

SPECIFICATIONS AND SERVICE DATA

[S200] **2-3**
2. Service Data

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NOTE:

STD: Standard, I.D.: Inner Diameter, O.D.: Outer Diameter, OS: Oversize, US: Undersize

Belt tensioner adjuster	Protrusion of adjuster rod		5.2 — 6.2 mm	(0.205 — 0.244 in)	
Belt tensioner	Spacer O.D.		17.955 — 17.975 mm	(0.7069 — 0.7077 in)	
	Tensioner bush I.D.		18.00 — 18.08 mm	(0.7087 — 0.7118 in)	
	Clearance between spacer and bush	STD	0.025 — 0.125 mm	(0.0010 — 0.0049 in)	
		Limit	0.175 mm	(0.0069 in)	
Side clearance of spacer	STD	0.2 — 0.55 mm	(0.0079 — 0.0217 in)		
	Limit	0.81 mm	(0.0319 in)		
Valve rocker arm	Clearance between shaft and arm	STD	0.020 — 0.054 mm	(0.0008 — 0.0021 in)	
		Limit	0.10 mm	(0.0039 in)	
Camshaft	Bend limit		0.020 mm	(0.0008 in)	
	Thrust clearance	STD	0.030 — 0.090 mm	(0.0012 — 0.0035 in)	
		Limit	0.11 mm	(0.0043 in)	
	Cam lobe height (2200 cc)	Intake	STD	38.732 — 38.832 mm	(1.5249 — 1.5288 in)
			Limit	38.632 mm	(1.5209 in)
		Exhaust	STD	39.257 — 39.357 mm	(1.5455 — 1.5495 in)
			Limit	39.157 mm	(1.5416 in)
	Cam lobe height (2500 cc)	Intake	STD	39.485 — 39.585 mm	(1.5545 — 1.5585 in)
			Limit	39.385 mm	(1.5506 in)
		Exhaust	STD	39.257 — 39.357 mm	(1.5455 — 1.5495 in)
			Limit	39.157 mm	(1.5416 in)
Camshaft journal O.D.		31.928 — 31.945 mm	(1.2570 — 1.2577 in)		
Camshaft journal hole I.D.		32.000 — 32.018 mm	(1.2598 — 1.2605 in)		
Oil clearance	STD	0.055 — 0.090 mm	(0.0022 — 0.0035 in)		
	Limit	0.118 mm	(0.0046 in)		
Cylinder head	Surface warpage limit		0.05 mm	(0.0020 in)	
	Surface grinding limit		0.3 mm	(0.012 in)	
	Standard height		127.5 mm	(5.02 in)	
Valve set	Refacing angle		90°		
	Contacting width	Intake	STD	1.0 mm	(0.039 in)
			Limit	1.7 mm	(0.067 in)
		Exhaust	STD	1.4 mm	(0.055 in)
Limit			2.1 mm	(0.083 in)	
Valve guide	Inner diameter		6.000 — 6.012 mm	(0.2362 — 0.2367 in)	
	Protrusion above head	Intake	20.0 — 20.5 mm	(0.787 — 0.807 in)	
		Exhaust	16.5 — 17.0 mm	(0.650 — 0.669 in)	

