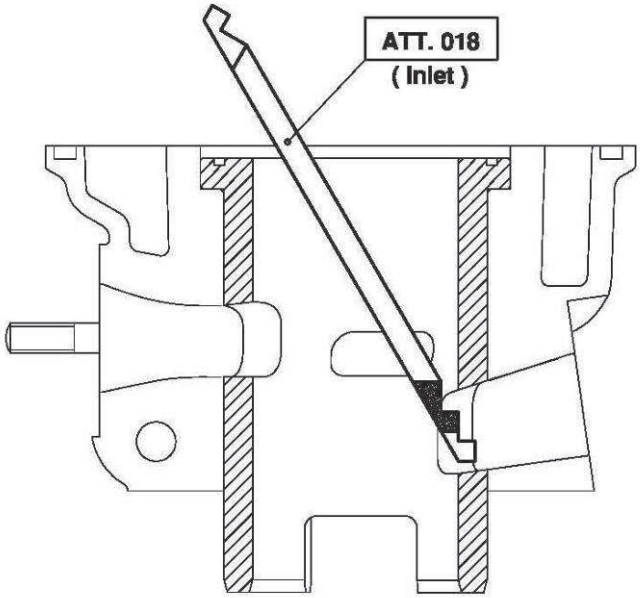
2023

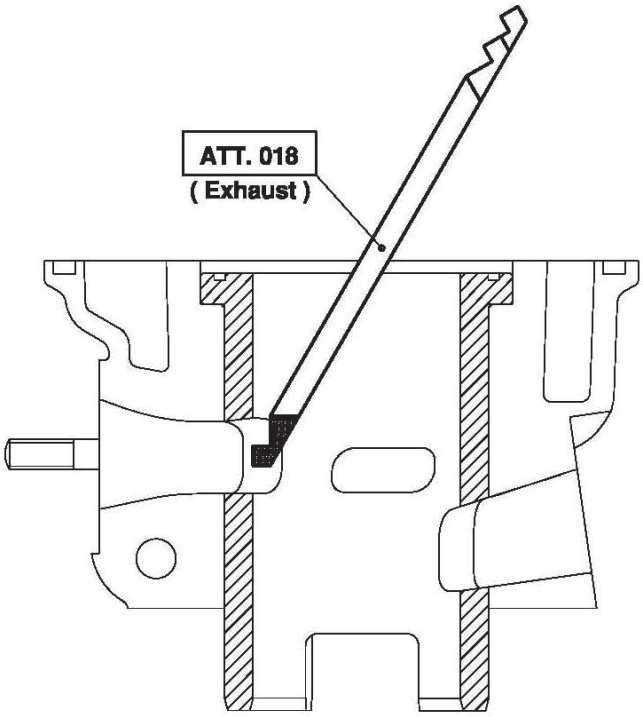
NO GO GAUGES
OUTILS N'ENTRE PAS DANS

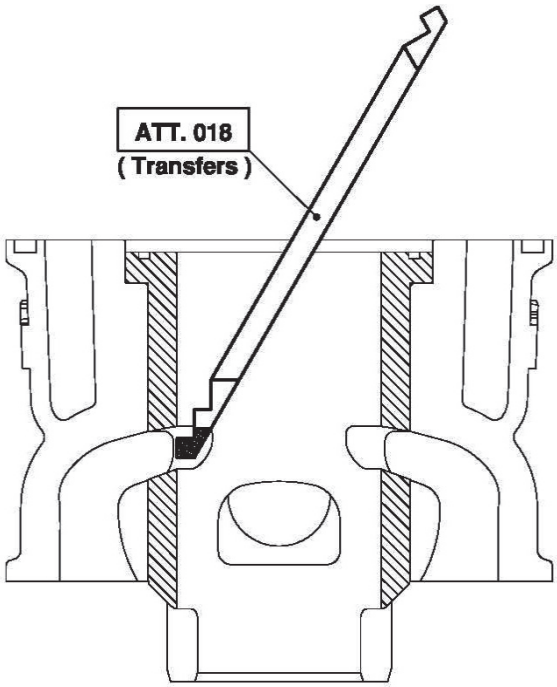




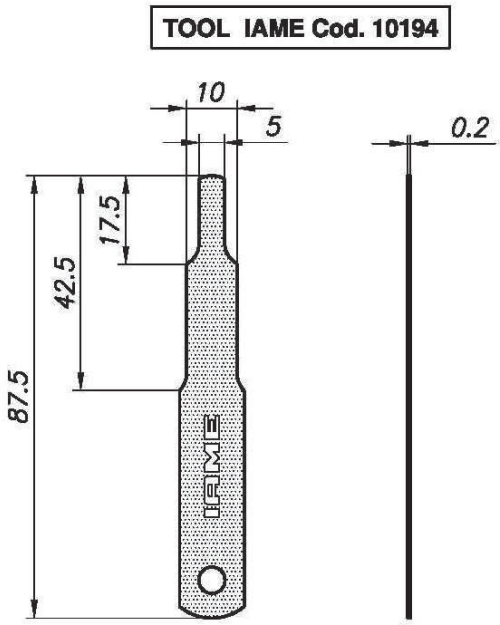
NO GO GAUGES
OUTILS N'ENTRE PAS DANS

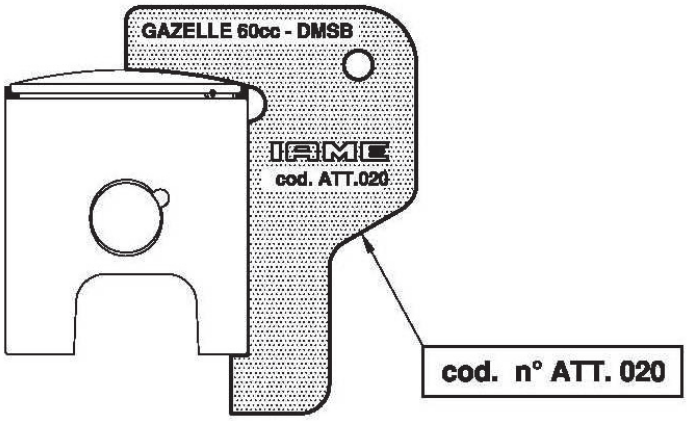


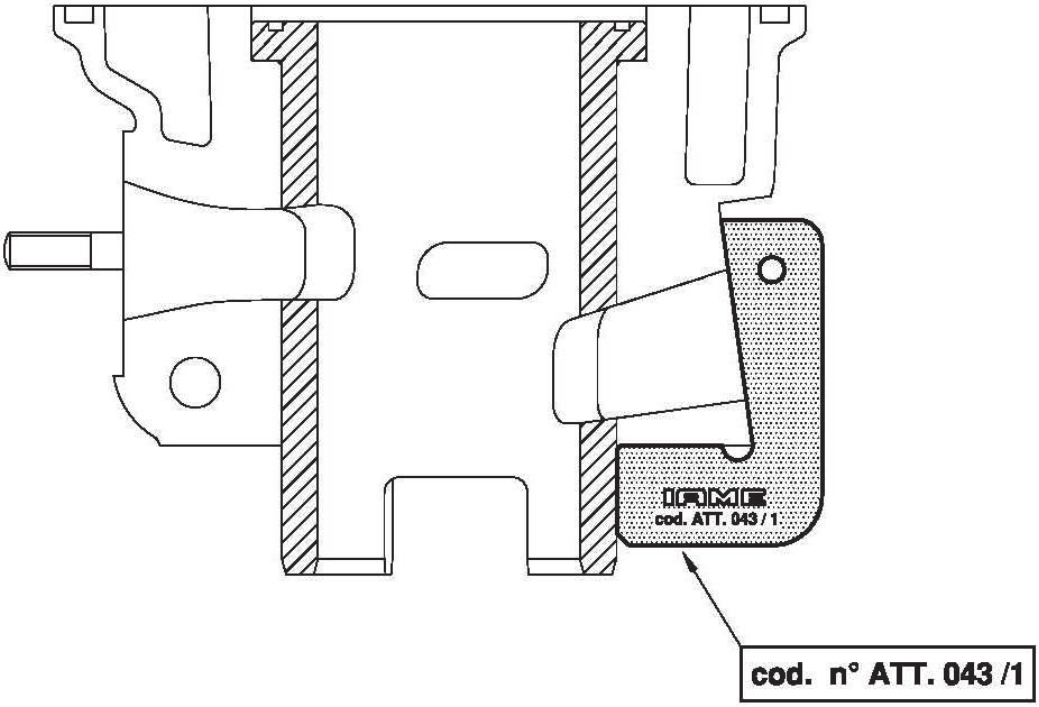




CONTROL GAUGES
OUTILS DE CONTROLL

