

Nicasil Update Kit

KIT P/N 2203299



Before you begin, read these instructions and check to be sure all parts and tools are accounted for. Please retain these installation instructions for future reference and parts ordering information.

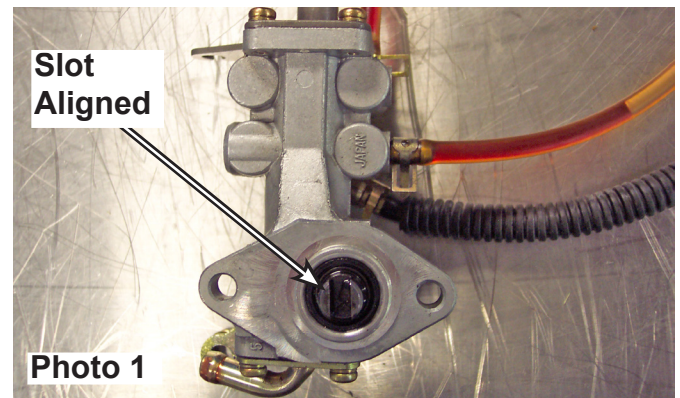
This kit includes:

Qty	Description	Part Number
1	Kit-550 Fan Heat Update	2876132
2	Piston Pin	3083838
4	Clip Piston PI	3084167
2	Small End Bearing	3085595
2	Gasket-Cylinder	3085666
1	Gasket-Head	3085704
2	Gasket-Exhaust	3085714
2	Cylinder-Complete	3089934
2	Piston-Set	3089935
4	Piston-Ring	3089936
1	CDI System-Complete	3089939
2	Oil Pump Mounting Screw	7517277
1	Gasket Oil Pump	5813237
1	Instructions	9920914

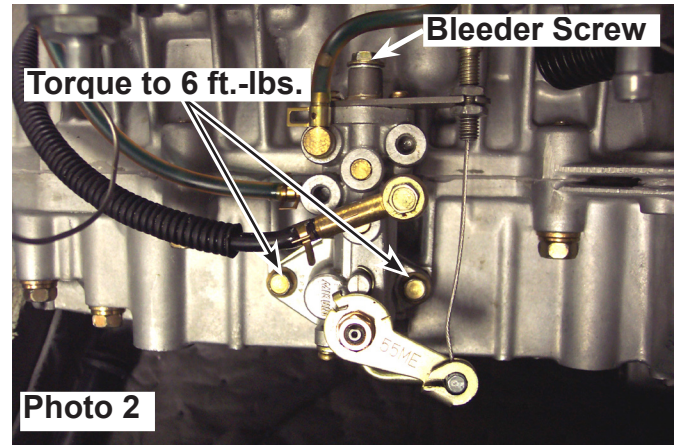
IMPORTANT: For your safety, and to ensure a satisfactory installation, perform all installation steps correctly in the sequence as shown on the attached instructions.

INSTALLATION INSTRUCTIONS

1. Remove and replace pistons, cylinders, and associated parts included in this kit according to the 550 Service manual section on Engine Rebuilding reference pages, 6.26 through 6.29.
2. Inspect oil feed line from oil tank to pump. If any air bubbles are found they should be bled off when the oil pump is removed from the engine later in this process.
3. Using a short T-handled #2 Phillips screwdriver, apply steady even force and loosen the mounting screws on the oil pump. Remove and discard these screws.
4. Remove and discard the oil ring from back side of oil pump mount. **CAUTION: Inside of the oil pump drive cavity there maybe shim washers. Ensure that these are not removed or lost. NOTE:** Inspect oil feed line from oil tank to pump. If any air bubbles are found they should be bled off utilizing bleeder screw.
5. Install gasket (PN 5813237) to oil pump.
6. Install one new 5 mm cap screw (PN 7517277) into oil pump and gasket to help locate gasket for assembly.
7. Position oil pump assembly to crankcase location turn pump right and left to seat properly on drive. If pump will not seat completely it may be necessary to rotate the drive clutch until oil pump engages the drive internal to the crankcase. **NOTE:** Failure to follow these procedures will cause severe damage to oil pump and drive. Photo 1.



8. Turn in cap screw making sure it is not cross threaded. Install the second 5 mm cap screw (PN 7517277). Tighten screws and torque to 6 ft.-lbs. Photo 2.
9. Reinstall carburetors level float bowls and tighten carburetor adapter clamps.
10. Install heat shields and foil per kit instructions 9920915.



11. Jetting Recommendation: Trail RMK's with ACCS continue to use all carburetor and jetting settings per original engine specifications. For all other models use chart included in this kit.
12. Clutch engine according to the original specifications.

Oil Pump Bleed Procedure with Unit Running

1. Using a stiff wire, form a hook at on one end The wire should be long enough to reach the oil pump arm down between the carburetor with the air box installed.
2. Start the engine and bring idle up to 3000 RPMS.
3. With the tool made in step one lift the oil pump arm to the wide open position and hold open for one minute. This will allow enough time to bleed pump.

Carburetor Settings

Pilot Jet	35
Jet Needle	6BGY41
Needle Jet	Q-0 (480)
Cutaway	3.0
Throttle Gap Under CA	6.50mm / .256"
Fuel Screw (from fully seated)	N/A
Air Screw (from fully seated)	1.0 Turns
Pilot Air Jet	2.5

Main Jet Recommendation Chart

Production Setting

Altitude	Ambient Temperature	Below -25°F Below -31°C	-30° to -10°F -34° to -23°C	-15° to +5°F -26° to -15°C	0° to +20°F -18° to -7°C	+15° to +35°F -9 to +2°C	+30° to +50°F -1° to +10° C	+45° to +65°F +7° to +18°C	Above +60°F Above +16°C
Meters (Feet)	0-600 (0-2000)	270 #4	260 #4	250 #4	240 #4	230 #3	220 #3	210 #2	200 #1
	600-1200 (2000-4000)	260 #4	250 #4	240 #3	230 #3	220 #3	220 #2	210 #2	200 #1
	1200-1800 (4000-6000)	250 #4	240 #3	230 #3	220 #3	210 #2	210 #2	200 #2	190 #1
	1800-2400 (6000-8000)	230 #3	220 #3	220 #3	210 #2	210 #2	200 #2	190 #1	180 #1
	2400-3000 (8000-10000)	220 #3	210 #3	210 #2	200 #2	190 #2	190 #2	180 #1	170 #1
	3000-3700 (10000-12000)	210 #3	200 #3	190 #2	190 #2	180 #2	180 #2	170 #1	160 #1