



SERVICE BULLETIN

U. S. SUZUKI TECHNICAL SERVICE

Bulletin No. 2
Date February 1, 1973
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SUBJECT: Piston Ring Replacement
Affected Models: All
Effective Engine No.: As noted
Reference: Parts Manual

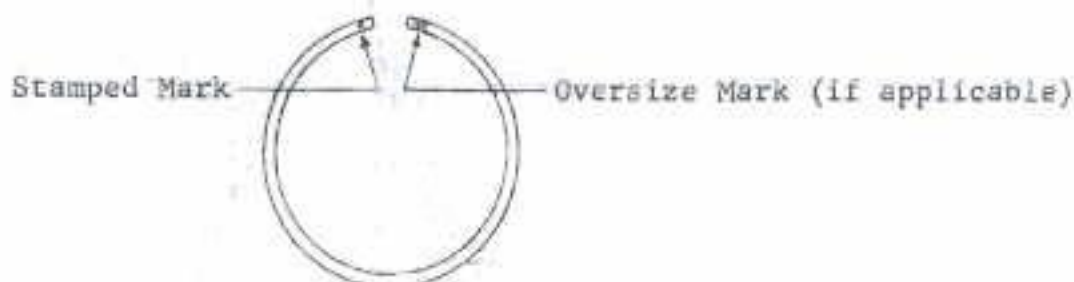
Read & Initial

Manager _____
Parts _____
Service _____

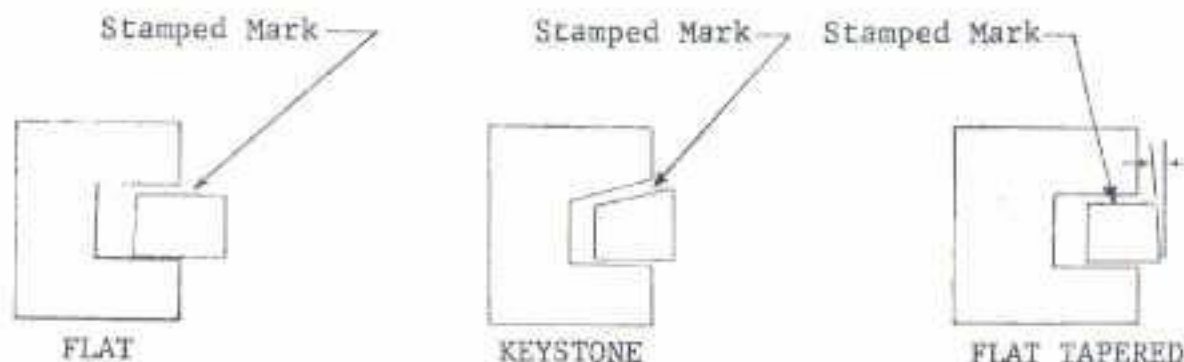
The attached service information provides piston ring data for all Suzuki motorcycles. All Suzuki piston rings are marked at the left end with a letter designation; usually "R", "NR", or "T". This mark designates the top of the piston ring and should always face toward the top of the piston. Some standard bore-pistons may also be marked "STD".

Oversize piston rings are marked as follows:

1st Oversize = 0.5mm (.020") overmarked "50"
2nd Oversize = 1.0mm (.040") overmarked "100"
3rd Oversize = 1.5mm (.060") overmarked "150"



Suzuki piston rings come in three types as illustrated below:



U. S. SUZUKI motor corporation

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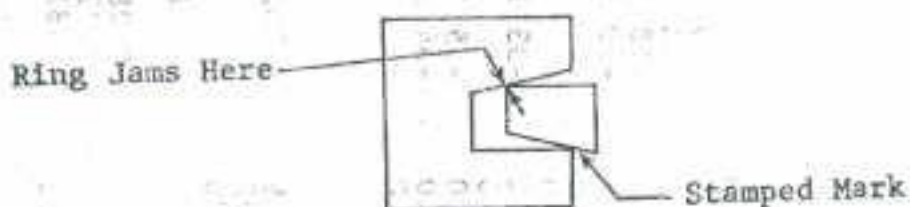
PISTON RING SET FOR ONE ENGINE