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Valve	Head edge thickness	Intake	STD	1.0 mm	(0.039 in)
			Limit	0.6 mm	(0.024 in)
		Exhaust	STD	1.2 mm	(0.047 in)
			Limit	0.6 mm	(0.024 in)
	Stem diameter		Intake	5.950 — 5.965 mm	(0.2343 — 0.2348 in)
			Exhaust	5.945 — 5.960 mm	(0.2341 — 0.2346 in)
	Stem oil clearance	STD	Intake	0.035 — 0.062 mm	(0.0014 — 0.0024 in)
			Exhaust	0.040 — 0.067 mm	(0.0016 — 0.0026 in)
Overall length		Limit	—	0.15 mm	(0.0059 in)
		Intake	120.6 mm	(4.75 in)	
Valve spring	Free length		Exhaust	121.7 mm	(4.79 in)
				54.30 mm	(2.1378 in)
	Squareness		2.5°, 2.4 mm	(0.094 in)	
	Tension/spring height		214.8 — 246.2 N (21.9 — 25.1 kg, 48.3 — 55.3 lb)/45.0 mm (1.772 in) 526.6 — 581.6 N (53.7 — 59.3 kg, 118.4 — 130.8 lb)/34.7 mm (1.366 in)		
Cylinder block	Surface warpage limit (mating with cylinder head)			0.05 mm	(0.0020 in)
	Surface grinding limit			0.1 mm	(0.004 in)
	Cylinder bore (2200 cc)	STD	A	96.905 — 96.915 mm	(3.8151 — 3.8155 in)
			B	96.895 — 96.905 mm	(3.8148 — 3.8151 in)
	Cylinder bore (2500 cc)	STD	A	99.505 — 99.515 mm	(3.9175 — 3.9179 in)
			B	99.495 — 99.505 mm	(3.9171 — 3.9175 in)
	Taper		STD	0.015 mm	(0.0006 in)
			Limit	0.050 mm	(0.0020 in)
	Out-of-roundness		STD	0.010 mm	(0.0004 in)
			Limit	0.050 mm	(0.0020 in)
Piston clearance		STD	0.010 — 0.030 mm	(0.0004 — 0.0012 in)	
		Limit	0.050 mm	(0.0020 in)	
Enlarging (boring) limit			0.5 mm	(0.020 in)	
Piston	Outer diameter (2200 cc)	STD	A	96.885 — 96.895 mm	(3.8144 — 3.8148 in)
			B	96.875 — 96.885 mm	(3.8140 — 3.8144 in)
		0.25 mm (0.0098 in) OS		97.125 — 97.135 mm	(3.8238 — 3.8242 in)
	Outer diameter (2500 cc)	STD	A	99.485 — 99.495 mm	(3.9167 — 3.9171 in)
			B	99.475 — 99.485 mm	(3.9163 — 3.9167 in)
		0.25 mm (0.0098 in) OS		99.725 — 99.735 mm	(3.9262 — 3.9266 in)
Standard clearance between piston pin and hole in piston	STD		0.004 — 0.008 mm	(0.0002 — 0.0003 in)	
		Limit	0.020 mm	(0.0008 in)	
Degree of fit			Piston pin must be fitted into position with thumb at 20°C (68°F).		

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Piston ring	Piston ring gap	Top ring	STD	0.20 — 0.35 mm	(0.0079 — 0.0138 in)
			Limit	1.0 mm	(0.039 in)
		Second ring	STD	0.37 — 0.52 mm	(0.0146 — 0.0205 in)
			Limit	1.0 mm	(0.039 in)
		Oil ring	STD	0.20 — 0.50 mm	(0.0079 — 0.0197 in)
			Limit	1.0 mm	(0.039 in)
	Clearance between piston ring and piston ring groove	Top ring	STD	0.040 — 0.080 mm	(0.0016 — 0.0031 in)
			Limit	0.15 mm	(0.0059 in)
Second ring		STD	0.030 — 0.070 mm	(0.0012 — 0.0028 in)	
		Limit	0.15 mm	(0.0059 in)	
Connecting rod	Bend twist per 100 mm (3.94 in) in length	Limit	0.10 mm	(0.0039 in)	
	Side clearance	STD	0.070 — 0.330 mm	(0.0028 — 0.0130 in)	
		Limit	0.4 mm	(0.016 in)	
Connecting rod bearing	Oil clearance (2200 cc)	STD	0.010 — 0.038 mm	(0.0004 — 0.0015 in)	
		Limit	0.05 mm	(0.0020 in)	
	Oil clearance (2500 cc)	STD	0.020 — 0.046 mm	(0.0008 — 0.0018 in)	
		Limit	0.050 mm	(0.0020 in)	
	Thickness at center portion (2200 cc)	STD	1.492 — 1.501 mm	(0.0587 — 0.0591 in)	
		0.03 mm (0.0012 in) US	1.510 — 1.513 mm	(0.0594 — 0.0596 in)	
		0.05 mm (0.0020 in) US	1.520 — 1.523 mm	(0.0598 — 0.0600 in)	
		0.25 mm (0.0098 in) US	1.620 — 1.623 mm	(0.0638 — 0.0639 in)	
	Thickness at center portion (2500 cc)	STD	1.486 — 1.498 mm	(0.0585 — 0.0590 in)	
		0.03 mm (0.0012 in) US	1.504 — 1.512 mm	(0.0592 — 0.0595 in)	
		0.05 mm (0.0020 in) US	1.514 — 1.522 mm	(0.0596 — 0.0599 in)	
		0.25 mm (0.0098 in) US	1.614 — 1.622 mm	(0.0635 — 0.0639 in)	
Connecting rod bushing	Clearance between piston pin and bushing	STD	0 — 0.022 mm	(0 — 0.0009 in)	
		Limit	0.030 mm	(0.0012 in)	