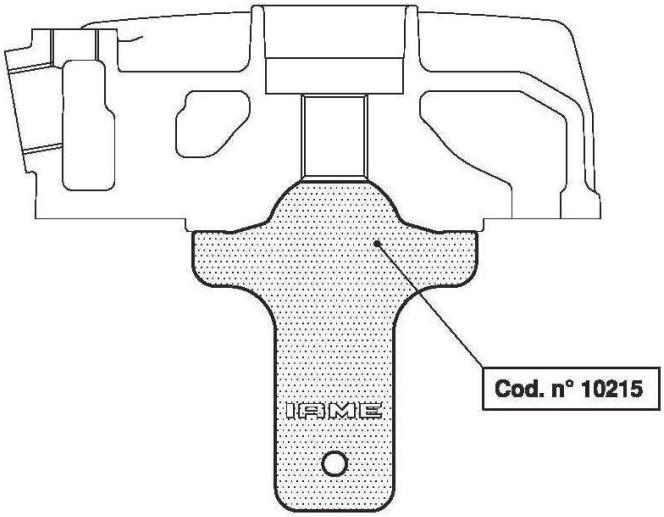


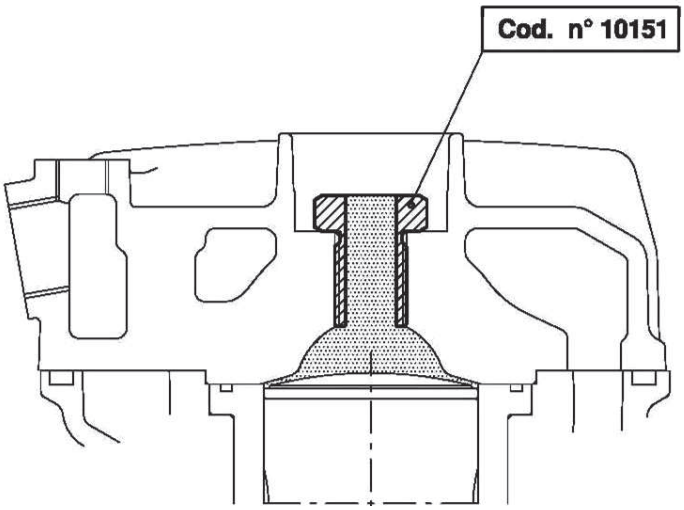


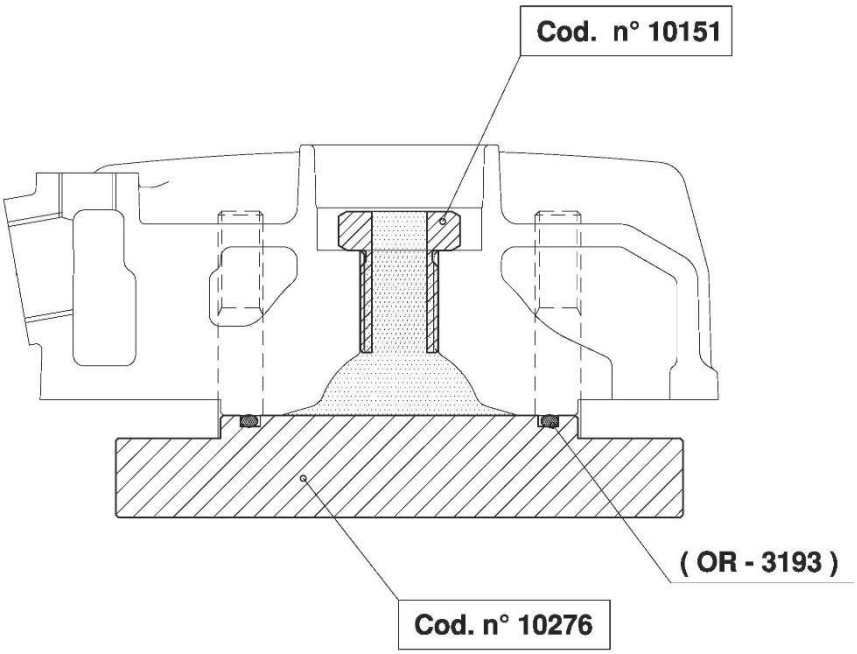


2023

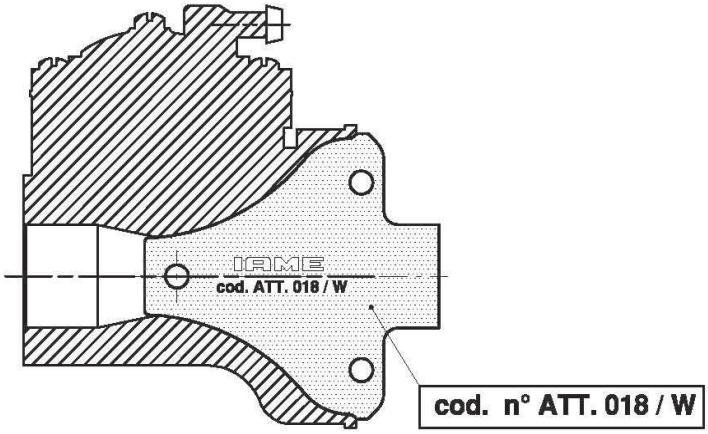
CONTROL GAUGES
OUTILS DE CONTROLL



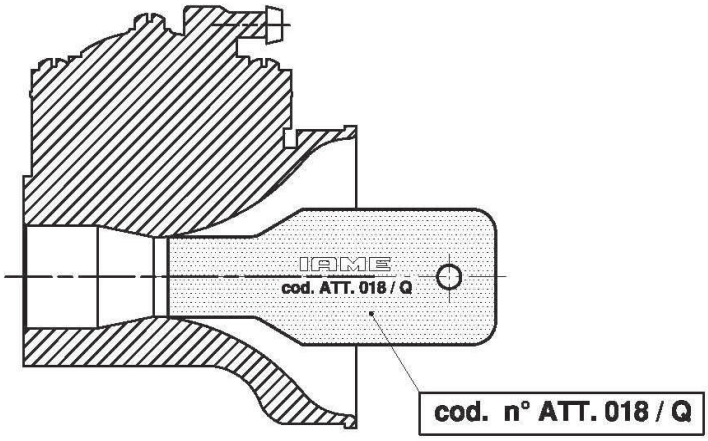




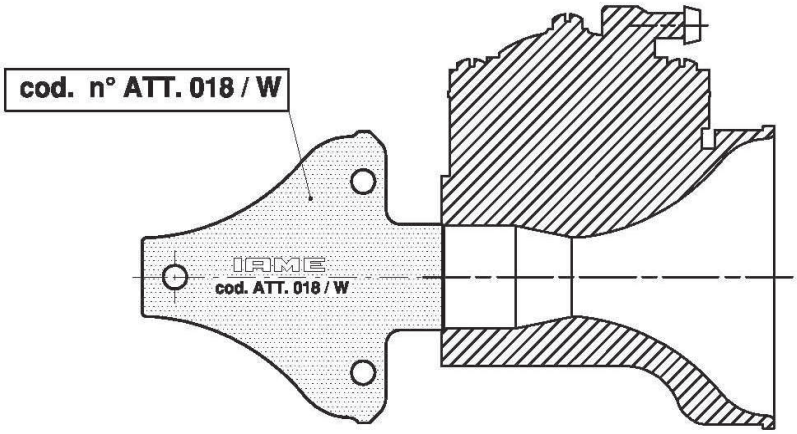
CONTROL GAUGES
OUTILS DE CONTROLL



