

4. MAINTENANCE STANDARDS

Item		Standard	Service Limit
Engine	Idle speed	1,300±100 min ⁻¹ (rpm) (in Forward)	—
	Cylinder compression	4,500±100 kPa (4.5±1 kg/cm ² , 64±14 psi)/600 min ⁻¹ (rpm)	—
Carburetor	Main jet	#75	—
	Pilot screw opening	2-3/8 turns	—
Thermostat	Float height	9.0—11.0 mm (0.35—0.43 in)	—
	Opens	50°—54°C (122°—140°F)	—
	Valve lift	3—4 mm (0.12—0.16 in)	—
Spark plug	Gap	0.7—0.8 mm (0.028—0.031 in)	—
Valve	Valve tappet clearance	IN 0.06—0.14 mm (0.002—0.006 in)	—
		EX 0.11—0.19 mm (0.004—0.007 in)	—
	Valve stem O.D.	IN 5.48 mm (0.216 in)	5.45 mm (0.215 in)
		EX 5.44 mm (0.214 in)	5.41 mm (0.213 in)
	Valve guide I.D.	IN 5.50 mm (0.217 in)	5.54 mm (0.218 in)
		EX 5.50 mm (0.217 in)	5.57 mm (0.219 in)
	Valve stem-to-guide clearance	IN 0.020—0.044 mm (0.0008—0.0017 in)	0.07 mm (0.003 in)
		EX 0.060—0.087 mm (0.0024—0.0034 in)	0.15 mm (0.006 in)
	Valve seat width	0.8 mm (0.03 in)	1.80 mm (0.070 in)
	Valve spring free length	29.60 mm (1.165 in)	28.10 mm (1.106 in)
Camshaft	Cam height	IN 27.710 mm (1.0909 in)	27.45 mm (1.081 in)
		EX 27.747 mm (1.0924 in)	27.50 mm (1.083 in)
	O.D. (at oil pump)	13.984 mm (0.5506 in)	13.95 mm (0.549 in)
Oil pump	Body I.D.	23.15 mm (0.911 in)	23.20 mm (0.913 in)
	Inner rotor-to-outer rotor clearance	0.15 mm (0.006 in) max.	0.20 mm (0.008 in)
	Outer rotor-to-body clearance	0.15—0.21 mm (0.006—0.008 in)	0.26 mm (0.010 in)
	Outer rotor height	11.98 mm (0.472 in)	11.95 mm (0.470 in)
	Pump body depth	12.00 mm (0.472 in)	12.06 mm (0.475 in)
	Rotor-to-body side clearance	0.02—0.09 mm (0.0008—0.0035 in)	0.11 mm (0.004 in)
Piston	O.D. (at skirt)	59.965 mm (2.3616 in)	59.92 mm (2.359 in)
	Piston pin hole I.D.	18.002 mm (0.7087 in)	18.02 mm (0.709 in)
	Piston pin O.D.	18.000 mm (0.7087 in)	17.97 mm (0.707 in)
	Piston pin-to-piston clearance	0.002—0.014 mm (0.0001—0.0006 in)	0.04 mm (0.002 in)
	Piston ring side clearance	Top/Second/Oil 0.015—0.045 mm (0.0006—0.0018 in)	0.10 mm (0.004 in)
Cylinder	Ring end gap	Top/Second/Oil 0.15—0.35 mm (0.006—0.014 in)	0.50 mm (0.020 in)
	Sleeve I.D.	60.000 mm (2.3622 in)	60.07 mm (2.366 in)
	Piston-to-cylinder clearance	0.015—0.050 mm (0.0006—0.0020 in)	0.10 mm (0.004 in)

Bf5a Work Shop Manual

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Embracing the Tune of Appearance: An Psychological Symphony within **Bf5a Work Shop Manual**

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