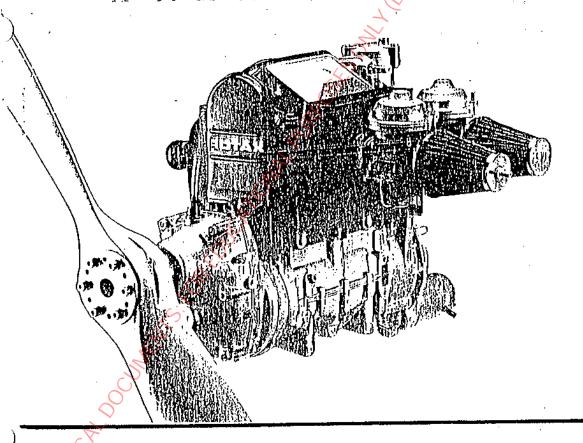
REPAIR

MANUAL FOR

ROTAX - ENGINE TYPE 508 UL



Page 1

- 1. Oil return line
- 2. Clamp
- 3. Rotax engine 508
- 4. Stud M10 x 42/22.5 (4)
- 5. Distance sleeve (4)
- 6. Medium strength threadlocker Loctite 242
- 7. Oil outlet line
- 8. Elastic stop nut M6
- 9. Ground cable
- 10. Tooth washer
- 11. Bolt M6 x 20
- 12. Engine brecket
- 13. Flat washer 10.5 mm x 21 x 2 (4)
- 14. Lock washer 10 mm
- 15. Nut M10
- 16. Rubber mount (4)
- 17. Washer (4)

- 18. Elastic stop nut M10 x 1.5
- 19. Muffler
- 20. Push nut (2)
- 21. Cup (4)
- 22. Spring (4)
- 23. Cup (4)
- 24. Exhaust grommet
- 25. Bushing (2)
- 26. Muffler clamp (2)
- 27. Hexagonal head screw M8 x 1.25 x 80
- 28. Clamp (3)
- 29. Hose
- 30. Male ball joint
- 31. Connector pipe
- 32. Spring (4)
- 33. Elbow

REMOVAL FROM CRAFT

Remove or disconnect the following then lift engine from craft.

- ground cable from battery then from engine bracket
- muffler, connector pipe and elbow
- console and intake panels
- impulse line, carburetor from its flange
- disconnect starter wires
- -- disconnect wires from magneto, oil pressure and temperature switches
- disconnect oil return line and plug it
- disconnect oil outlet line from engine and plug both fitting and hose
- unscrew nuts retaining engine support to frame
- remove engine from right hand side

ASSEMBLY

4,6,12,15, Stud, threadlocker, engine bracket & nut

Install engine on its bracket with intake manifold on same side of ground cable fixing hole.

Apply medium strength threadlocker Loctite 242 on stud nuts then torque to 35 Nom (26 lbfoft).

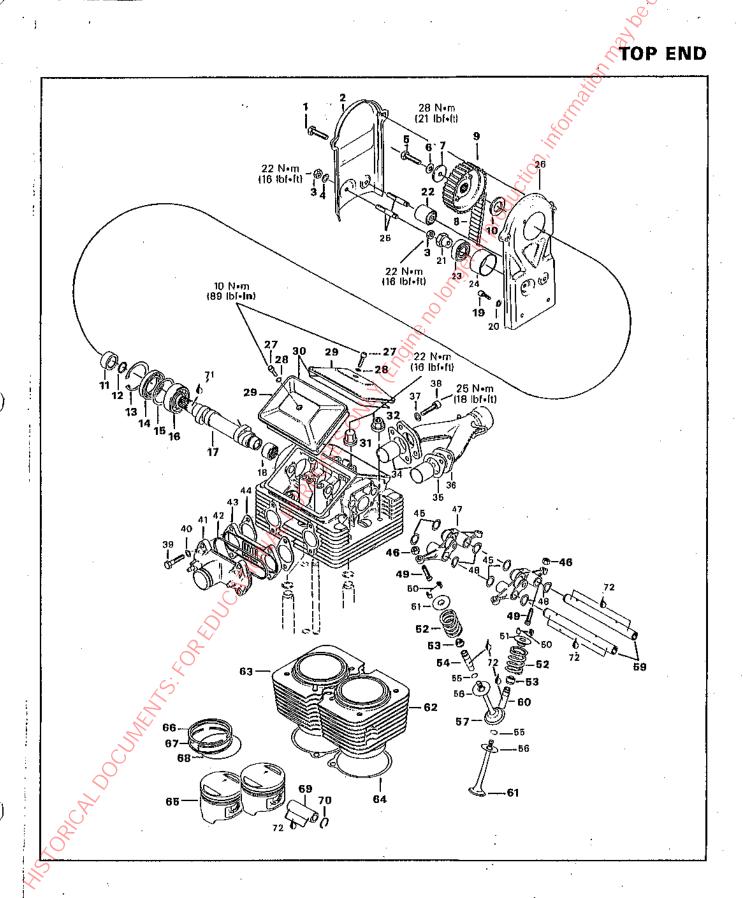
Torque nuts retaining engine support to 38 N·m (28 lbf•ft).

