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## **IM70 Iron Maiden Cylinder Assembly**

**IMPORTANT NOTICE:** Please be advised that there is no warranty coverage for stripped cylinder head nuts. To ensure proper installation and prevent damage, we strongly recommend using a torque wrench.



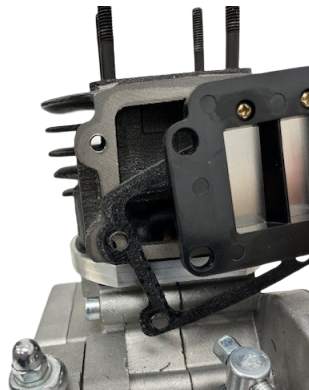
1. Once the piston is installed (arrow pointing forward), slide the crankcase gasket into place.



2. Slide the CNC spacer plate on followed by the spacer gasket.



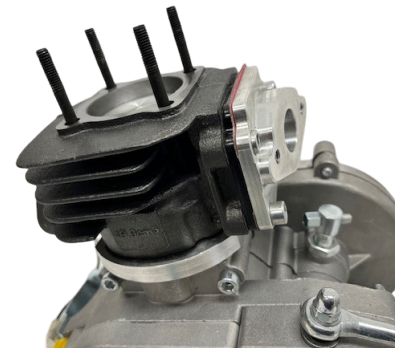
3. Next, slide the cylinder into place making sure it is facing the correct way.



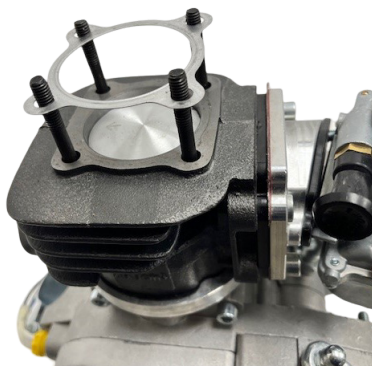
4. On the intake side of the cylinder, line up the reed valve gasket, then the reed valve.



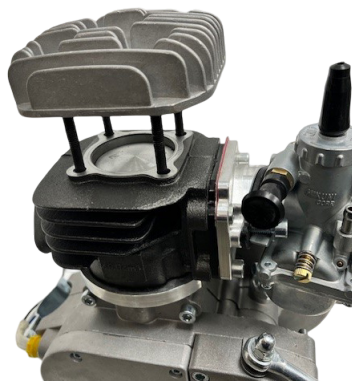
5. Then, line up the intake gasket and the CNC intake.



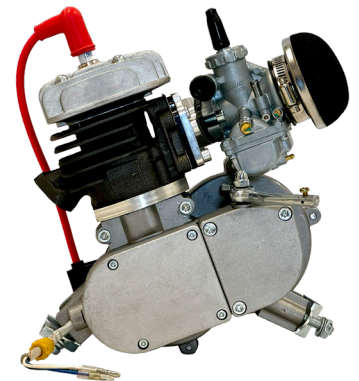
6. Bolt the reed valve gasket, reed valve, intake gasket, and CNC intake onto the cylinder.



7. Slide the head gasket, raised inner edge facing down, onto the cylinder.



8. Place on the head, washers, lock washers, and nuts then torque to 12 ft./lbs.



**Fully assembled engine with carburetor and spark plug mounted.**

# ***IM70 Iron Maiden Cylinder Assembly***



- 1. Crankcase Gasket
- 2. CNC Spacer Plate
- 3. Spacer Gasket
- 4. Minarelli Style Iron Cylinder
- 5. Reed Gasket

- 6. Flat Reed Valve
- 7. Intake Gasket
- 8. CNC Air Intake
- 9. Cylinder Head Gasket
- 10. Cylinder Head