Check that the tool must be the same shape of the inlet carburettor.
Vérifier que l'outil doit avoir la même forme que l'admission du carburateur.

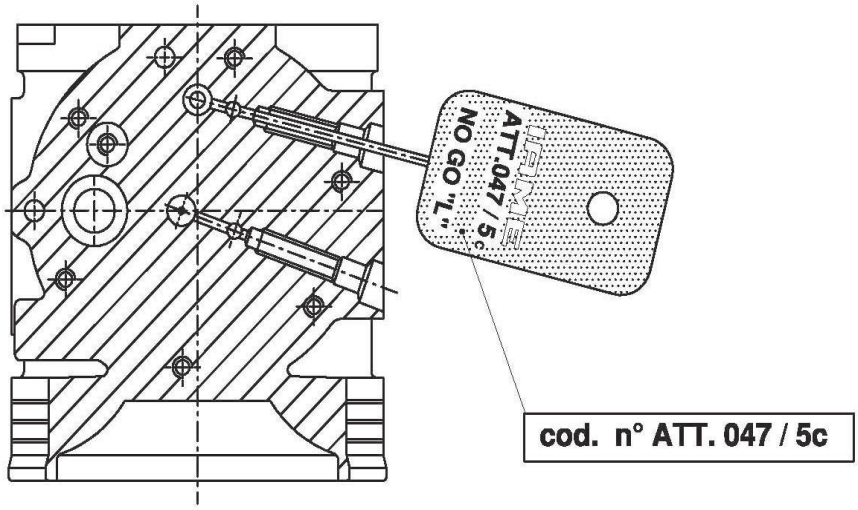


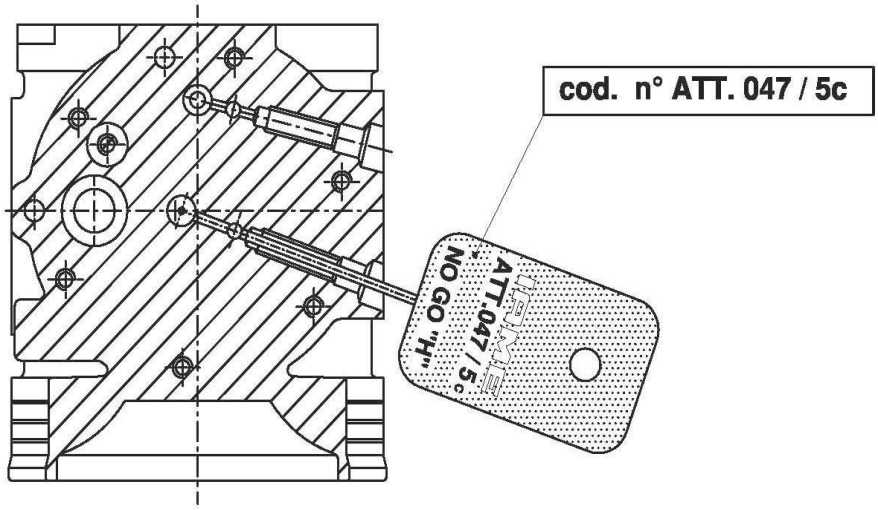
Check that the tool does not enter into the venture duct inlet of carburettor.
Vérifier que l'outil n'entre pas dans l'entrée du conduit Venturi du carburateur.