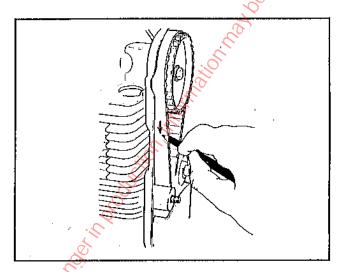
INSTALLATION ON CRAFT

To install engine on craft, reverse removal procedure. However, pay attention to the following:

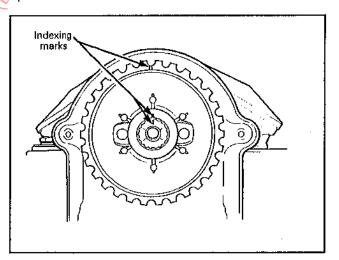
- Check tightness of engine mount nuts.
- Check pulley alignment and drive belt tension.
- Should a slight exhaust leak be experienced at muftler ball joint, Dow corning sealer #763 RTV can be used. However after some hours of use, carbon deposits should seal joint.

Page 2





Remove guide pulley then slip timing belt off timing pulley. If too tight slacken (clockwise) tensioner eccentric after unlocking hexagonal nut. Remove timing pulley, note indexing marks. Remove thrust washer. Unscrew socket head screws retaining timing belt housing to cylinder head.



1,2,3,4, Taptite screw, timing belt cover, nut & lock washer

Unfasten timing belt cover

5,6,7,8,9,10,19,22, Screw, spring washer, washer, thrust washer, timing belt, timing pulley, tensioner eccentric, socket head screw & guide pulley

Remove screw spring washer and washer.

Mark timing belt direction of rotation.

Remove both cylinder cowls.

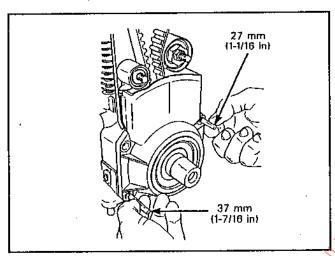
27,28,29,31,32, Screw, gasket ring, valve cover & nut

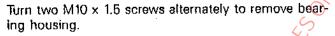
Remove valve covers. Unscrew all cylinder nuts then lift cylinder head.

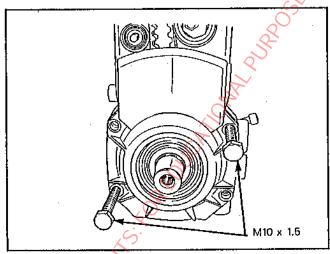
65,69,70, Piston, piston pin & circlip

To gain access to circlip, remove either fan housing (see section 02-13 ''Cooling system'') or timing belt housing. To remove timing belt housing:

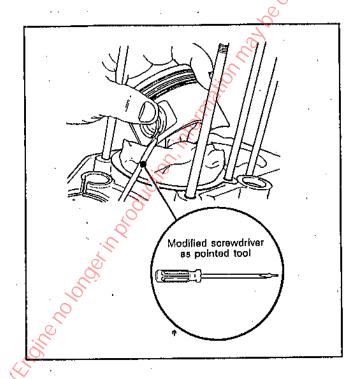
 remove four screws on PTO side bearing housing and insert two pins as illustrated.

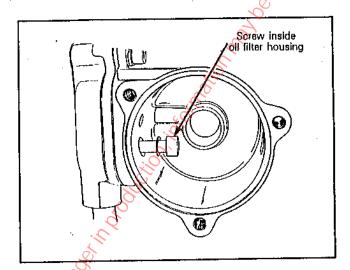






Remove timing belt housing. Place a clean cloth over crankcase ther with a pointed tool inserted in piston notch, remove circlip from piston.





CLEANING

Discard all gaskets and O-rings.

Clean all metal components in a non-ferrous metal cleaner.

Scrape off carbon formation from cylinder head using a wire brush. Remove carbon on piston dome using a wooden spatula.

NOTE: An arrow on piston dome pointing exhaust side must be visible after cleaning.

Clean piston ring grooves with a groove cleaner of a piece of broken ring.

DISASSEMBLY

IMPORTANT: All parts must be reinstall in their original location.

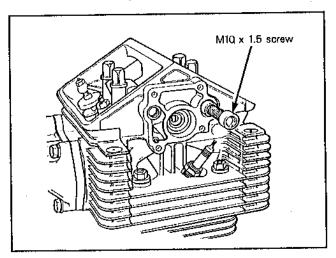
Remove four screws retaining oil litter housing and oil pump housing. One screw is located inside oil filter housing.

46,49 Nut & adjustment screw

Unlock nut then turn adjustment screw out for each valve to remove any tension on rocker shaft.

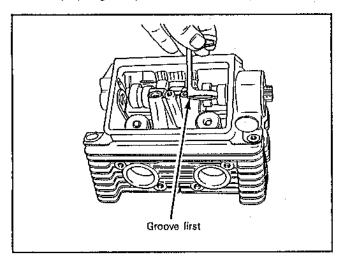
47,58,59, Rocker arm & rocker shaft

Extract rocker shaft using a M10 x 1.5 screw. Remove rocker arm and note position of all parts including wave washers for assembly.



50,51,52,57,61, Valve cotter, valve spring retainer, valve spring & valve

Install valve spring pusher Part # 276 470 with its groove first on valve retainer and compress spring with a C-clamp spring compressor such as Snap-On YA4430.



53,54,60, Valve stem seal, valve guide

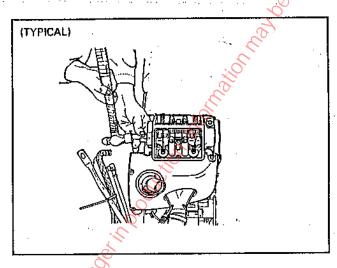
Do not remove valve guide unless necessary. To remove, use an appropriate pusher to drive valve guide out of cylinder head working from combustion chamber side. Valve stem seal will come with guide.

