



January 4, 2025,

TILLOTSON USA INFORMATION BULLETIN: 2025/TB-2

REGARDING: The Tillotson 225 RS Standard (GRN-1) and High Output (GEN-2) Engine.

- **Head Bolts Torque Specifications reduced from 37Nm(27.29 F/lbs.) to 26Nm(19.17 F/lbs.):** We measured the cylinders after torquing them to various forces and noticed that the cylinder was moving out of shape with a higher torque value on the cylinder head bolts. We have since been recommending the 26Nm to avoid twisting the cylinder so we can maintain performance.
- **Side Cover Bolts:** The Gen2 Engine generates more compression at higher rpm, which creates more vibration. So, we have **increased the torque to 33Nm (24.27 F/lbs.) on the side cover and are applying Red Loctite** to prevent any bolts from coming loose.
- Please follow the following procedure during the initial break-in, or when removing the head, or for any reason.
 - Before break-in, ensure the head is torqued to the abovementioned torque values.
 - After the first 15 minutes of break-in, re-torque the head
 - After 30 minutes of use, check and re-torque the head if necessary
- Setting and maintaining the proper float height ensures the engine operates at the appropriate temperature. The float height should be set between .390" and .400". These measurements will provide sufficient fuel for proper temperature control and performance

Accompanying this Bulletin is a recommended Maintenance Schedule