Check that the tool does not enter into the venture duct outlet of carburettor.
Vérifier que l'outil n'entre pas dans la sortie du conduit Venturi du carburateur.

CONTROL GAUGES
OUTILS DE CONTROLL

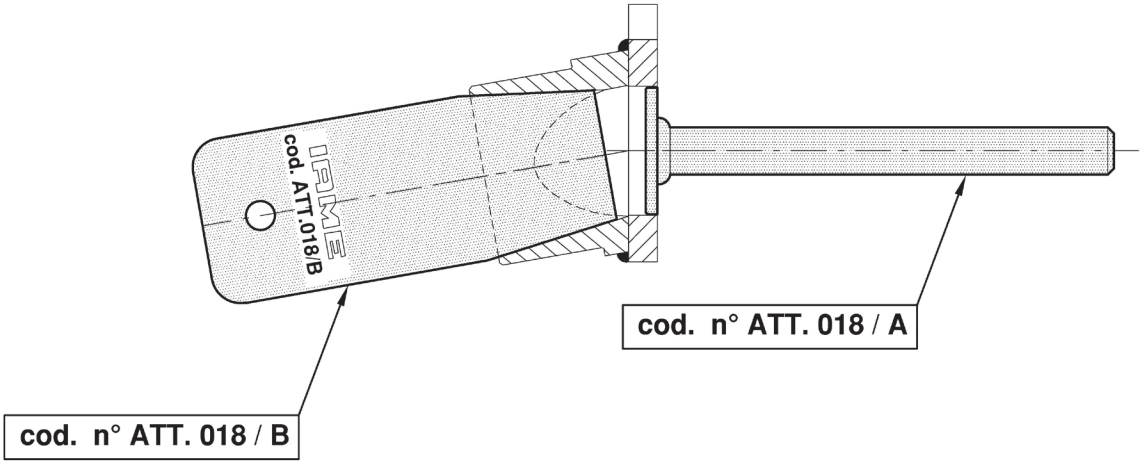


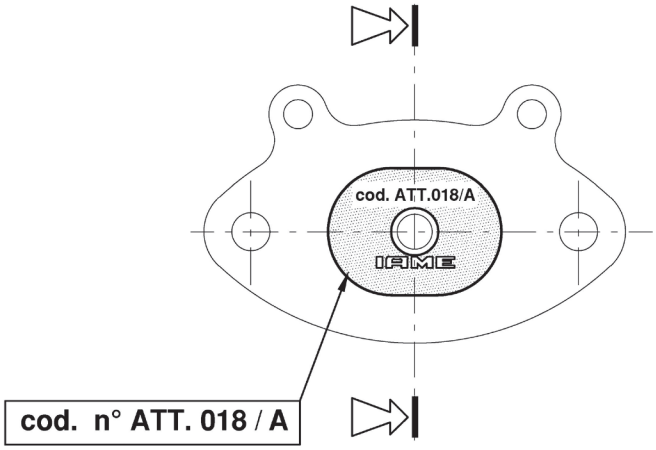


Check that the spikes does not enter into the holes.
Vérifiez que les pointes n'entrent pas dans les trous.