To replace valve stem seal, pry it from valve guide end.

11,12,13,14,15,17, Distance sleeve, oring, snap ring, oil seal, shim & camshaft

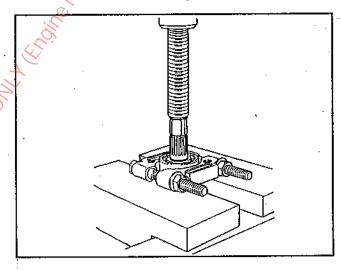
Remove distance sleeve, o-ring then snap-ring.

Tap on camshaft end on oil pump side using a punch of same diameter. Ball bearing and oil seal will go out with camshaft.



16, Ball bearing

Press camshaft out of bearing.



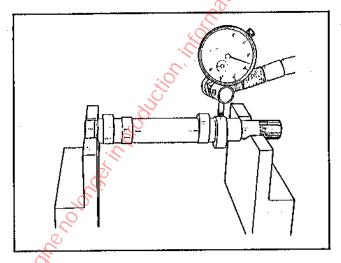
INSPECTION

Inspection of engine top end should include the following measurements:

MEASUREMEN	1TS	TOLERÁNCI NEW P (Min.)	WEAR LIMIT mm (in)		
Camshaft lobe lift		5.734 (.226)	•		
Valve spring lengt	h	36.6 (1.44			
Velve stem / valve guide	EX.	0.03 6 {.0014}	0.063 (.0025)	0.5	
clearance	IN.	0.026 (.0010)	0.053 (.0021)	(.020)	
Valve face conctact width	EX.	1.5 (.059)	2.0 (.079)		
ļ	IN.	1.0 (.039)	1.5 (.059)		
Rocker arm inside	dia.	14.05 (.5531)	14.068 (.5539)	· –	
Rocker arm shaft	dia.	14,001 (.5512)	14,012 (.5517)	1	
Cylinder head warpage		_		0.03 (.0012)	
Cylinder diameter		71.0 (2.7953)	71.02 (2.7961)	71,10 (2,7992)	
Cylinder taper		_	_	0.05 (.002)	
Cylinder out of ro	und			0.04 (.0016)	
Piston / cylinder clearance		0,03 (.0012)	0.04 (.0016)	0.1 (.004)	
Piston diameter	Red	70,96 (2.7937)	70.97 (2.7941)	70.90	
,	Green	70.97 (2.7941)	70.98 (2.7945)	(2.7913)	
Ring / groove clearance	& 1 st 2 nd	0,03 1,0012)	0.05 (,0020)		
	3rd	0.01 (.0001)	0.03 (.0012)		
Ring end gap	3rd 2nd 3rd	0.3	0.5 {.020}	1.0 (.040)	

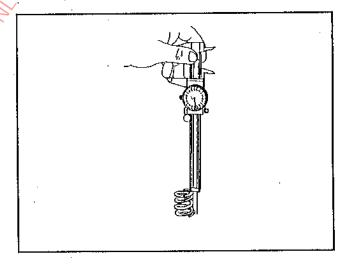
17, Camshaft

Check lobes for scratch and measure lift, it should be 5.734-5.934 mm (.226-.234 in) either on exhaust and intake.



52 Valve spring

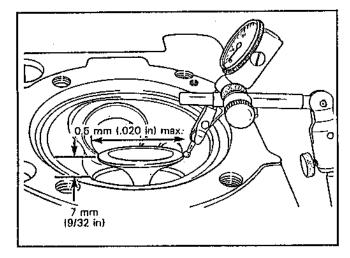
Check spring length, it should be 36.6 mm (1.441 in).



Spring rate is 50 N/mm (285 lbf/in).

54,57,60,61, Valve guide & valve

Check valve stem/guide clearance. With valve 7 mm (9/32 in) open, move valve in direction of largest clearance. Service limit is 0.5 mm (.020 in) measured at valve head.



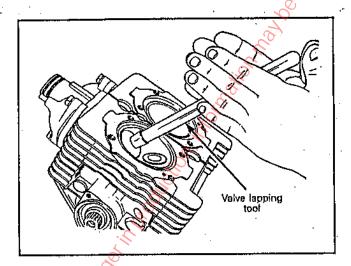
Using an appropriate hole gauge and a micrometer compare valve stem diameter and valve guide inside diameter.

VALVE STEE	VALVE GUIDE INSIDE DIA. mm (In)	
EXHAUST	INTAKE	EXHAUST & INTAKE
6.955-6.970 (.27382744)	6.965-6.980 (.27422748)	7.006-7.018 (.27582763)
		

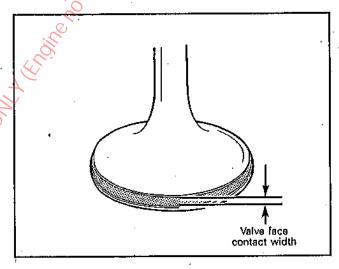
VALVE/GUIDE CLEARANCE mm (lin)			
NEW PARTS SERVICE LIMIT			
EXHAUST	INTAKE	EXHAUST & INTAKE	
0.036-0.063 (.00140025)	0.026-0.053 (.0010 ₇ .0021)	0.5 (.020)	

Valve face and seat 6

Apply some lapping compound to valve face and work valve on its seat with a lapping tool.



Measure valve face contact width. Note location of contact area, it should be in center of valve face.



