

Specifications* (375)

VALVES AND GUIDES		
Valve Face Diameter	(intake) (exhaust)	30.6 mm (1.20 in.) 27.0 mm (1.06 in.)
Valve/Tappet Clearance (cold engine)	(intake) (exhaust)	0.05-0.10 mm (0.002-0.004 in.) 0.17-0.22 mm (0.007-0.009 in.)
Valve Guide/Stem Clearance	(intake) (exhaust)	0.010-0.037 mm (0.0004-0.0015 in.) 0.030-0.057 mm (0.0012-0.0022 in.)
Valve Guide/Valve Stem Deflection (wobble method)	(max)	0.35 mm (0.014 in.)
Valve Guide Inside Diameter		5.000-5.012 mm (0.1969-0.1973 in.)
Valve Stem Outside Diameter	(intake) (exhaust)	4.975-4.990 mm (0.1959-0.1965 in.) 4.955-4.970 mm (0.1951-0.1957 in.)
Valve Stem Runout	(max)	0.05 mm (0.002 in.)
Valve Head Thickness	(max)	0.5 mm (0.02 in.)
Valve Stem End Length	(max)	2.3 mm (0.09 in.)
Valve Face/Seat Width		0.9-1.1 mm (0.035-0.043 in.)
Valve Seat Angle	(intake) (exhaust)	45° 45°
Valve Face Radial Runout	(max)	0.03 mm (0.001 in.)
Valve Spring Free Length (max)	(inner) (outer)	35.1 mm (1.38 in.) 37.8 mm (1.49 in.)
Valve Spring Tension @ 26 mm (1.10 in.)	(inner)	5.4-6.4 kg (12-14 lb)
Valve Spring Tension @ 31.5 mm (1.24 in.)	(outer)	13.2-15.0 kg (29-33 lb)
CAMSHAFT AND CYLINDER HEAD		
Cam Lobe Height (min)	(intake) (exhaust)	32.830 mm (1.293 in.) 32.830 mm (1.293 in.)
Camshaft Journal Oil Clearance	(max)	0.15 mm (0.0059 in.)
Camshaft Journal Holder Inside Diameter	(right & center) (left)	22.612-22.625 mm (0.8898-0.8971 in.) 17.512-17.525 mm (0.6894-0.6900 in.)
Camshaft Journal Outside Diameter	(right & center) (left)	21.959-21.980 mm (0.8645-0.8654 in.) 17.465-17.484 mm (0.6876-0.6883 in.)
Camshaft Runout	(max)	0.10 mm (0.004 in.)
Rocker Arm Inside Diameter		12.000-12.018 mm (0.472-0.473 in.)
Rocker Arm Shaft Outside Diameter		11.973-11.984 mm (0.4714-0.4718 in.)
Cylinder Head Distortion	(max)	0.05 mm (0.002 in.)
Cylinder Head Cover Distortion	(max)	0.05 mm (0.002 in.)

CYLINDER, PISTON, AND RINGS	
Piston Skirt/Cylinder Clearance	0.065-0.075 mm (0.0026-0.0030 in.)
Cylinder Bore	82.000-82.015 mm (3.2283-3.2289 in.)
Piston Diameter 15 mm (0.6 in.) from Skirt End	81.930-81.945 mm (3.2256-3.2262 in.)
Piston Ring Free End Gap (max)	(1st ring) 6.9 mm (0.3504 in.) (2nd ring) 6.3 mm (0.3268 in.)
Bore x Stroke	82 x 71.2 mm (3.29 x 2.80 in.)
Cylinder Trueness (max)	0.05 mm (0.002 in.)
Piston Ring End Gap - Installed (max)	0.50 mm (0.020 in.)
Piston Ring to Groove Clearance (max)	(1st) 0.180 mm (0.0071 in.) (2nd) 0.150 mm (0.0059 in.)
Piston Ring Groove Width	(1st) 1.01-1.03 mm (0.0398-0.0406 in.) (2nd) 1.01-1.03 mm (0.0398-0.0406 in.) (oil) 2.01-2.03 mm (0.0791-0.0799 in.)
Piston Ring Thickness	(1st) 0.97-0.99 mm (0.0381-0.0389 in.) (2nd) 0.97-0.99 mm (0.0381-0.0389 in.)
Piston Pin Bore (max)	20.03 mm (0.789 in.)
Piston Pin Outside Diameter (min)	19.98 mm (0.787 in.)
CRANKSHAFT	
Connecting Rod (small end inside diameter) (max)	21.04 mm (0.8283 in.)
Connecting Rod (big end side-to-side)	0.1-1.0 mm (0.004-0.039 in.)
Connecting Rod (big end width)	21.95-22.00 mm (0.8642-0.8661 in.)
Connecting Rod (small end deflection) (max)	3 mm (0.12 in.)
Crankshaft (web-to-web)	60.9-61.1 mm (2.398-2.406 in.)
Crankshaft Runout (max)	0.08 mm (0.003 in.)
Oil Pump Reduction Ratio	1.59 (29/20)
Oil Pressure at 60°C (140°F) @ 3000 RPM	(above) 1.53 kg/cm ² (21.7 psi) (below) 3.57 kg/cm ² (50.8 psi)
Engine Oil Thermo-Switch Operating Temperature	(off--on) 160°C (320°F) (on--off) 140°C (284°F)
CARBURETOR	
Type	Kaishin CVK32
Main Jet	150
Slow Jet	38
Pilot Screw Setting (turns)	2 1/8
Jet Needle	N8TV
Needle Jet	4.0/3.4
Idle RPM	1200-1350
Starter Jet	60
Float Arm Height	17 mm (0.7 in.)
Throttle Cable Free-Play (at lever)	3-6 mm (1/8-1/4 in.)

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