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Crankshaft	Bend limit		0.035 mm	(0.0014 in)	
	Crankpin and crank journal		Out-of-roundness	0.030 mm (0.0012 in) or less	
			Grinding limit	0.250 mm (0.0098 in)	
	Crankpin outer diameter		STD	51.984 — 52.000 mm (2.0466 — 2.0472 in)	
			0.03 mm (0.0012 in) US	51.954 — 51.970 mm (2.0454 — 2.0461 in)	
			0.05 mm (0.0020 in) US	51.934 — 51.950 mm (2.0446 — 2.0453 in)	
			0.25 mm (0.0098 in) US	51.734 — 51.750 mm (2.0368 — 2.0374 in)	
	Crank journal outer diameter		#1, #5, #3	STD	59.992 — 60.008 mm (2.3619 — 2.3625 in)
				0.03 mm (0.0012 in) US	59.962 — 59.978 mm (2.3607 — 2.3613 in)
				0.05 mm (0.0020 in) US	59.942 — 59.958 mm (2.3599 — 2.3605 in)
				0.25 mm (0.0098 in) US	59.742 — 59.758 mm (2.3520 — 2.3527 in)
			#2, #4	STD	59.992 — 60.008 mm (2.3619 — 2.3625 in)
				0.03 mm (0.0012 in) US	59.962 — 59.978 mm (2.3607 — 2.3613 in)
				0.05 mm (0.0020 in) US	59.942 — 59.958 mm (2.3599 — 2.3605 in)
				0.25 mm (0.0098 in) US	59.742 — 59.758 mm (2.3520 — 2.3527 in)
Thrust clearance		STD	0.030 — 0.115 mm (0.0012 — 0.0045 in)		
		Limit	0.25 mm (0.0098 in)		
Oil clearance		STD	0.010 — 0.030 mm (0.0004 — 0.0012 in)		
		Limit	0.040 mm (0.0016 in)		
Crankshaft bearing	#1, #3		STD	1.998 — 2.011 mm (0.0787 — 0.0792 in)	
			0.03 mm (0.0012 in) US	2.017 — 2.020 mm (0.0794 — 0.0795 in)	
			0.05 mm (0.0020 in) US	2.027 — 2.030 mm (0.0798 — 0.0799 in)	
			0.25 mm (0.0098 in) US	2.127 — 2.130 mm (0.0837 — 0.0839 in)	
	#2, #4, #5		STD	2.000 — 2.013 mm (0.0787 — 0.0793 in)	
			0.03 mm (0.0012 in) US	2.019 — 2.022 mm (0.0795 — 0.0796 in)	
			0.05 mm (0.0020 in) US	2.029 — 2.032 mm (0.0799 — 0.0800 in)	
			0.25 mm (0.0098 in) US	2.129 — 2.132 mm (0.0838 — 0.0839 in)	