

# NEWS BULLETIN

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Title: CFR Octane Cylinder Overhaul Kits

Bulletin No. 03-02

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The purpose of this CFR News Bulletin is to inform customers that Waukesha Engine has released four new CFR cylinder overhaul kits based on P/N FA109355. The kits will be offered for standard, 0.010", 0.020", and 0.030" size cylinders. These kits will allow customers to confidently rebuild their cylinder assemblies with all new components and will ensure critical manufacturing tolerances listed under the ASTM method are met. These kits also offer the customer a convenient way to purchase overhaul parts as a set. The four cylinder overhaul kits and their respective parts are listed on page 2.

Waukesha also announces that it can rebuild your cylinders for you. Do you know what you are paying for when you get a cylinder overhaul? Tired of paying top dollar for poor quality overhauls that do not meet the rating requirements listed in ASTM? Do the parts in your cylinder overhaul meet the critical requirements of the ASTM methods?

For customers who do not want to perform their own overhauls and would like to have their cylinders rebuilt for them, Waukesha offers cylinder rebuilds that are backed by a one-year warranty against defects and workmanship. Waukesha uses the complete cylinder kits for cylinder overhauls. By doing so the customer can have peace of mind that they will have a quality cylinder that will give them dependable rating performance while meeting critical part tolerances required in the ASTM methods.

What does a Waukesha rebuild entail?

1. Cylinder is received and inspected for damage.

2. Cylinder is completely disassembled to a bare casting and thoroughly cleaned.
3. After cleaning, the cylinder is inspected and measured to determine if bore is within the wear tolerance. If the bore is within tolerance then it goes to the honing unit to have the finish put back in the bore (cross-hatching). If the cylinder bore is out of specification, the cylinder is sent to the honing unit and is honed to the correct manufacturing tolerances/size, as well as having the correct finish put on it. (Customer will be contacted if damage on cylinder is extensive or if rebuilding is not possible).
4. When the cylinder has been re-sized and has had the correct finish put on the bore, new seats are installed and new valves are lapped. Then the cylinder is thoroughly washed a second time.
5. The cylinder is then rebuilt using all new components meeting the manufacturer's tolerances. (See kit listings on page 2.)
6. After being rebuilt, the cylinder is painted, inspected, and then carefully packaged and sent back to the customer ready for use.

*NOTE: If the clamping sleeve is sent with the cylinder, it will be toleranced along with the internal components and replaced if necessary. Cost for sleeve or sleeve components are in addition to the cost of the cylinder overhaul.*

As mentioned before, Waukesha offers a one-year warranty covering defects and workmanship on any rebuilt cylinder starting from the day it is received. Current lead times are 3-4 weeks. If you are interested in having your cylinder(s) repaired by Waukesha or would like to have more information about the overhaul kits, please contact Waukesha's CFR Department at (262) 549-2915.



**Service Cylinder Part Kit – G-801-5 (Standard)**

P/N	ITEM	QTY.
105208	Carburetor Stud	4
23436A	Intake Valve	1
26800	Roll Pin	1
106625	Exhaust Valve	1
106420A	Valve Spring Cup	1
106424	Cup Gasket	1
B4680	Felt Washer	2
43335C	Valve Spring	1
106523	Valve Taper	2
106407	Valve Spring Retainer	1
O109657	Roto Cap Assembly	1
105987A	STD Seat Insert	2
109658	Valve Keeper	2
B2575	Exhaust Studs	2
23109A	Guide	1
23109B	Guide	1
AA23204G	STD Piston Assembly	1
23505	Oil Ring	1
78282A	Pipe Plug	1
106222A	Compression Rings	3
106222B	Chrome Ring	1

**Service Cylinder Part Kit – G-801-6 (0.010")**

P/N	ITEM	QTY.
105208	Carburetor Stud	4
23436A	Intake Valve	1
26800	Roll Pin	1
106625	Exhaust Valve	1
106420A	Valve Spring Cup	1
106424	Cup Gasket	1
B4680	Felt Washer	2
43335C	Valve Spring	1
106523	Valve Taper	2
106407	Valve Spring Retainer	1
O109657	Roto Cap Assembly	1
105987A	STD Seat Insert	2
109658	Valve Keeper	2
B2575	Exhaust Studs	2
23109A	Guide	1
23109B	Guide	1
AA23204G1	STD Piston Assembly	1
23505 1	Oil Ring	1
78282A	Pipe Plug	1
106222A1	Compression Rings	3
106222B1	Chrome Ring	1

**Service Cylinder Part Kit – G-801-7 (0.020")**

P/N	ITEM	QTY.
105208	Carburetor Stud	4
23436A	Intake Valve	1
26800	Roll Pin	1
106625	Exhaust Valve	1
106420A	Valve Spring Cup	1
106424	Cup Gasket	1
B4680	Felt Washer	2
43335C	Valve Spring	1
106523	Valve Taper	2
106407	Valve Spring Retainer	1
O109657	Roto Cap Assembly	1
105987A	STD Seat Insert	2
109658	Valve Keeper	2
B2575	Exhaust Studs	2
23109A	Guide	1
23109B	Guide	1
AA23204G2	STD Piston Assembly	1
23505 2	Oil Ring	1
78282A	Pipe Plug	1
106222A2	Compression Rings	3
106222B2	Chrome Ring	1

**Service Cylinder Part Kit – G-801-8 (0.030")**

P/N	ITEM	QTY.
105208	Carburetor Stud	4
23436A	Intake Valve	1
26800	Roll Pin	1
106625	Exhaust Valve	1
106420A	Valve Spring Cup	1
106424	Cup Gasket	1
B4680	Felt Washer	2
43335C	Valve Spring	1
106523	Valve Taper	2
106407	Valve Spring Retainer	1
O109657	Roto Cap Assembly	1
105987A	STD Seat Insert	2
109658	Valve Keeper	2
B2575	Exhaust Studs	2
23109A	Guide	1
23109B	Guide	1
AA23204G3	STD Piston Assembly	1
23505 3	Oil Ring	1
78282A	Pipe Plug	1
106222A3	Compression Rings	3
106222B3	Chrome Ring	1