VALVE FACE CONTACT WIDTH mm (in)		
EXHAUST	INTAKE	
1.5-2.0 (.059-,079)	1,0-1.5 (.039059)	

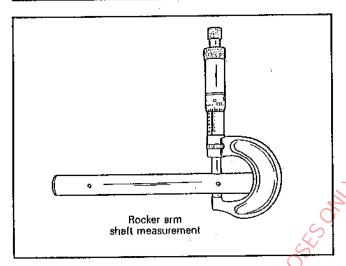
Refacing valves and valve seats

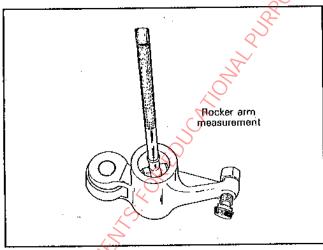
Refer to a specifized shop for refacing. Exhaust and intake valve seats and valve faces have a 45° angle. Measure valve margin after valves are refaced. Valves with less than 0.75 mm (.030 in) margin must be replaced.

47,58,59, Rocker arm & rocker arm shaft

Check for scored friction surfaces, if so, replace parts. Fit parts together and check for excessive play. Exact clearance can be determined by measuring both parts.

	ROCKER ARM SHAFT OUSIDE DIAMETER mm (In)	HOCKER ARM INSIDE DIAMETER mm (In)	CLEARANCE mm (In)
Ī	14,001-14,012	14,05-14,088	0.038-0.067
	(.56125517)	(,5531-,5539)	(.00150026)

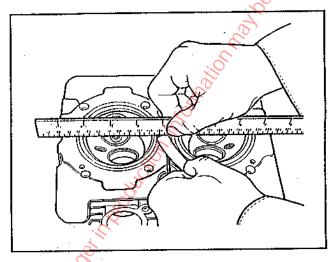




33, Cylinder head

Check for crack between valve seats, if so, replace cylinder head.

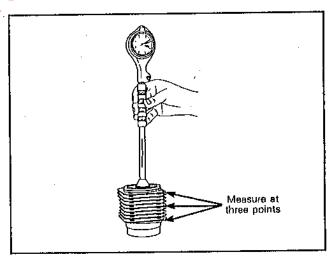
Maximum cylinder head warpage is 0.03 mm (.0012 in).



62,63, Cylinder

Cylinder taper

Measure cylinder diameter 16 mm (5/8 in) from top of cylinder then half-way through and finally at bottom. Difference between measurements should not exceed 0.05 mm (.002 in). If so, replace cylinder.

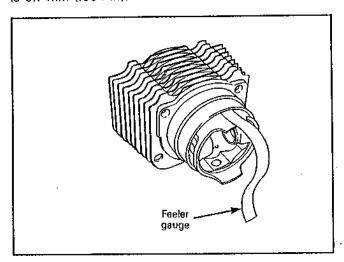


Cylinder out of round

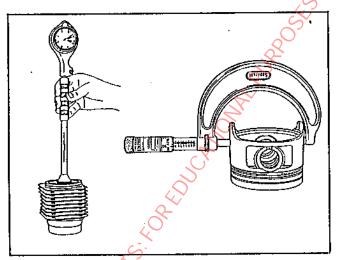
Measure cylinder diameter in piston axis direction 16 mm (5/8 in) from top of cylinder. Take an other measurement 90° from first one and compare. Difference between measurements should not exceed 0.04 mm (.0016 in). If so, replace cylinder.

Piston/cylinder clearance

Clearance can be quickly checked with a long feeler gauge. Insert feeler gauge in cylinder then slide piston (without rings) into cylinder. When fitting new parts clearance is 0.03-0.04 mm (.0012-0016 in). Wear limit is 0.1 mm (.004 in).



To accurately determine piston/cylinder clearance, measure piston at 12 mm (15/32 in) above skirt end. Measure cylinder 16 mm (5/8 in) from top.

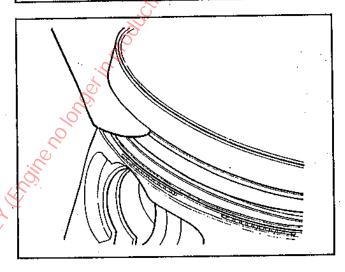


Difference between these two measurements should be within specified tolerance.

Ring/piston groove clearance

Using a feeler gauge measure each ring/piston groove clearence.

RING/PIST	RING/PISTON GROOVE CLEARANCE mm (In)		
Ring	(Min.)	(Max.)	
1 st & 2 nd	0.03 (.0012)	0.05 (.0020)	
3 rd	0.017.00041	0.03 (.0012)	

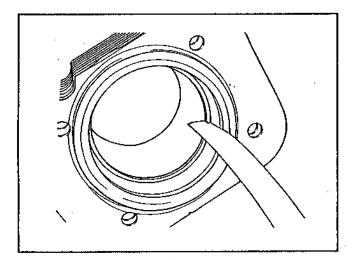


If out of tolerance replace ring(s) and/or piston.

Ring end gap

Position ring about 50 mm (2 in) from top of cylinder in which it is to be fitted.

NOTE: An inverted piston can be used to push rings to insure positioning rings squarely in cylinder bore before measuring.



