



SERVICE BULLETIN

U. S. SUZUKI TECHNICAL SERVICE

Bulletin No. 1
Date February 1, 1973
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SUBJECT: Piston Replacement

Affected Models: All

Effective Engine No.: All

Reference:

Read & Initial

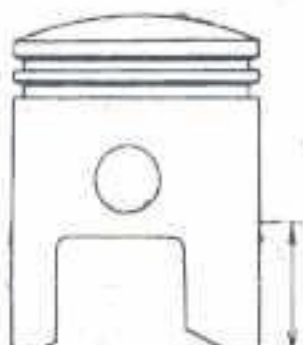
Manager

Parts

Service

This bulletin is issued to assist our dealers in the replacement of piston and rings in Suzuki motorcycles.

1. Always measure the piston diameter at the specified distance from the base of the piston. Measure at right angle to the piston pin hole.



MEASURE PISTON DIAMETER
AT SPECIFIED HEIGHT



MEASURE AT 90°
TO PIN HOLE

2. Always fit the piston with arrow pointing towards the front of the engine, toward the exhaust port. This is important because of the ring end gap location.



ARROW SHOULD POINT
TO EXHAUST PORT

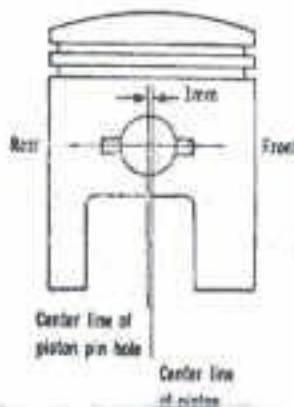
NOTE: Some TM250 pistons were not marked. Fit the piston with the notch in the pinhole to the rear of the engine, toward the intake port.

U. S. SUZUKI motor corporation

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Piston Replacement

3. The piston pinhole is always offset to the rear of the piston centerline. This is to anticipate the BTDC firing of the ignition system and reduce side thrust on the piston skirt.



4. When using old pistons, clean the ring grooves out before installing new rings.
5. Measure the cylinder bore at 5mm above the exhaust port for piston clearance diameter. No more than .002" total taper in the bore is permissible.
6. Check the ring end gap in the cylinder before assembling the engine. Push the ring into the cylinder with the piston to get it square in the bore. Check the end gap with a feeler gauge, while the ring is at its lowest normal position in the cylinder bore; just above the intake port. If the gap is too narrow, file both ends of the ring with a file gripped in a vice.
7. When inspecting used rings, check the free gap with a caliper. This is an indication of ring tension. If the ring is 1.0mm (.040") less than specified, replace it.

