

# D SERVICE SPECIFICATIONS

MAINTENANS SPECIFIED VALUE----- D - 1

# 1 MAINTENANS SPECIFIED VALUE

## Cylinder head

			Specified value	Allowable limit	Applicable
Flatness (mm)	Cylinder Block Side		—	0.05	
	Manifold Side	IN	—	0.05	
		EX	—	0.05	
Valve seat	Contact width (mm)	IN	1.0—1.4	—	
		EX	1.0—1.4	—	
	Contact width (degree)	IN	—	20—45—70	
		EX	—	20—45—70	

## Camshaft

			Specified value	Allowable limit	Applicable
Deformation(mm)			—	0.03 (runout)	
Cam height (mm)		IN	41.54—41.64	41.44	
		EX	40.97—41.07	40.87	
Thrust clearance (mm)			0.100—0.225	0.24	
Journal diameter (mm)	Camshaft	IN	1J	33.984—34.000	—
			2—4J	22.949—22.965	—
		EX	1J	25.979—25.995	—
			2—4J	22.949—22.965	—
	Cylinder head	IN	1J	34.025—34.045	—
			2—4J	23.000—23.021	—
		EX	1J	26.032—26.052	—
			2—4J	23.000—23.021	—
Oil clearance (mm)		IN	1J	0.025—0.061	0.09
			2—4J	0.035—0.072	0.1
		EX	1J	0.037—0.073	0.1
			2—4J	0.035—0.072	0.1

## Valve spring

			Specified value	Allowable limit	Applicable
Squareness (mm)			—	1.5	
Free length (mm)			—	51.63	

## Valve

			Specified value	Allowable limit	Applicable
Contact width		IN	$1.30^{+0.4}_{-0.1}$	—	
		EX	$1.26^{+0.35}_{-0.15}$	—	
Stock thickness of valve head		IN	$1.25 \pm 0.2$	0.7	
		EX	$1.30 \pm 0.2$	0.7	
Stem outer diameter		IN	4.97—4.985	—	
		EX	4.965—4.98	—	

## Valve guide bush

			Specified value	Allowable limit	Applicable
Bush inner diameter(mm)		IN	5.01—5.03	—	
		EX	5.01—5.03	—	
Stem × Bush of clearance		IN	0.025—0.06	0.08	
		EX	0.03—0.065	0.1	

## Cylinder block

			Specified value	Allowable limit	Applicable
Head for deformation (mm)			—	0.05	
Polish the cylinder head surface(The block height)(mm)			—	257	
Cylinder of ellipes (mm)			—	0.02	
Cylinder degree of taper (mm)			—	0.02	
Cylinder inner diameter (mm)			71.000—71.013	71.013	

## Piston/Piston ring

		Specified value	Allowable limit	Applicable
Oil clearance(Cylinder × Piston)(mm)		0.08—0.103	0.103	
Oil clearance(Piston × Pin)(mm)		0.005—0.011	—	
Piston ring groove-to-ring clearance (mm)	Compression No.1	0.02—0.07	0.07	
	Compression No.2	0.02—0.06	0.06	
	Oil	0.02—0.065	0.065	
Ring end gap (mm)	Compression No.1	0.20—0.30	0.79	
	Compression No.2	0.40—0.60	0.75	
	Oil	0.10—0.40	0.69	
Piston outer diameter(mm)		70.915±0.05	—	
Piston pin outer diameter(mm)		17.999—18.002	—	
Piston pin installation position diameter (mm)		18.007—18.01	—	

## Connecting rod

		Specified value	Allowable limit	Applicable
Thrust clearance (mm)		0.10—0.30	0.35	
Oil clearance (mm)		0.016—0.042	0.045	

## Crankshaft

		Specified value	Allowable limit	Applicable
Thrust clearance (mm)		0.02—0.22	0.3	
Oil clearance (mm)		0.021—0.046	0.046	
Check of bend (mm)		—	0.03(runout)	
Check of journal wear (mm)	True ovality	—	0.003	
	Degree of taper	—	0.003	
Check of pin section wear	True ovality	—	0.003	
	Degree of taper	—	0.003	