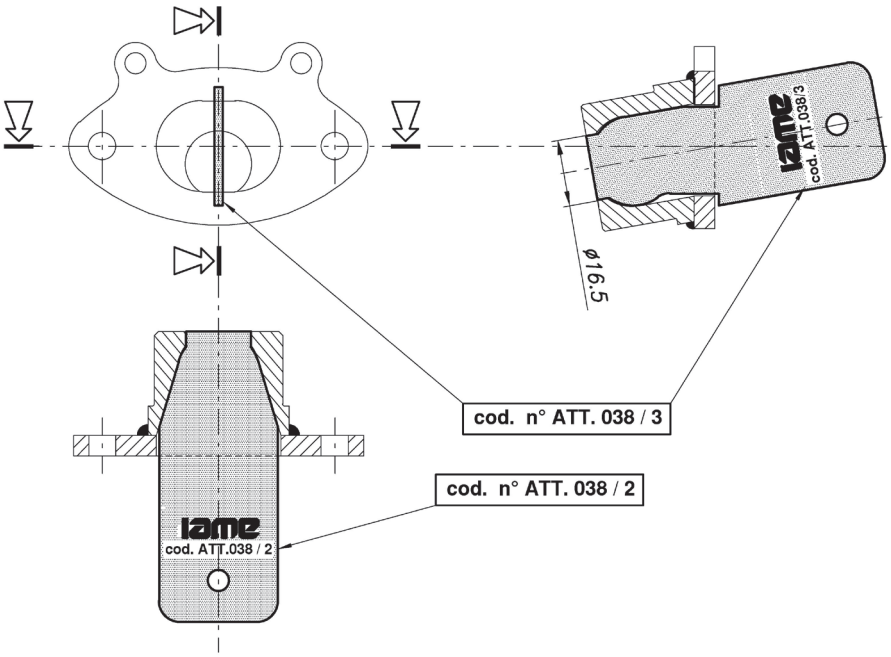
2023

CONTROL GAUGES
OUTILS DE CONTROLL

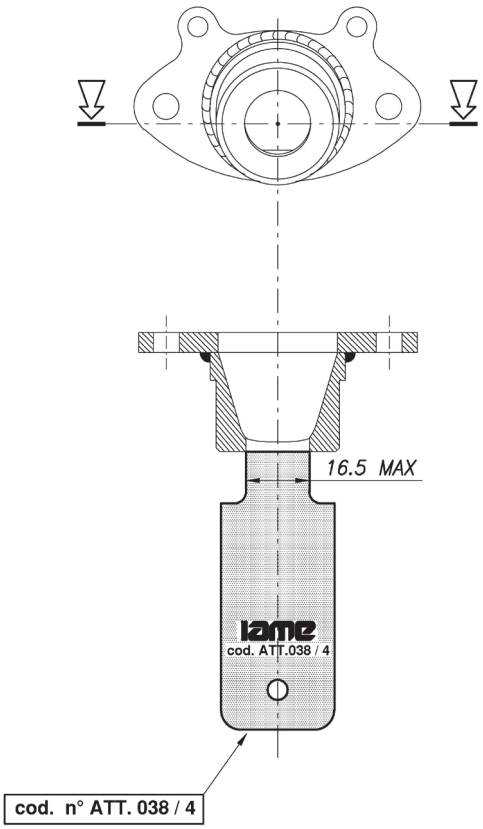




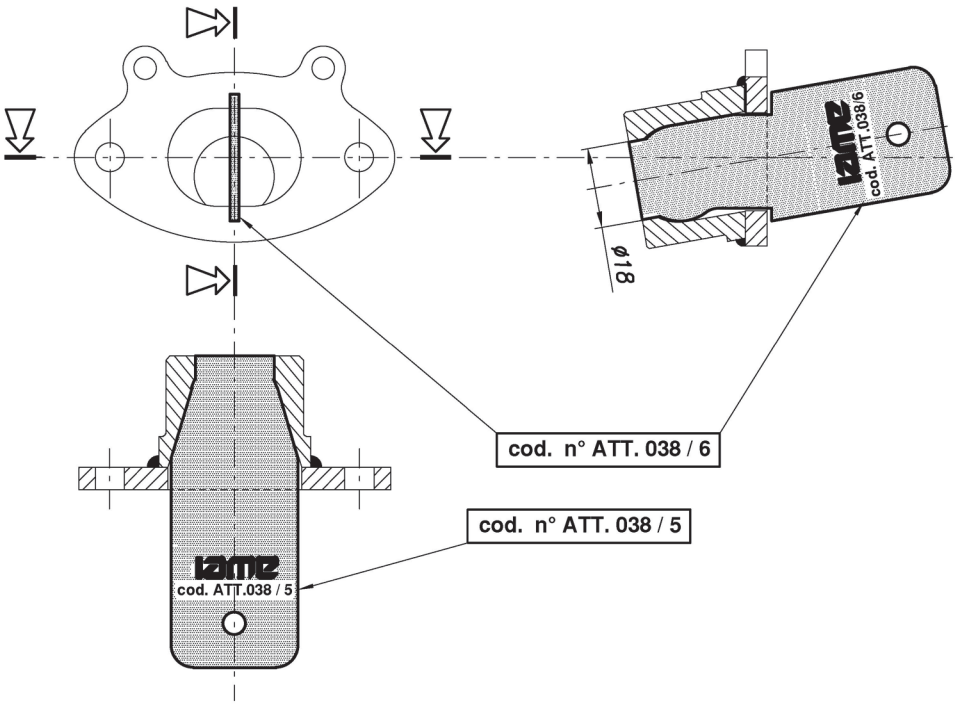
Check that the tool must be the same shape of the exhaust manifold.
Vérifiez que l'outil doit être de la même forme du collecteur d'échappement



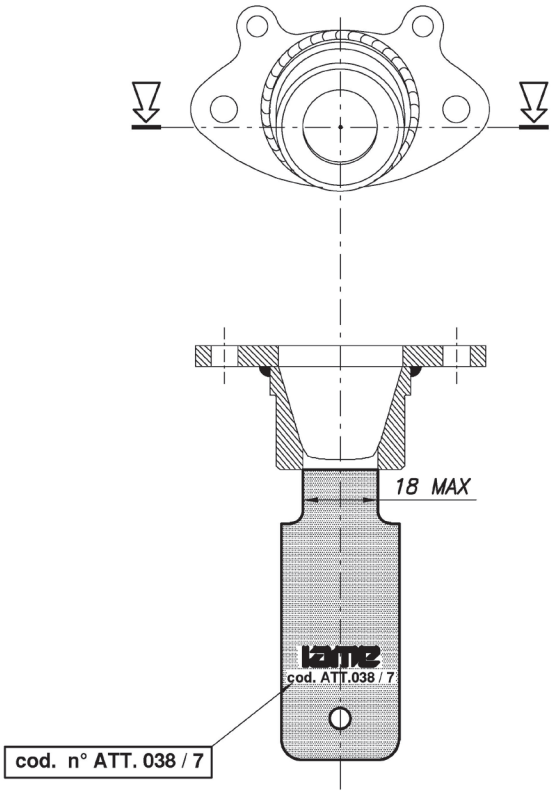
Check that the tool must be the same shape of the inlet carburettor.
Vérifier que l'outil doit avoir la même forme que l'admission du carburateur.



Check that the tool does not enter into the exhaust restrictor.
Vérifier que l'outil n'entre pas dans le restricteur d'échappement



Check that the tool must be the same shape of the inlet carburettor.
Vérifier que l'outil doit avoir la même forme que l'admission du carburateur.



Check that the tool does not enter into the exhaust restrictor.
Vérifier que l'outil n'entre pas dans le restricteur d'échappement

CARBURETTOR / *CARBURATEUR*

Tillotson HW-31A

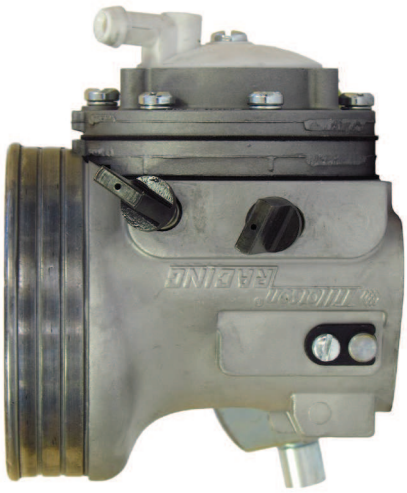
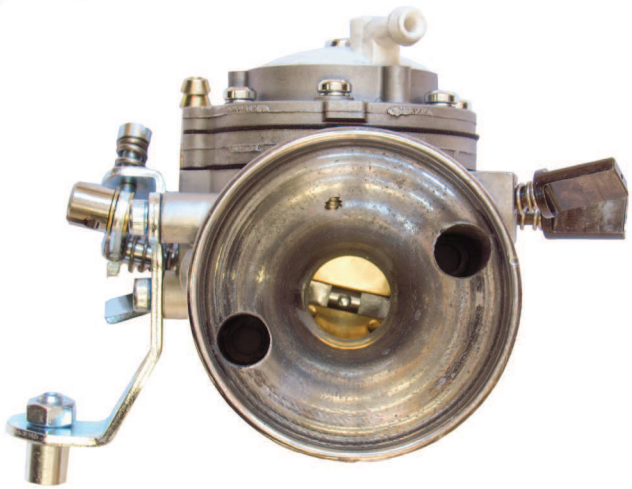
	