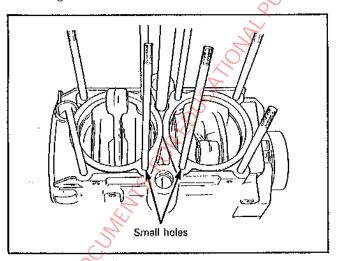
RING END GAP rnm (in)			
Ring	NEW (Min.)	PARTS (Max.)	WEAR LIMIT
1 ^{s1} , 2 nd & 3 rd	0.3 (.012)	0.5 (.020)	1.0 (.039)

ASSEMBLY

Assembly is essentially the reverse of disassembly procedure. However pay particular attention to the following:

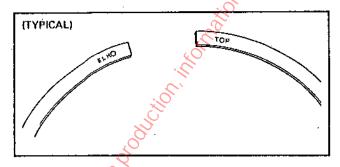
64,Gasket

Position gaskets with their small holes inwards.

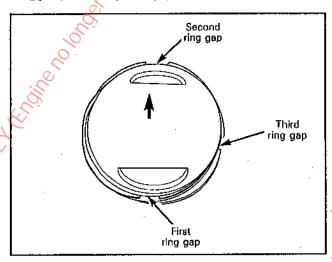


66,67,68, Ring

Install all rings on piston with writing facing top of piston.

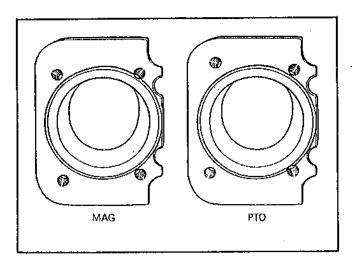


Stagger piston ring end gaps as illustrated.



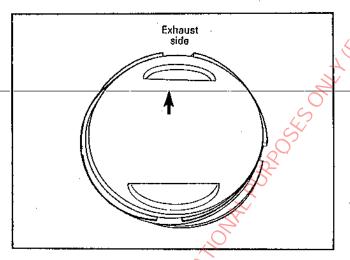
62,63, Cylinder

Identify cylinders. Difference between MAG and PTO-cylinder is position of stud holes related to cylinder bore.



65, Piston

Install piston with arrow on piston pointing exhaust side.

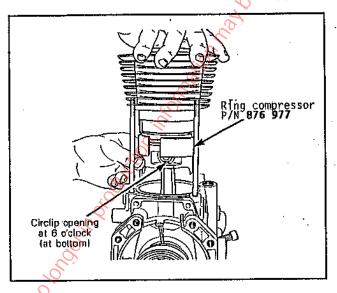


70, Circlip

CAUTION: To minimize the effect of acceleration force on circlips, install them so that their openings are located at 6 oclock (at bottom).

CAUTION: Always use new circlips. At installation, take care not to deform them. Overstressed circlips will come loose and will damage engine. Circlips must not move freely after installation, replace if circlip rotates after installation.

Lubricate rings with motor oil. Use ring compressor Part # 876 977 to easyly install of cylinder.



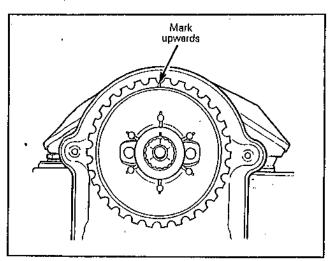
54,60, Valve guide

Apply Molykote G - N to valve guide then drive it into cylinder head from camshaft side until its circlip seats in cylinder head groove.

New valve guide must be reamed to fit valve. Use a 7_mm (.0275_in) reamer_such as Dormer_1683.

31,32,33, Collar hex. nut, cap nut & cylinder head

Temporary install timing pulley to turn carnshaft until mark is upwards.

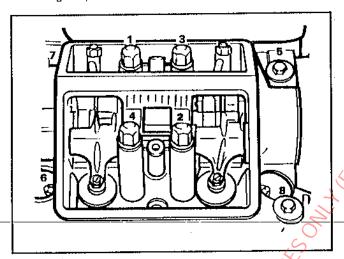


CAUTION: Do not turn camshaft when cylinder head is installed on engine. Otherwise valves may contact pistons.

Lock crankshaft with PTO piston at TDC using fixation screw Part # 241 965.

Coat O-rings of oil return tubes with Silastic RTV 732 . Install cylinder head on studs making sure oil return tubes are well inserted.

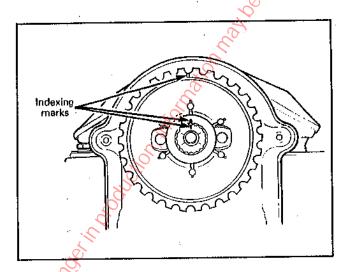
Torque cylinder head nuts to 22 N•m (16 lbf•ft) in the following sequence.



ADJUSTMENT

8, Timing belt

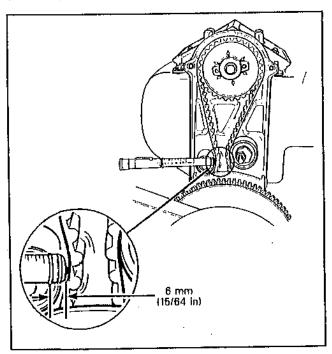
Install belt pulley with its mark corresponding with camshaft mark which already show upwards. With crankshaft already locked with fixation screw tPTO piston at TDC), install timing belt. Torque belt pulley screw to 28 N•m (21 lbf•ft).



NOTE: If camshaft or crankshaft has to be turned before timing belt installation, completely stacken valve adjustment screw to avoid valve contacting piston dome.

3,21,24, Nut, tensioner excentric & guide pulley

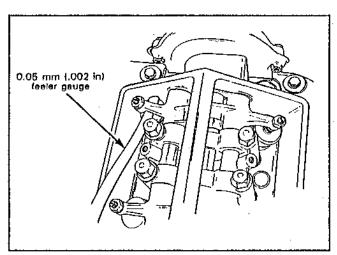
Turn tensioner excentric as far to the left to obtain a gap of 6 mm (15/64 in) between beit and guide pulley when applying a force of 20 N (4.5 lb). Torque nut to 22 N•m (16 lbf•ft).