MODEL	DISPLACEMENT	NOMINAL CYLINDER BORE MEASURE @	PISTON CLEARANCE FIT TO	REPLACE AT	IN CYLINDER	RING END GAP REPLACE AT
F50R, MT50K	49cc	41mm (1.62")	(.0028-.0031")	.009"	.006-.014"	.040"
AS50, AC50, TS50K	49cc	41mm (1.62")	(.0026-.0029")	.005"	.004-.012"	.020"
M12, M15, M12-2, M15-2	50cc	41mm (1.62")	(.0020-.0025")	.006"	.004-.010"	.028"
M31	55cc	43mm (1.69")	(.0035-.0038")	.010"	.004-.010"	.035"
K10, K11	79cc	45mm (1.77")	(.0032-.0038")	.008"	.004-.012"	.040"
K15	79cc	45mm (1.77")	(.0035-.0040")	.008"	.004-.012"	.040"
K10P, K11P, K15P	79cc	45mm (1.77")	(.0014-.0016")	.004"	.004-.012"	.040"
RV90K	88cc	50mm (1.98")	(.0026-.0030")	.005"	.006-.014"	.047"
TS/TC90	89cc	47mm (1.85")	(.0022-.0026")	.004"	.006-.014"	.016"
AL00	98cc	50mm (1.98")	(.0020-.0024")	.004"	.006-.014"	.016"
AC100	98cc	50mm (1.98")	(.0018-.0022")	.004"	.006-.014"	.016"
AL00 RT KIT	98cc	50mm (1.98")	(.0025-.0032")	.005"	.006-.014"	.016"
TC120	98cc	52mm (2.05")	(.0018-.0022")	.005"	.004-.012"	.040"
T125	124cc	43mm (1.69")	(.0035-.0040")	.010"	.012-.014"	.046"
TS/TC125, RV125K	123cc	56mm (2.20")	(.0024-.0028")	.009"	.006-.014"	.040"
S32	149cc	46mm (1.81")	(.0022-.0026")	.005"	.004-.012"	.060"
TS185K	183cc	64mm (2.52")	(.0024-.0028")	.009"	.006-.014"	.040"
T200, TC200	196cc	50mm (1.98")	(.0016-.0020")	.003"	.004-.012"	.040"
T10	246cc	52mm (2.05")	(.0049-.0050")	.008"	.006-.014"	.040"
TM250 (1968)	246cc	66mm (2.64")	(.0120-.0130")	.015"	.008-.015"	.040"
TM250J, K	246cc	70mm (2.76")	(.0024-.0028")	.009"	.006-.014"	.040"
TS250-II	246cc	70mm (2.75")	(.0070-.0074")	.012"	.006-.014"	.040"
TS250 R, J, K	246cc	70mm (2.76")	(.0024-.0028")	.009"	.006-.014"	.040"
T20, TC250	247cc	54mm (2.13")	(.0020-.0024")	.005"	.004-.010"	.040"
T250J	247cc	54mm (2.13")	(.0022-.0026")	.005"	.006-.014"	.040"
GT250K	247cc	54mm (2.13")	(.0016-.0022")	.005"	.006-.014"	.040"
T305, TC305	305cc	60mm (2.36")	(.0022-.0026")	.005"	.006-.014"	.040"
T350J	315cc	61mm (2.40")	(.0022-.0026")	.005"	.006-.014"	.040"
GT380K	371cc	54mm (2.13")	(.0016-.0020")	.005"	.006-.014"	.040"
TM400K	396cc	82mm (3.23")	(.0041-.0046")	.012"	.008-.016"	.040"
TS400K	396cc	82mm (3.23")	(.0029-.0033")	.010"	.008-.016"	.040"
T500	492cc	70mm (2.75")	(.0070-.0074")	.012"	.008-.016"	.040"
T500 II, III, R, J, K	492cc	70mm (2.75")	(.0026-.0030")	.010"	.008-.014"	.040"
GT550K	544cc	61mm (2.40")	(.0016-.0020")	.004"	.006-.014"	.040"
GT750K	738cc	70mm (2.76")	(.0018-.0022")	.004"	.006-.014"	.040"

MODEL	STANDARD	1ST O.S. (0.5mm)	2ND O.S. (1.0mm)
F50R, MT50K	12110-19600	-19720	-19730
AS50, AC50, TS50K	12110-05101	-05750	-05760
M12, M15, M12-2, M15-2	12110-01601	-01721	-01740
M31	12110-02610	-02750	
K10, K11	12110-03971	-03981	-03991
K15	12110-03960	-03950	-03940
K10P, K11P, K15P	12110-03100	-03700	-03710
TS/TC90	12110-25100	-25721	-25731
RV90K	12110-23000	-23700	-23710
A100, AC100, AC100	12110-12000	-12700	-12710
A100 RT KIT	12110-17400	-17410	-17420
TS/TC100	12110-25601	-25761	-25771
TC120	12110-20200	-20720	-20730
T125	12110-20600	-20740	-20750
TS/TC125,	12110-28000	-28710	-28720
S32	12110-09205	-09705	-09715
TS185K	12110-29000	-29710	-29720
T200, TC200	12110-10000	-10700	-10710
T10	00059-61300	-61302	-61304
TM250 (1968)	12110-16200		
TM250J, K	12110-30731	-30740	
TS250II	12110-16400	-16700	-16710
TS250R, J, K	12110-30000	-30710	-30720
T20, TC250	12110-11600	-11720	-11730
T250J	12110-18400	-18750	-18760
GT250K	12110-18401	-18751	-18761
T305, TC305	12110-18000	-18700	-18710
T350	12110-18301	-18741	
T350II, R, J	12110-18500	-18770	
GT380K	12110-33001	-33701	-33711
TM400K	12110-16500	-16720	
TS400K	12110-32000	-16720	
T500 (R.H.)	12110-15000	-15700	-15710
(L.H.)	12120-15000	-15700	-15710
T500III, R, J, K (R.H.)	12110-15101	-15721	-15731
(L.H.)	12120-15101	-15721	-15731
GT550K	12110-34000	-34700	-34710
GT750K (R.H.)	12110-31000	-31710	-31720
(L.H.)	12120-31000	-31710	-31720
RV125K	12110-27300	-28710	-28720