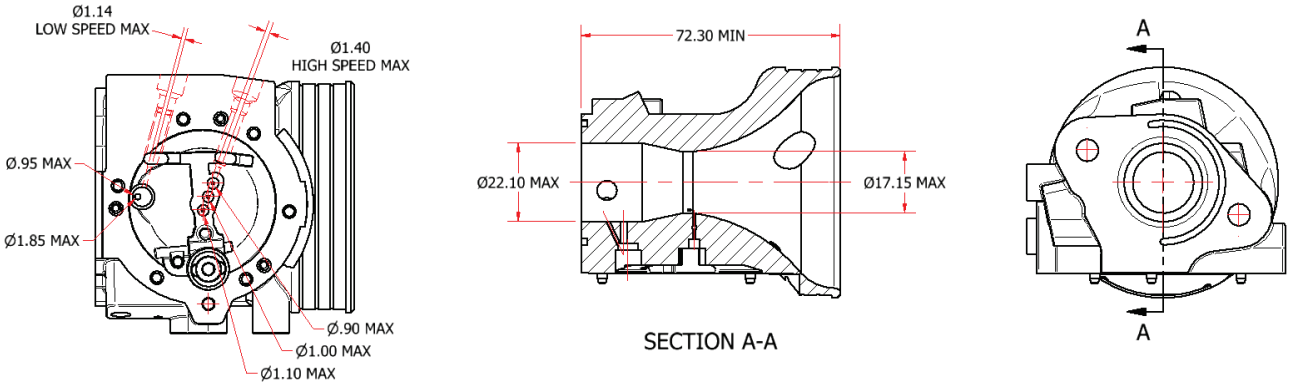
PHOTO OF ADJUSTING SIDE *PHOTO CÔTÉ RÉGLAGE*	PHOTO OF INLET SIDE *PHOTO CÔTÉ ASPIRATION*

Manufacturer - *Constructeur*	**TILLOTSON LTD.**
Make - *Marque*	**TILLOTSON**
Model - Modèle	**HW-31A**

