



THIS DOCUMENT REPRESENTS THE TECHNICAL CHANGES TGB HAS IMPLEMENT ON THE 2006 UNITS. REFER TO THE SUMMARY PAGE FOR THE VIN #S OF WHEN THE CHANGES WERE PUT INTO PRODUCTION. ATTACHED IS 10 BULLETINS REFERRING TO AREAS OF CONCERN AND THE SPECIFIC CHANGES TGB MADE TO RECTIFY SUCH ISSUES.

2006 Warranty Claims and Improvement Table

Item	Problems and Descriptions	Solutions and Countermeasures	Improved date	Improved Frame No.	Attached Files
1	crankshaft middle bearing defect	1.low down engine rpm 2. Modify oil fill position and oil qtt.	2006.09.28	634670	sheet 1
2	stator defect	change supplier and check quality	2006.09.28	634670	sheet 2
3	fan cooling broken	1.change material 2. four bolts type used	2006.09.28	634670	sheet 3
4	fuel cock	change supplier	2006.03.22	623188	sheet 4
5	fuel tank cap	new supplier and full inspection	2006.06.01	628916	sheet 5
6	CDI defect	twin fuse design and change plug color from green to red	2006.06.01	628900	sheet 6
7	R50X steering lock assy. defect due to front fender and waterproof function NG	1. modify R50X front fender. 2. paint some isolation glue on the terminals of main switch, tin terminals and add a rubber cover as well.	2006.10.04	635002	sheet 7
8	turn signal relay waterproof issue	modify R50X front fender and evaluate relay fix direction	2006.10.04	635002	
9	smooth throttle cable	1.modify cable angle 2.modify fixing bolt 3.modify throttle housing and grip model	2006.09.28	634670	sheet 8
11	speedometer gear and speedometer cable damaged by salt, dirt, normal use	add a rubber cover	2006.09.28	634670	sheet 9
12	R50X tail pipe crack (broken)	weld an bracket to support	2006.10.04	635002	sheet 10
13					
14					

TGB TECHNICAL BULLETIN

Topic:

engine maintenance of crankshaft defect at con rod big end bearing

Scope:

for all scooter 50 cc engines

Current condition and problems:

We received claims that big end bearing of con rod melted within short mileage(see picture 1, 2, 3, 4).

Countermeasure:

Modifications are as below.

1) original oil supply system (see picture 5): oil pump pumps oil to a) carburetor and b) both L. and R. side check valves of intake pipe Assy.

2) new oil supply system (see picture 6): oil pump pumps oil to a) carburetor and b) check valve on intake pipe Assy.

2-1) parts replaced:

A) replace with new crankshaft(having washers at both side)(see Picture 7)

A) cancel three way check valve Assy.(part no. 425038, see Picture 8)

B) replace original intake pipe Assy. (part no.421001, see Picture 9). with new intake pipe Assy. (part no.421001A, see Picture 10).

C) Connect oil pump and new intake pipe Assy. with an oil tube (part no. GA605PP02, see Picture 11).

3) Note-1: while re-building an engine, be sure to follow below steps:

A) add oil on con rod big end bearing

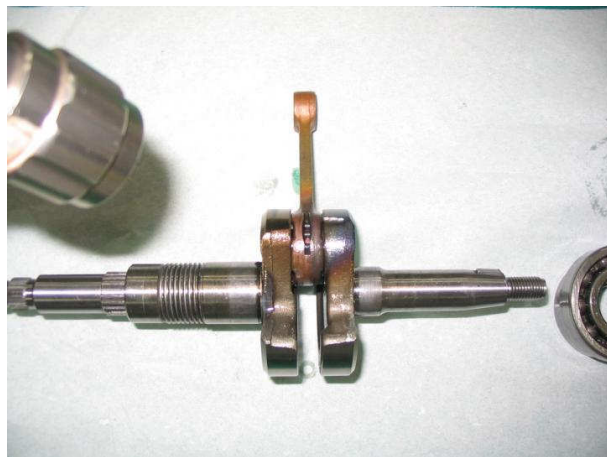
B) add oil on bearing, LH (part no. GA505BR04) and bearing, RH (part no. GA505BR03) of crankcase

C) while connecting this check valve and oil pump Assy. with this new tube, this tube should full of oil.

