

GENERAL INFORMATION

CYLINDER HEAD/VALVE SPECIFICATIONS

ITEM			STANDARD	SERVICE LIMIT
Cylinder compression			1,177 kPa (13.6 kgf/cm ² , 177 psi) at 350 rpm	—
Valve clearance		IN	0.20 ± 0.03 (0.008 ± 0.001)	—
		EX	0.26 ± 0.03 (0.010 ± 0.001)	—
Camshaft	Cam lobe height	IN	37.66 ± 0.02 (1.483 ± 0.001)	37.66 (1.472)
		EX	37.74 ± 0.02 (1.487 ± 0.001)	37.64 (1.470)
	Runout		—	0.06 (0.002)
	Oil clearance		0.33 ± 0.002 (0.0008 ± 0.0001)	0.06 (0.004)
Valve lifter	Valve lifter O.D.		26.978 ± 0.002 (1.0230 ± 0.0001)	26.97 (1.022)
	Valve lifter bore I.D.		26.050 ± 0.002 (1.0248 ± 0.0001)	26.04 (1.023)
Valve, valve guide	Valve stem O.D.	IN	4.975 ± 0.002 (0.1959 ± 0.0001)	4.965 (0.1952)
		EX	4.960 ± 0.002 (0.1953 ± 0.0001)	4.950 (0.1949)
	Valve guide I.D.		5.000 ± 0.012 (0.1969 ± 0.0001)	5.040 (0.1984)
	Stem-to-guide clearance		0.010 ± 0.007 (0.0004 ± 0.0001)	—
	Valve guide projection above cylinder head	IN	0.035 ± 0.002 (0.0010 ± 0.0001)	—
		EX	0.035 ± 0.002 (0.0010 ± 0.0001)	—
	Valve guide projection above cylinder head		16.3 ± 0.5 (0.64 ± 0.01)	—
Valve seat width		IN/EX	0.90 ± 0.10 (0.035 ± 0.004)	1.0 (0.040)
Valve spring free length		IN/EX	43.52 (1.7133)	41.5 (1.63)
Cylinder head warpage			—	0.50 (0.020)

ALTERNATOR/STARTER CLUTCH SPECIFICATIONS

ITEM	STANDARD	SERVICE LIMIT
Starter gear gear mesh O.D.	51.885 ± 0.118 (2.0434 ± 0.0047)	51.684 (2.0348)

CRANKSHAFT/BALANCER/PISTON SPECIFICATIONS

ITEM			STANDARD	SERVICE LIMIT
Crankshaft	Connecting rod side clearance		0.15 ± 0.36 (0.006 ± 0.012)	0.30 (0.012)
	Crankpin bearing oil clearance		0.028 ± 0.002 (0.0010 ± 0.0001)	0.06 (0.002)
	Main journal oil clearance		0.018 ± 0.002 (0.0007 ± 0.0001)	0.045 (0.0018)
	Balancer oil clearance		0 ± 0.05 (0 ± 0.0020)	0.06 (0.002)
	Runout		—	0.3 (0.01)
Piston, piston rings	Piston O.D. at 4 (0.2) from bottom		76.970 ± 0.002 (3.1099 ± 0.0001)	76.90 (3.106)
	Piston pin hole I.D.		22.652 ± 0.002 (0.8917 ± 0.0001)	22.63 (0.891)
	Piston pin O.D.		21.954 ± 0.002 (0.8643 ± 0.0001)	21.954 (0.8643)
	Piston-to-piston pin clearance		0.002 ± 0.014 (0.0001 ± 0.0001)	—
	Piston ring end gap	Top	0.175 ± 0.025 (0.0069 ± 0.001)	0.48 (0.019)
		Second	0.48 ± 0.05 (0.019 ± 0.002)	0.7 (0.028)
		Oil (after test)	0.2 ± 0.8 (0.01 ± 0.03)	1.0 (0.04)
		Piston ring-to-ring groove clearance	Top	0.008 ± 0.070 (0.0001 ± 0.0028)
Second			0.015 ± 0.045 (0.0006 ± 0.0018)	0.06 (0.002)
Cylinder	I.D.	76.000 ± 0.015 (3.1132 ± 0.0006)	76.10 (3.114)	
	Out-of-round	—	0.10 (0.004)	
	Taper	—	0.10 (0.004)	
	Warpage	—	0.05 (0.002)	
	Cylinder-to-piston clearance	0.010 ± 0.045 (0.0004 ± 0.0018)	—	
Connecting rod small end I.D.			22.036 ± 0.001 (0.8673 ± 0.0001)	22.061 (0.8685)
Connecting rod to piston pin clearance			0.030 ± 0.007 (0.0012 ± 0.0001)	—

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