

GENERAL INFORMATION

Unit: mm (in)

Unit: mm (in)

CYLINDER/PISTON ITEM			STANDARD	SERVICE LIMIT
Cylinder	I.D.		100.000 – 100.015 (3.9370 – 3.9376)	100.05 (3.939)
	Taper		_____	0.05 (0.002)
	Out of round		_____	0.05 (0.002)
	Warpage		_____	0.05 (0.002)
Piston, pistonrings	Piston mark direction		“IN” mark facing toward the intake side	_____
	Piston O.D.		99.96 – 99.99 (3.935 – 3.937)	99.86 (3.931)
	Piston O.D. measurement point		20 mm (0.8 in) from bottom of skirt	_____
	Piston pin bore I.D.		23.002 – 23.008 (0.9056 – 0.9058)	23.03 (0.907)
	Piston pin O.D.		22.994 – 23.000 (0.9053 – 0.9055)	22.98 (0.905)
	Piston-to-piston pin clearance		0.002 – 0.014 (0.0001 – 0.0006)	0.04 (0.002)
	Piston ring-to-ring groove clearance	Top	0.045 – 0.080 (0.0018 – 0.0031)	0.095 (0.0037)
		Second	0.025 – 0.060 (0.0010 – 0.0024)	0.075 (0.0030)
	Piston ring end gap	Top	0.25 – 0.40 (0.010 – 0.016)	0.55 (0.022)
		Second	0.40 – 0.55 (0.016 – 0.022)	0.70 (0.028)
		Oil (side rail)	0.20 – 0.70 (0.008 – 0.028)	0.90 (0.035)
	Piston ring mark	Top	“R” mark	_____
		Second	“RN” mark	_____
Cylinder-to-piston clearance			0.010 – 0.055 (0.0004 – 0.0022)	0.19 (0.007)
Connecting rod small end I.D.			23.020 – 23.041 (0.9063 – 0.9071)	23.05 (0.907)
Connecting rod-to-piston pin clearance			0.020 – 0.047 (0.0008 – 0.0019)	0.067 (0.0026)

Unit: mm (in)

CLUTCH/KICKSTARTER/GEARSHIFT LINKAGE		STANDARD	SERVICE LIMIT
ITEM			
Clutch	Clutch lever free play	10 – 20 (3/8 – 13/16)	—
	Spring free length	49.0 (1.93)	46.0 (1.81)
	Disc thickness	A (6 discs)	3.22 – 3.38 (0.127 – 0.133)
		B (1 disc)	2.92 – 3.08 (0.115 – 0.121)
	Plate warpage	—	0.30 (0.012)
	Clutch outer I.D.	29.000 – 29.021 (1.1417 – 1.1426)	29.05 (1.144)
	Outer guide	I.D.	21.990 – 22.035 (0.8657 – 0.8675)
		O.D.	28.959 – 28.980 (1.1401 – 1.1409)
	Mainshaft O.D. at clutch outer guide	21.967 – 21.980 (0.8648 – 0.8654)	21.94 (0.864)
	Starter idle gear I.D.	23.000 – 23.021 (0.9055 – 0.9063)	23.11 (0.910)
Kickstarter	Starter idle gear bushing	I.D.	20.013 – 20.031 (0.7879 – 0.7886)
		O.D.	22.959 – 22.980 (0.9039 – 0.9047)
	Kickstarter pinion gear I.D.	22.020 – 22.041 (0.8669 – 0.8678)	22.09 (0.870)
	Kickstarter spindle O.D.	21.959 – 21.980 (0.8645 – 0.8654)	21.91 (0.863)
	Countershaft O.D. at starter idle gear	19.980 – 19.993 (0.7866 – 0.7871)	19.94 (0.785)