Page 🚶

46,49, Nut & adjustment screw

With belt pulley mark showing downwards, adjust PTO side valves clearance to 0.05 mm (.002 in) by turning in or out adjustment screw. Clearance is measure at valve stem end and adjustment screw. Tighten lock nut and recheck valve clearance.

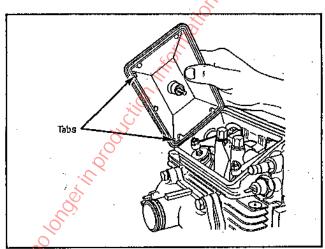


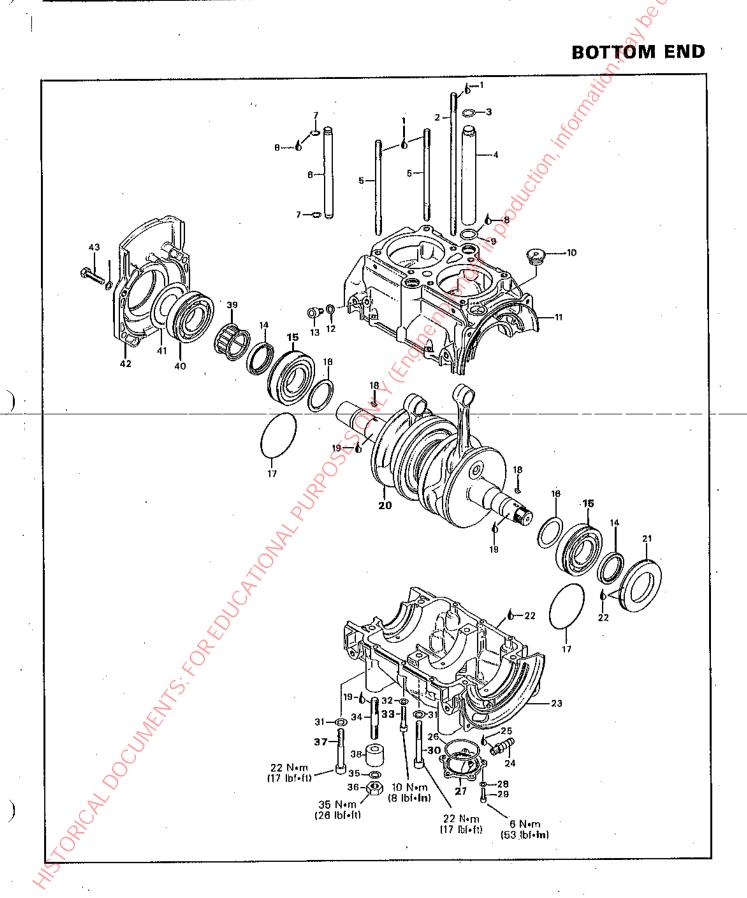
Rotate engine counter-clockwise 180°, camshaft will rotate-90° ready-for-adjusting-MAG-side-valves-clearance.

NOTE: PTO piston is at TDC on compression stroke when belt pulley mark shows downwards. MAG piston is at TDC on compression stroke when belt pulley mark is at 3 o'clock position.

29, Valve cover

Install valve covers with their tabs towards bottom.





- 1. Molykote G-N
- 2. Stud M8 x 235 (4)
- 3. O-ring (2)
- 4. Return tube (2)
- 5. Stud M8 x 150 (2)
- 6. Oil pressure tube
- 7. O-ring (2)
- 8. Silastic RTV 732
- 9. O-ring (2)
- 10. Cable grommet
- 11. Upper crankcese half
- 12. Gasket ring
- 13. Hexagonal socket head screw M8 x 12
- 14. Oil seal (2)
- 15. Ball bearing 6207 (2)
- 16. Distance shim 1.5 mm (2)
- 17. O-ring (2)
- 18. Woodruff key (2)
- 19. Medium strength threadlocker. Loctite 242
- 20. Crankshaft ass'v
- 21. Oil seal holder
- 22. Paste gasket

Loctite 515

- 23. Lower crankcase half
- 24. Nipple
- Loctite 620 25, High temp, threadlocker
- 26. O-ring
- 27. Return oil cover
- 28. Lock washer (5)
- 29. Hexagonal socket head screw МБ 📈 б (Б)
- 30. Hexagonal socket head screw M8 x 65 (2)
- 31, Lock washer 8 mm (6)
- 32. Lock washer 6 mm (6)
- 33. Hexagonal socket head scraw M6 x 30 (6)
- 34. Stud M10 x 29/20 (4) 35. Lock washer 10 mm (4)2
- 36. Hexagonal nut M10 (4)
- 37. Hexagonal socket head screw M8 x 60 (4)
- 38. Distance sleeve (4)
- 39, Timing pulley 15 👩
- 40. Ball bearing 6306.
- 41. Cover disc
- 42. Bearing housing
- 43. Screw M8 x 30 (4)

NOTE: Engine must be removed from chassis to perform the following procedures.

CLEANING

Discard all oil seals, gaskets and O-rings.

Clean all metal components in a non-ferrous metal cleaner.

Remove old paste gasket from crankcase mating surfaces sealant stripper with

CAUTION: Never use a sharp object to scrape away old paste gasket as score marks incurred are detrimental to crankcase sealing.