MODEL	PISTON RING DATA		PART NUMBER	
	TOP RING TYPE & FINISH	BOTTOM RING TYPE & FINISH CHANGE?	INTER- STANDARD	1ST O.S. (0.5mm) 2ND O.S. (1.0mm) 3RD O.S. (1.5mm)
F50, MT50K	Keystone Chrome	Flat Chrome	No	12140-05828
AS/AC50, TS50K	Keystone Chrome	Flat Chrome	No	12140-05110
RV90K	Keystone Chrome	Flat Chrome	No	12140-23802
TS/TC90J	Flat Chrome	Flat Chrome	Yes	12140-25011
TS/TC125, RV125	Keystone Chrome	Keystone Chrome	Yes	12140-28010
TS/TC100K	Keystone Chrome	Keystone Chrome	Yes	12140-25840
TS185K	Keystone Chrome	Keystone Chrome	Yes	12140-29010
T250J	Keystone Chrome	Keystone Chrome	Yes	12140-18410
GT250K	Keystone Chrome	Keystone Chrome	Yes	12140-18411
TS250K, TM250K	Keystone Chrome	Keystone Chrome	Yes	12140-30010
T350	Keystone Chrome	Flat Chrome	No	12140-18330
T350J	Keystone Chrome	Keystone Chrome	Yes	12140-18510
GT380K	Keystone Chrome	Keystone Chrome	Yes	12140-33011
TS/TM400K	Keystone Chrome	Keystone Chrome	Yes	12140-16510
T500K	Keystone Chrome	Keystone Chrome	Yes	12140-15011
GT550K	Keystone Chrome	Keystone Chrome	Yes	12140-34030
GT750K	Keystone Chrome	Keystone Chrome	Yes	12140-31010
				-05829
				-05750
				-23808
				-25730
				-28710
				-25850
				-29710
				-18720
				-18721
				-30710
				-18740
				-18750
				-33701
				-16700
				-15700
				-34710
				-31710

OLDER MODELS

A100, AS100, AC100	Keystone Black	Keystone Chrome	No	12140-12818
B100P, 105P, KT120	Keystone Chrome	Keystone Chrome	Yes	12140-07602
K10, K11, K15	Flat Chrome	Flat Black	No	12140-03010
K10P, K11P, K15P	Keystone Chrome	Keystone Black	No	12140-03111
M31	Flat Chrome	Flat Black	No	12140-02110
M12	Flat Chrome	Flat Black	No	12140-01010
M12-2, M15-2	Keystone Chrome	Flat Black	No	12140-01600
S32-2	Keystone Chrome	Keystone Chrome	Yes	12140-09809
TM250 (1968)	Flat Chrome	Flat Chrome	Yes	12141-16200
T10	Flat Chrome	Flat Black	Yes	00031-01120
T20, TC250	Keystone Chrome	Keystone Chrome	Yes	12140-11012
T200, TC200	Keystone Chrome	Keystone Chrome	Yes	12140-10010
T305, TC305	Keystone Chrome	Flat Chrome	No	12140-18030
TC120	Keystone Chrome	Flat Chrome	No	12140-20211
T125	Keystone Chrome	Flat Chrome	No	12140-14010
TS250II	Keystone Chrome	Keystone Chrome	Yes	12140-15011
				-12819
				-07722
				-03970
				-03701
				-02700
				-01760
				-01760
				-09810
				-16210
				-01125
				-11702
				-10730
				-10740
				-18710
				-20721
				-14700
				-15700

Keystone-type piston rings must be installed with the letter marking up or the following problem will occur. This makes it impossible to slip the cylinder down over the piston.



1. Always use new rings when installing a new piston.
2. All rings are supplied in quantities sufficient for one engine: 4 rings for a twin, 2 rings for a single, etc.
3. The TM 250 (1968) rings are the exception to the above rule; each ring must be ordered separately.
4. The A100 uses an expander for the bottom ring. The expander is included and should be replaced when the rings are replaced.
5. Take special care that each piston ring is installed so the ring end gap is located around the alignment pin in the groove.
6. It is next to impossible to determine whether a piston ring is keystone or flat with the naked eye. An easy method for determining which rings are keystone is shown below:
Place the ring in the jaws of the vernier calipers and hold it firmly imprisoned with your thumb. Next, attempt to rock the ring up and down. If the ring is flat it will not rock, only flex. If it is keystone it will rock until the keystone edge hits the jaw