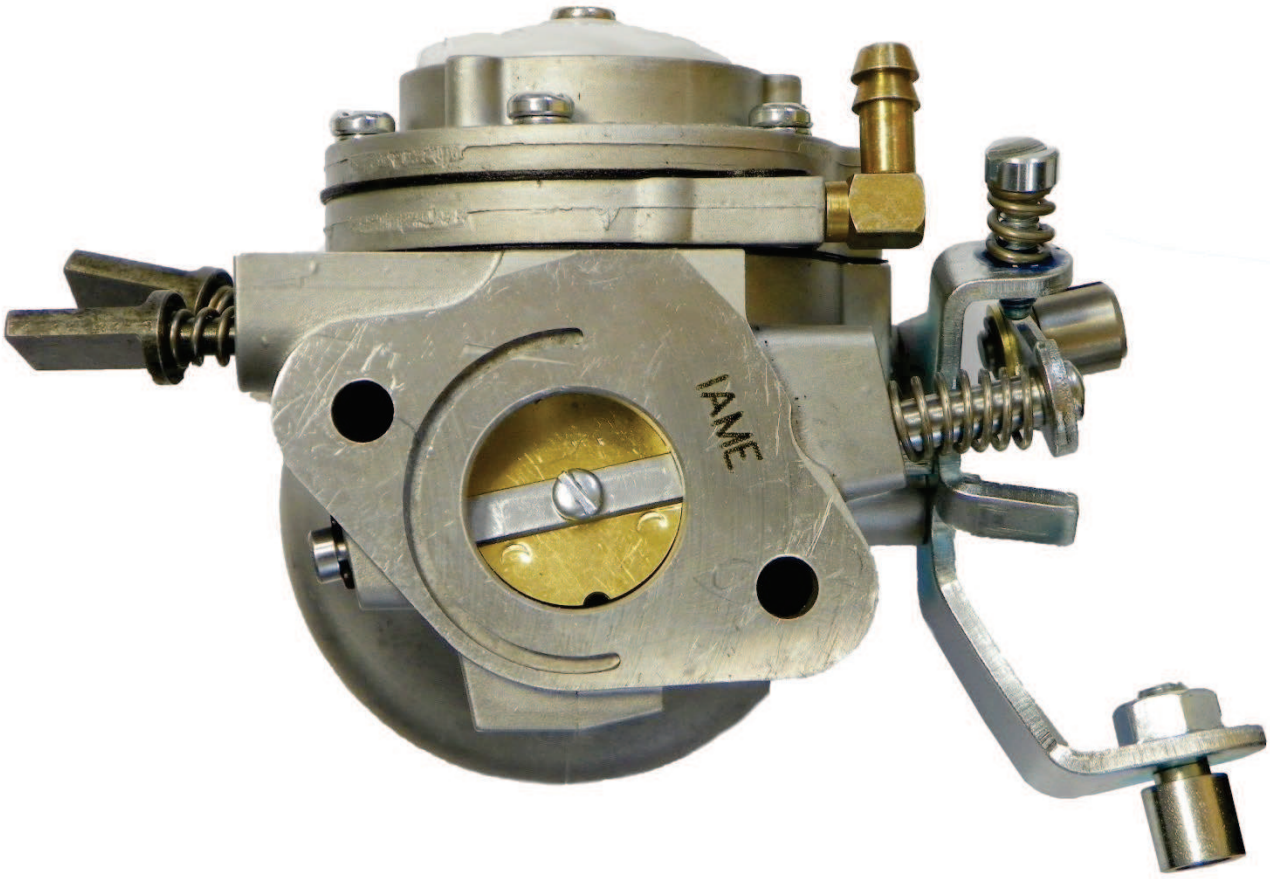
SPORT

2023

SECTION VIEW – *VUE DE SECTION AVEC DIMENSIONS*

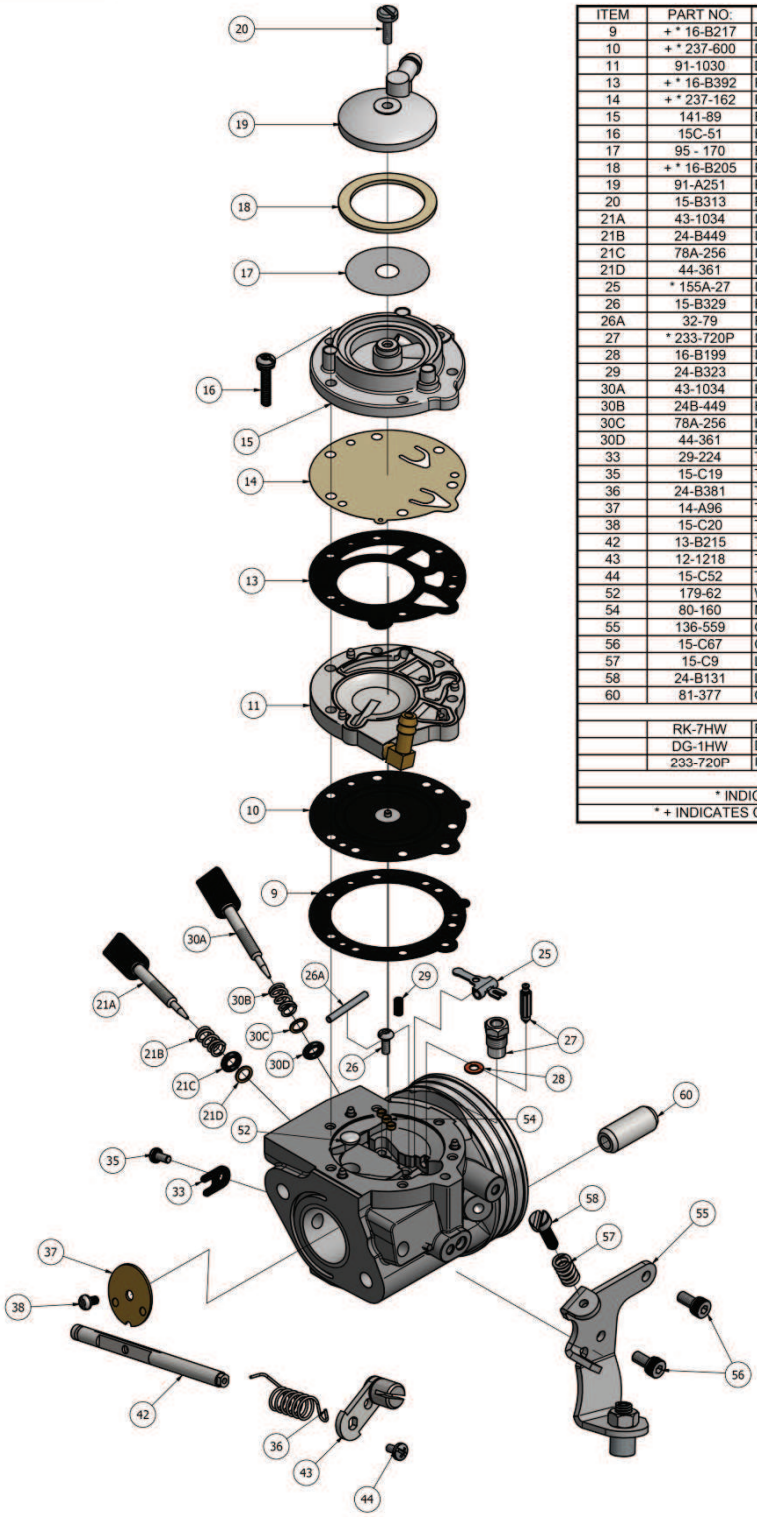


"IAME" MARKING – *MARQUAGE "IAME"*



2023

HW-31A



ITEM	PART NO:	DESCRIPTION	QTY
9	+ * 16-B217	DIAPHRAGM GASKET	1
10	+ * 237-600	DIAPHRAGM	1
11	91-1030	DIAPHRAGM COVER	1
13	+ * 16-B392	FUEL PUMP GASKET	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-B205	FUEL STRAINER COVER GASKET	1
19	91-A251	FUEL STRAINER COVER	1
20	15-B313	FUEL STRAINER COVER RETAINING SCREW	1
21A	43-1034	IDLE MIXTURE SCREW	1
21B	24-B449	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-B329	FULCRUM LEVER SCREW	1
26A	32-79	FULCRUM LEVER PIN	1
27	* 233-720P	INLET NEEDLE & SEAT SET	1
28	16-B199	INLET SEAT GASKET	1
29	24-B323	INLET TENSION SPRING	1
30A	43-1034	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-B381	THROTTLE RETURN SPRING	1
37	14-A96	THROTTLE SHUTTER	1
38	15-C20	THROTTLE SHUTTER SCREW	1
42	13-B215	THROTTLE SHAFT	1
43	12-1218	THROTTLE LEVER ASSEMBLY	1
44	15-C52	THROTTLE LEVER RETAINING SCREW	1
52	179-62	WELCH PLUG	1
54	80-160	MAIN PLUG	3
55	136-559	CABLE BRAKET	1
56	15-C67	CABLE BRACKET RETAINING SCREW	2
57	15-C9	LIMITER SCREW	2
58	24-B131	LIMITER SPRING	2
60	81-377	CARBURETTOR MOUNTING NUT	2
	RK-7HW	REPAIR KIT	
	DG-1HW	DIAPHRAGM & GASKET (STANDARD)	
	233-720P	INLET NEEDLE & SEAT SET	

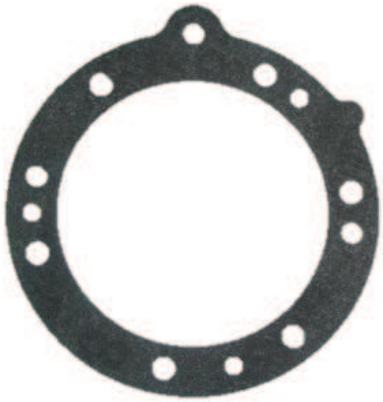
* INDICATES CONTENTS OF REPAIR KIT
* + INDICATES CONTENTS OF DIAPHRAGM & GASKET SET

Tillotson RACING
Clash Industrial Estate - Tralee - Ireland
www.tillotson-racing,com

