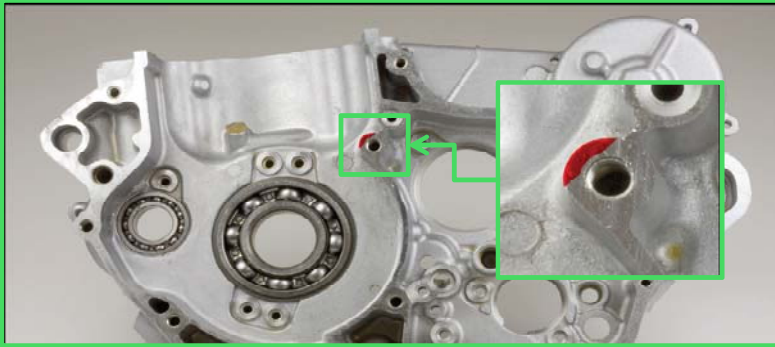


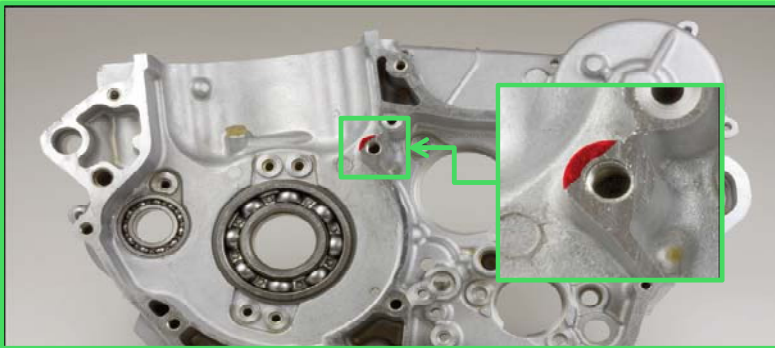
### SPECIAL INSTRUCTIONS FOR INSTALLING 4182 AND 4194 KX 450F STROKER CRANKS

- With addition of a 3mm stroke; interference will occur between the rear piston skirt and crankcase bolt boss at the bottom of the stroke.
- The crankcase must be relieved to a minimum piston to case clearance of 2mm (.080") — care must be taken to not expose the bolt hole.
- The amount of relief cut will vary with larger bore sizes and aftermarket pistons.
- This procedure must be performed before final case assembly and is best performed on a bare case with all bearings removed.



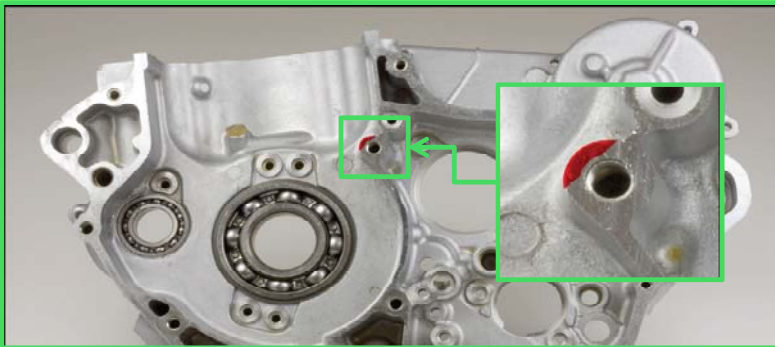
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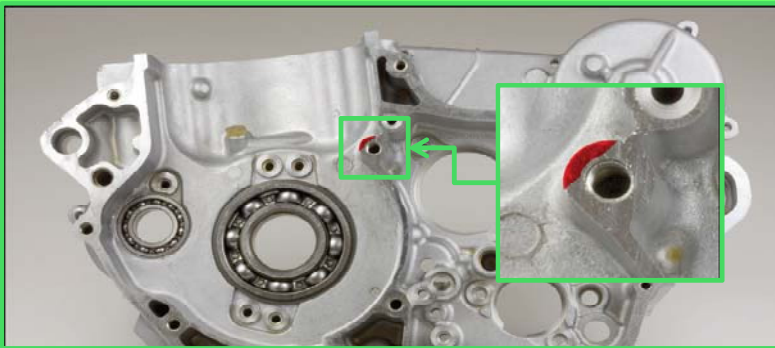
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