

Thank you for choosing a Namura replacement cylinder. This guide covers preparation and installation considerations for applicable KTM, Husqvarna, and GASGAS two-stroke engines (85cc–300cc). Verify compatibility with your exact model and year before beginning.

Review the applicable OEM service manual for the correct assembly procedures, specifications, tightening sequences, and torque values. Inspect all related components and replace any parts that are worn or damaged before installing the cylinder.

IMPORTANT: Refer to the OEM service manual for critical engine specifications. Exhaust-valve designs vary by model. If an installation step or fitment is uncertain, consult a qualified engine technician before continuing.

PRE-INSTALLATION & EXHAUST VALVE CHECKS

- Before assembly, check that the cylinder is clean and free of visible burrs or debris.
- Pay particular attention to the exhaust-valve opening and surrounding edges. If burrs are present, remove them carefully without damaging the cylinder or port surfaces (Photo A).
- Clean the exhaust-valve assembly, remove carbon deposits, and inspect its components for wear. Replace any parts outside the OEM service limits.
- Due to normal manufacturing tolerances, minor fitment adjustments may be required on some applications. Verify that the exhaust valve moves freely throughout its intended range without binding or contacting the cylinder.
- Apply machinist's layout dye, a permanent marker, or a similar marking medium to the exhaust valve (Photo B).
- Temporarily install the valve with its applicable guides or bushings according to the OEM design and check for smooth, unrestricted movement.
- Remove the valve and inspect the marked surfaces for contact points. If minor adjustment is necessary and permitted by the OEM service procedures, carefully polish the affected areas with 320–400 grit abrasive paper. Remove as little material as possible, then reinstall and test. Repeat only as needed.
- After fitting, wash the cylinder thoroughly with warm soapy water, rinse, and dry completely using compressed air. Lightly coat the bore with two-stroke oil and complete installation according to the OEM manual.

PHOTO A | Inspect for burrs



PHOTO B | Check contact marks