Note-2: please also be informed that this project has already put into mass production after frame no. **634670**.

as example :

Picture 1 : defect crankshaft



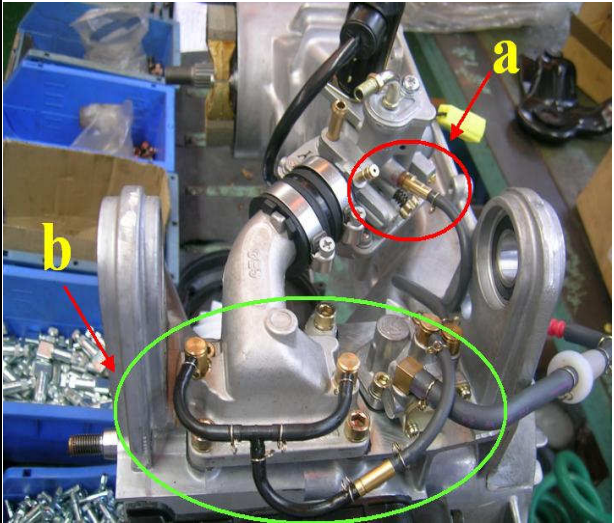
Picture 2 : defect crankshaft



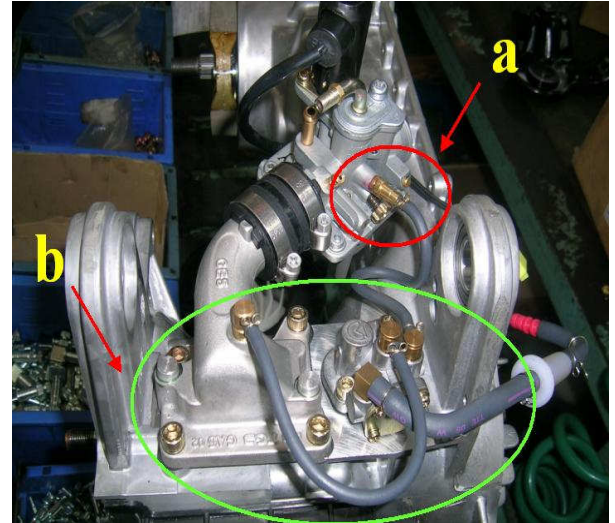
Picture 3 : defect crankshaft



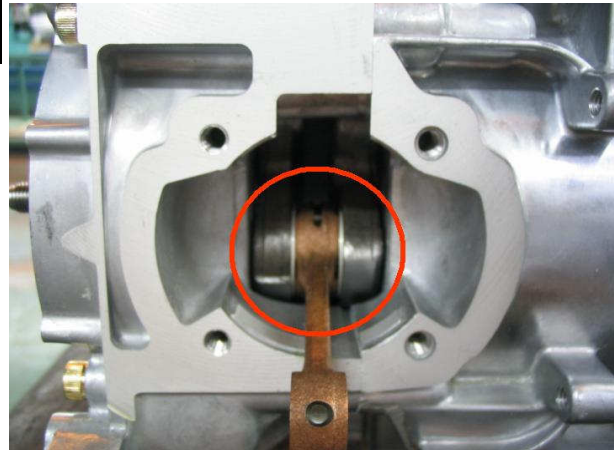
Picture 4 : defect crankshaft



Picture 5: Original oil supply system



Picture 6: New oil supply system



Picture 7 : new crankshaft



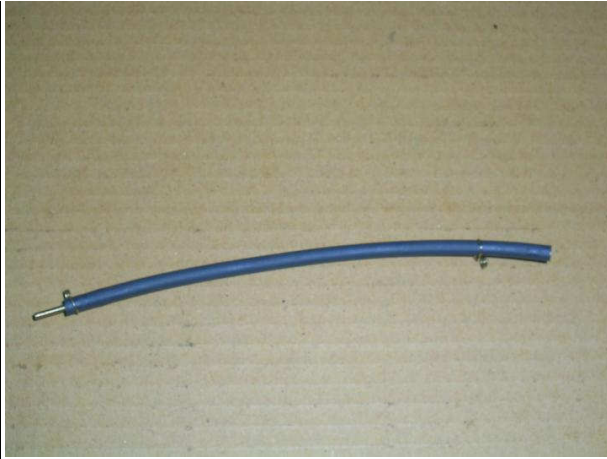
Picture 8: three way check valve assy. (part number 425038)



Picture 9: Original intake pipe assy.



