

PART SIX CORRECTIVE MAINTENANCE

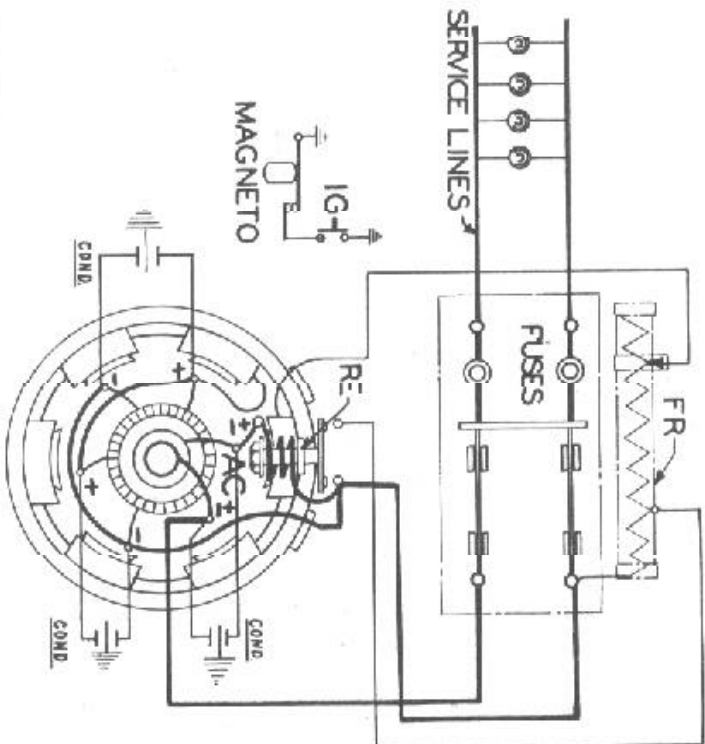
Section I—ENGINE

19. SPECIFICATIONS, TOLERANCES, AND CLEARANCES.

The table below gives information on specifications, tolerances, and clearances of engine parts in the 1 1/2 KVA Kohler unit:

TABLE IV—Specifications, Tolerances, and Clearances

Intake valve seat	1/32 in. x 45° chamfer x 25/32 in. diam.
Exhaust valve seat	1/32 in. x 45° chamfer x 25/32 in. diam.
Intake valve guide side clearance	0.002 in.
Exhaust valve guide side clearance	0.002 in.
Intake valve tappet clearance	0.005 in. hot.
Exhaust valve tappet clearance	0.005 in. hot.
Valve timing	40° before low dead center.
Main bearing diameters	Rear bearing, 1.251 in. Front bearing, 1.3125 in.
Main bearing diametral clearance	Rear bearing, 0.00125 in. Front bearing, 0.00125 in.
Main bearing thrust clearance	0.004 in.
Connecting-rod bearing diameter	1.249 in.
Connecting-rod bearing diametral clearance	0.00075 in.
Connecting-rod bearing side clearance	0.0035 in.
Camshaft bearing diameters	Rear, 1.4375 in. Front, 1.500 in.
Camshaft bearing clearances	Rear, 0.00145 in. Front, 0.00195 in.
Cylinder bore	2.001 in.
Piston clearance	0.00175 in.
Number and type of piston rings per piston	4 Rings (3 plain, 1 oil ring).
Piston ring side and bottom clearance	Bottom 0.007 in. Side 0.00125 in.
Piston pin diametral clearance	0.00 in.
Ignition timing-maximum degrees advance	Approximately 30°.



TL-90719

Figure 19. Wiring diagram, with ground button on magneto.