DISASSEMBLY

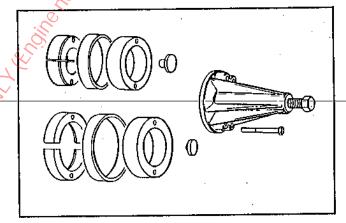
General

Remove top end as describled above.

To remove magneto, refer to section 02-11 "Magneto".

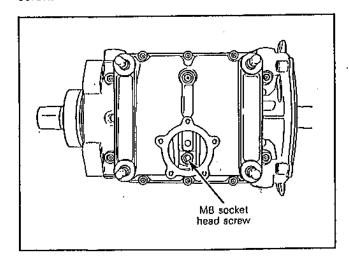
15, Ball bearing

To remove bearings from crankshaft, use a protective cap and special puller, as illustrated (see "Tools" section).



27,30, Return oil cover & socket head screw

Remove return oil cover to gain access to M8 socket head screw.



INSPECTION

The inspection of the engine bottom end must include the following measurements:

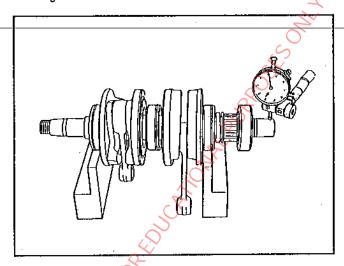
TOLERANCES				
MEASUREMENTS	NEW I	ING PARTS (Max.)	WEAR LIMIT	
Crankshaft deflection		-	0.05 mm (0.002 in)	
Connecting rod big end axial play	0.6 mm (.024 ln)	0.88 mm (,035 in)	1.50 mm (.059 in)	

20, Crankshaft

Deflection

Crankshaft deflection is measured at each end with a dial indicator.

First, check deflection with bearings installed. If deflection exceeds the specified tolerance, it can either be ball bearing wear or bent crankshaft. Remove crankshaft bearings and rechecked deflection.

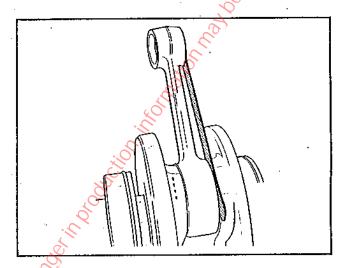


NOTE: Crankshaft deflection can not be correctly measured between centers of a lathe.

If deflection exceeds the specified tolerance, crankshaft should be repaired or replaced.

Connecting rod big end axial play

Using a feeler gauge, measure distance between thrust washer and crankshaft counterweight. If the distance exceeds specified tolerance, repair or replace crankshaft.

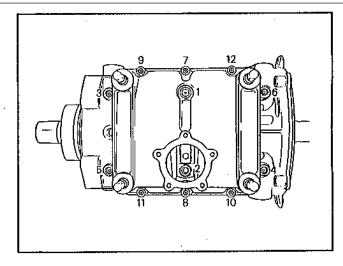


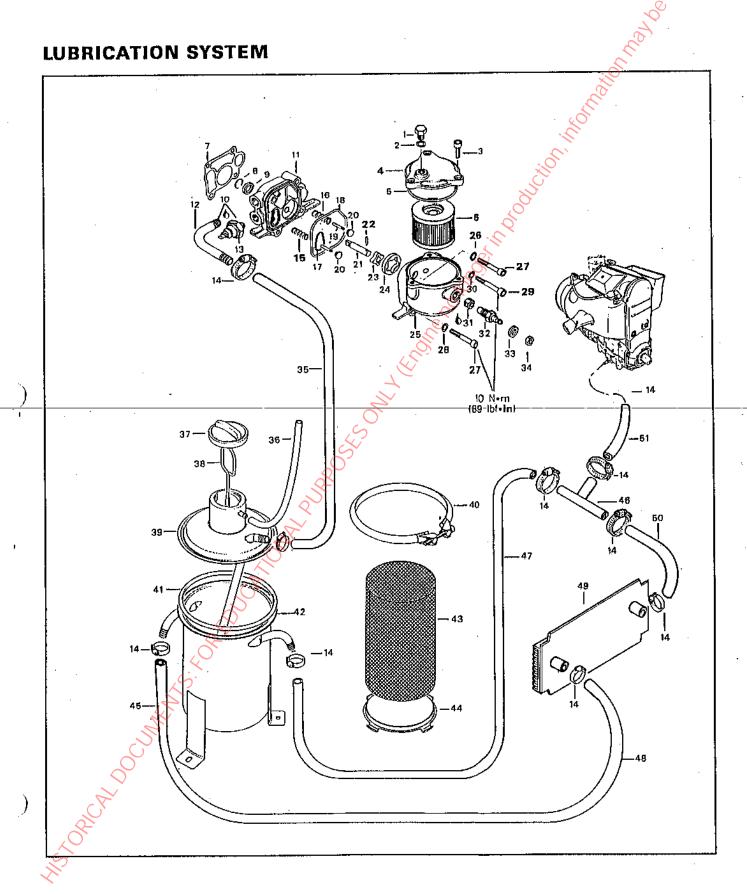
ASSEMBLY

Assembly is essentially the reverse of disassembly procedure. However pay particular attention to the following.

30,33,37, Socket head screw

Torque screws 1 to 6 to 22 N•m (17 lbf•ft) and screws 7 to 12 to 10 N•m (89 lbf•in) in following sequence.