Picture 10: new intake pipe assy.(part no. 421001A) including an new oil tube (part no. GA605PP02)



Picture 11: new oil tube (part no. GA605PP02)

TGB TECHNICAL BULLETIN

Topic:

Four coils stator (part no.GE5139904)

Scope:

All two stroke 50cc and 90cc engines (besides 50cc and 90cc R50X model)

Current condition and problems:

We received claims that our scooters would suddenly turn off and then could not start anymore due to stator problem.

Countermeasure:

1. Change stator supplier
2. To execute full inspection
3. Modify the plug from white color to blue color

Put into mass production frame number:

After frame no. 634670 is a modified one

as example :



Picture 1 : original stator (white color plug)



Picture 2 : new stator (blue color plug)

TGB TECHNICAL BULLETIN

Topic:

Fan cooling (part no. GA608PL10)

Scope:

All two stroke 50cc and 90cc engines

Current condition and problems:

We received claims that cooling fan (part no. GA608PL10) is easy to be defect.

Countermeasure:

1. Use 100% PP material
2. Modify two-hole type to four-hole type

Put into mass production frame number:

After frame no. 634670 is a modified one

as example :



four-hole cooling fan (part no. GA608PL10)

TGB TECHNICAL BULLETIN

Topic:

Fuel cock

Scope:

All models

Current condition and problems:

To extinguish the possibility of engine stop due to fuel cock problem .

Temporal Countermeasure:

Change fuel cock supplier

Put into mass production frame number:

After frame no. 623188 is a modified one

as example :



LH is original, RH is new

TGB TECHNICAL BULLETIN

Topic:

engine stop issue

Scope:

101S model

Current condition and problems:

Engine stops due to fuel tank cap problem

Countermeasure:

Modify the fuel tank cap with a hole.

Put into mass production frame number:

After frame no. 628916 is a modified one

Introduction:

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TGB TECHNICAL BULLETIN

Topic:

Electric part-C.D.I.

Scope:

All 50cc engines

Current condition and problems:

To extinguish the possibility of stop engine due to C.D.I. problem .

Countermeasure:

Redesign C.D.I.

Put into mass production frame number:

After frame no. 628900 is a modified one

as example :

New C.D.I. Is red color

TGB TECHNICAL BULLETIN

Topic:

water inside headlight assy. Issue

Scope:

R50X model

Current condition and problems:

fog(water) inside headlight

Countermeasure:

1. Modify the front fender.
2. Modify the mold of headlight to enhance waterproof function.

Put into mass production frame number:

After frame no. 635002 is a modified one

Introduction:**1. Modify the front fender.**

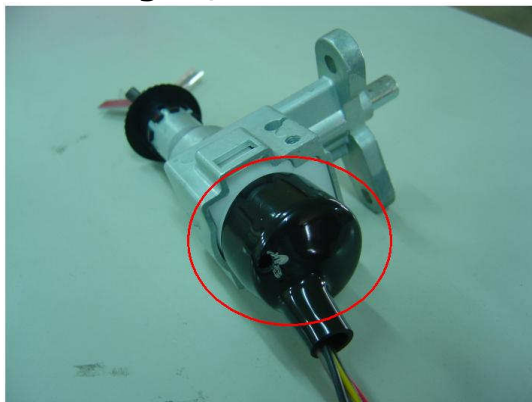
before Modified



after Modified

**2. Modify main switch assy.**

isolation glue, tin terminals and rubber cover



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TGB TECHNICAL BULLETIN

Topic:

throttle cable modified issue

Scope:

All model scooter.

Current condition and problems:

throttle cable can not work smoothly

Countermeasure:

1. Modify the angle of throttle cable metal shape.
2. Mounting extra hook and stopper .
3. Modify the mold of handle bar.