2023

PARTS OF CARBURETTOR – *PIÈCES DU CARBURATEUR*

REF.9 - P. N°16-B217
DIAPHRAGM GASKET
JOINT DE DIAPHRAGME

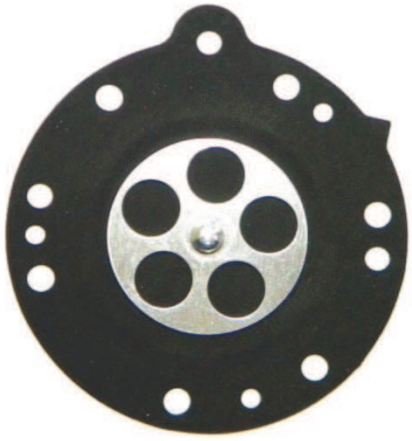


Thickness / *Epaisseur* = 0.5 ±0.1 mm

REF.13 - P. N° 16-B392
PUMP DIAPHRAGM GASKET
JOINT DE POMPE A ESSENCE

Thickness / *Epaisseur* = 0.8 ±0.1 mm

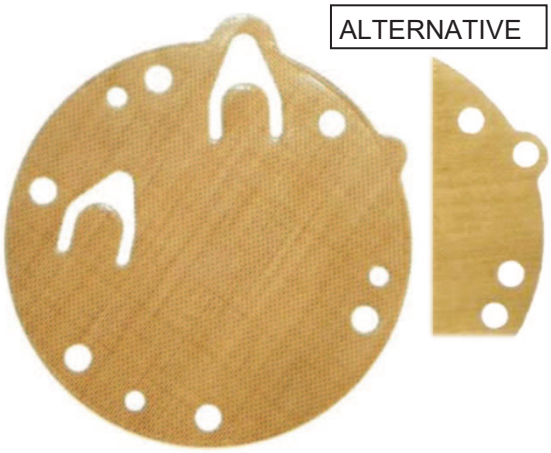
REF.10 - P. N°237-600
DIAPHRAGM
DIAPHRAGME ASSEMBLE



Thickness / *Epaisseur* = 0.13 ±0.07 mm

REF.14 - P. N°237-162
PUMP DIAPHRAGM
MEMBRANE DE POMPE A ESSENCE

ALTERNATIVE



Thickness / *Epaisseur* = 0.10 ±0.063 mm

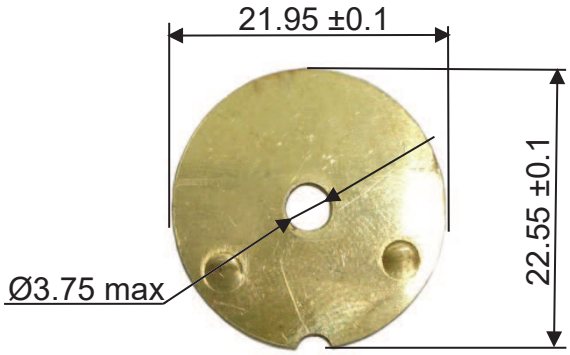
REF.11 - P. N° 91-1031
DIAPHRAGM COVER
COUVERCLE DE DIAPHRAGME

Thickness / *Epaisseur* = 6.75 ±0.15 mm

REF.15 - P. N° 141-89
PUMP COVER
CORPS DE POMPE A ESSENCE

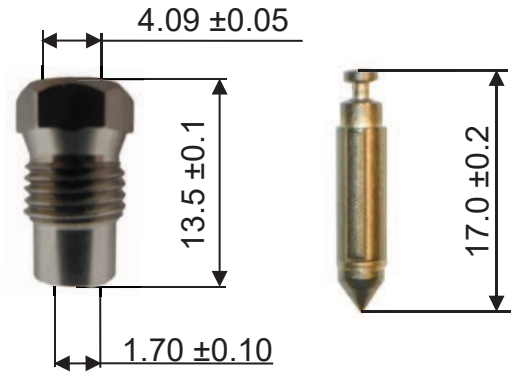
Thickness / *Epaisseur* = 12.5 ±0.15 mm

REF.37 - P. N° 14-A96
THROTTLE SHUTTER
PAPILLON

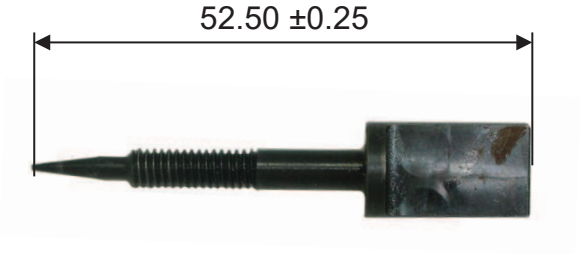


Thickness / *Epaisseur* = 0.81 ±0.1 mm

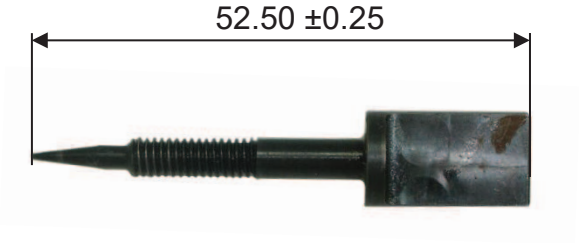
REF.27 - P. N° 233-720P
SEAT + NEEDLE
SIEGE + POINTEAU



REF.21A - P. N° 43-1034
NEEDLE LOW SPEED
VIS DE RAGLAGE BAS-REGIME

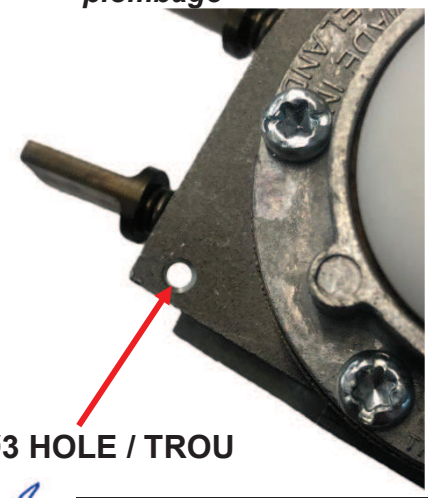


REF.30A - P. N° 43-1034
NEEDLE HIGH SPEED
VIS DE RAGLAGE HAUT-REGIME



NEEDLE FUEL ALTERNATIVE
POINTEAU ALTERNATIVE

REF.27 - P. N° 233-720P

HOLE FOR CARBURETTOR SEALING
TROU POUR LE PLOMBAGE

The carburettor can have this hole for sealing.
Le carburateur peut avoir ce trou pour le plombage