- 1. Bleeder screw M8 x 9
- 2. Gasket ring
- 3. Socket head screw M6 x 30
- 4. Oil filter cover
- 5. O-ring
- 6. Oil filter 7. Gasket
- 8. Retaining ring
- 9. Oil seal 8 x 14 x 4
- 10. High temperature threadlocker Loctite 620
- 11. Oll pump housing
- 12. Angular tube M12 x 1.5
- 13. Oil pressure switch M10 x 1
- 14. Clamp ()
- 15. Compression spring 13.0
- 16. Compression spring
- 17. O-ring
- 18. O-ring
- 19. Valve pin (2)
- 20. Pressure retaining valve
- 21. Pump shaft
- 22. Needle pin
- 23. Pressure inner rotor
- 24. Pressure outer rotor
- 25. Oil filter housing
- 26. Friction washer 6 mm

- 27. Socket head screw M6 x 40
- 28. Lock washer (3)
- 29. Socket head screw M6 x 45 (2)
- 30. Adaptor
- 31. Pipe sealant Loctite 592
- 32. High temperature switch
- 33. Lock washer
- 34. Nut
- 36. Inlet tube
- 36. Vent tube
- 37. Oil tenk cap
- 38. Oil dipstick
- 39. Oil tank cover
- 39. Oil tank cover
- 40. Clamp 41. O-ring
- 42. Oil tank
- 43. Baffle insert
- 44, Partition ...
- 45. Oil tank inlet tübe
- 45. Oli tank intel tobe
- 46 Thermostet
- 47. By-pass tube
- 48. Oil tank inlet tube
- 49. Radiator
- 50. Radiator inlet tube
- 51. Engine return tube

TECHNICAL DATA

Oil system capacity:

2.5 L (2.2 imp. quarts - 2.64 US quarts)

Oil pump pressure:

100-150 kPa (14.5-21.8 PSI) at 6000 RPM and oil temperature 140°C (284°F)

Oil pump delivery capacity :

1 L/min. at 6000 RPM

NOTE: The following procedures can be done without removing the engine from chassis.

REMOVAL

Without removing engine from chassis

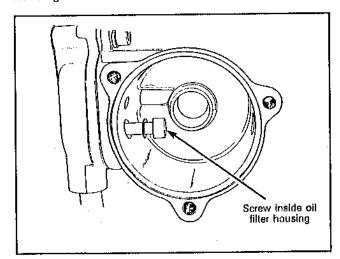
Fan housing has to be removed to gain access to lower rear screw of oil filter housing. To do so, remove fan guard, rewind starter, v-belt pulley, flywheel (refer to "CDI magneto" sub-section 02-11 for proper installation) then move fan housing aside.

4,6, Oil filter cover & oil filter

Remove oil filter cover and oil filter then siphon oil from oil filter housing.

26,27,29, Friction washer 6 mm & screw

Remove four screws retaining oil filter housing and oil pump_housing._One_screw_is_located_inside_oil_filter housing.



DISASSEMBLY

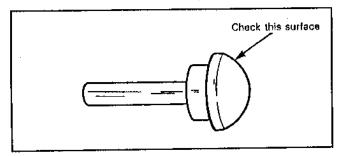
21,22, Pump shaft & needle pin

Needle pin is not press fit thus take care not to lose it.

INSPECTION

20, Pressure retaining valve

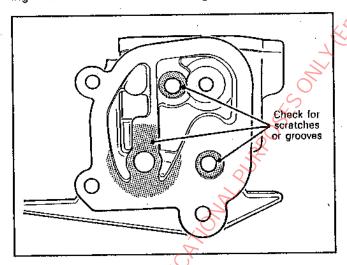
Check for grooved or scored surface, if so, replace.



25, Oil filter housing

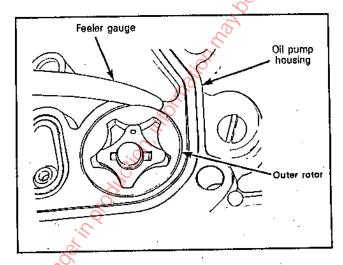
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Pressure retaining valve seating surfaces and oil pump mating surface should be smooth. Replace oil filter housing if surfaces are scratched or grooved.



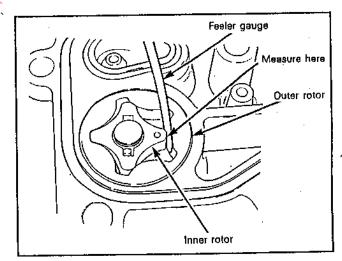
11,24, Oil pump housing & pressure outer rotor

Measure clearance between outer rotor and oil pump housing. If measurement is not between 0.11 and 0.19 mm (.0043 and .0075 in), replace oil pump housing.



23,24, Pressure inner rotor & pressure outer rotor

If tip clearance between inner rotor and outer rotor is not between 0.01 and 0.10 mm (.0004 and .0039 in), replace inner and outer rotor.



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ASSEMBLY

15,16, Spring

CAUTION: Do not mismatch pressure valve springs. Spring #15 is the softest.

Stifest spring goes on left hand valve which is the oil pressure relief valve. Softest spring goes on oil passage to cylinder head. It prevents oil fifter housing from draining when engine is stopped.

27,29, Screw

Torque screws in a crisscross sequence to 10 N•m (89 lbf•in).

OIL CHANGE

Siphon oil from oil tank or remove oil tank. Remove baffle insert and clean interior of oil tank.

Oil replenish

Install a new oil filter and refill oil filter housing with low temperature 4-stroke motor oil

Refill oil tank up to upper mark on dipstick. Start engine and open bleeder screw until oil begins to flow.