Put into mass production frame

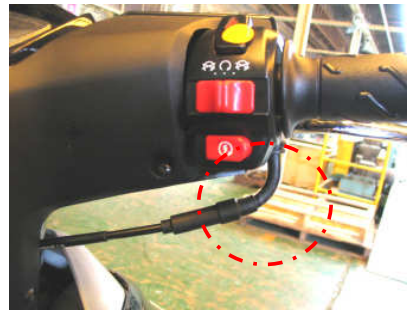
After frame no. 634670 is a modified one

Introduction:**1. Modify the angle of throttle cable shape.**

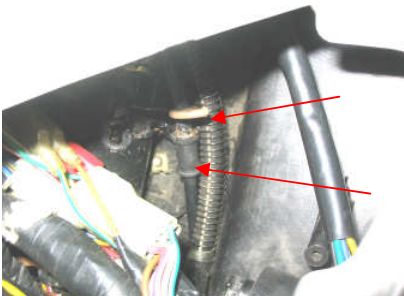
101S



R50X



303

**2. Mounting the hook and stopper .**

TGB TECHNICAL BULLETIN

No.20060911

Topic:

speedometer gear and cable endurance and reliability issue.

Scope:

All model scooter.

Current condition and problems:

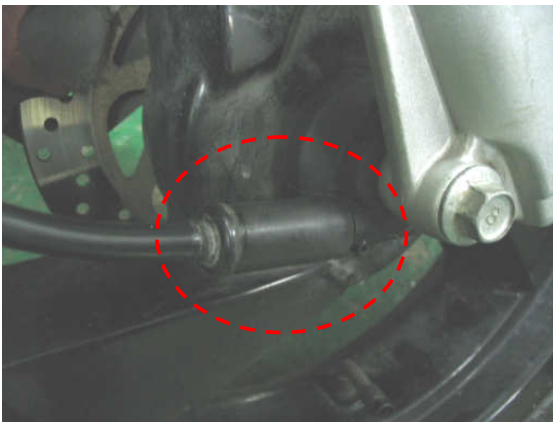
speedometer gear and cable damaged by salt or dirt.

Countermeasure:

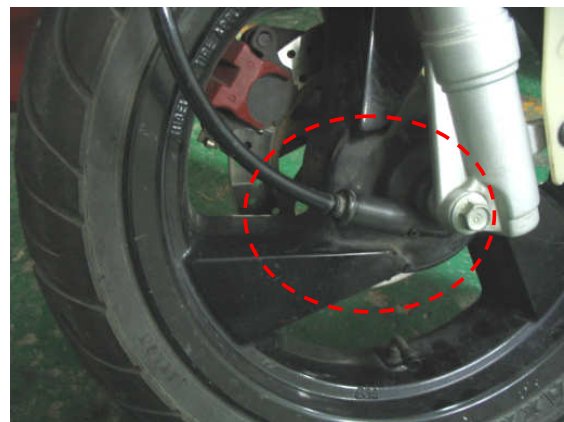
Install extra rubber cover on the speedometer cable to protect from salt and dirt.

Put into mass production frame

After frame no. 634670 is a modified one

Introduction:

speedometer cable part no. 411630



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TGB TECHNICAL BULLETIN

No.20060911

Topic:

Enhance the quality of muffler assy.

Scope:

R50X model

Current condition and problems:

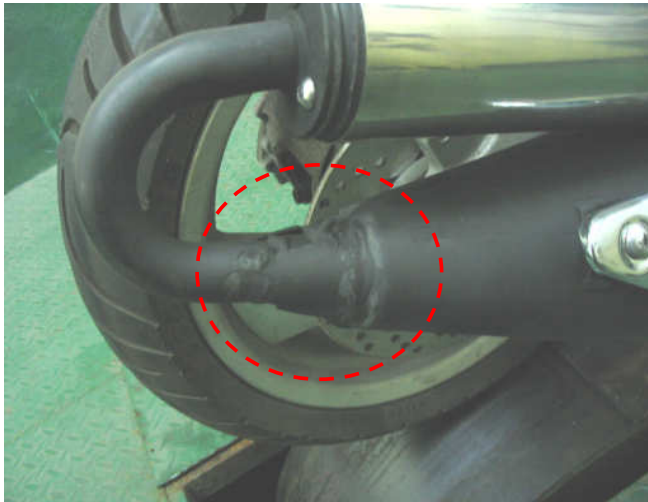
tail pipe crack (broken)

Countermeasure:

1. Enhance the welding of tail pipe.
2. Changed flange screw .

Put into mass production frame number:

After frame no. 635002 is a modified one

Introduction:**1. Enhance the welding to strength of tail .****2. Modified the screw .**

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