

4. MAINTENANCE STANDARDS

ENGINE

Unit: mm (in)

Part	Item		Standard	Service limit
Engine	Idle speed (in neutral)		900 $\pm$ 50 min ⁻¹ (rpm)	—
	Cylinder compression		1.5 $\pm$ 1 kg/cm ² (21.2 $\pm$ 1.4 psi) at 500 min ⁻¹ (rpm)	—
Carburetor	Main jet		ϕ 100	—
	Pilot screw opening		2 turns out	—
	Float height		14 (0.5)	—
Spark plug	Gap		0.6 – 0.7 (0.024 – 0.028)	—
Valves	Valve clearance	IN	0.10 – 0.14 (0.004 – 0.006)	—
		EX	0.18 – 0.22 (0.007 – 0.009)	—
	Stem O.D.	IN	5.475 – 5.490 (0.2154 – 0.2161)	5.45 (0.215)
		EX	5.455 – 5.470 (0.2148 – 0.2154)	5.43 (0.214)
	Guide I.D.	IN/EX	5.500 – 5.512 (0.2165 – 0.2170)	5.54 (0.218)
	Seat width	IN	0.9 – 1.1 (0.035 – 0.043)	2.0 (0.08)
		EX	0.9 – 1.1 (0.035 – 0.043)	2.0 (0.08)
	Spring free length	IN/EX	38.8 (1.49)	38.3 (1.39)
	Stem-to-guide clearance	IN	0.010 – 0.037 (0.0004 – 0.0015)	0.07 (0.003)
		EX	0.030 – 0.057 (0.0012 – 0.0022)	0.12 (0.005)
Rocker arm	Rocker arm I.D.		13.000 – 13.018 (0.5118 – 0.5125)	13.04 (0.513)
	Rocker arm shaft O.D.		12.982 – 12.990 (0.5103 – 0.5110)	12.92 (0.509)
	Rocker arm shaft-to-rocker arm clearance		0.020 – 0.056 (0.0007 – 0.0022)	0.07 (0.003)
Piston	Skirt O.D.		57.970 – 57.990 (2.2822 – 2.2831)	57.92 (2.280)
	Piston-to-cylinder clearance		0.010 – 0.045 (0.0004 – 0.0018)	0.1 (0.004)
	Pin bore I.D.		14.002 – 14.008 (0.5513 – 0.5519)	14.02 (0.552)
	Pin O.D.		13.984 – 14.000 (0.5509 – 0.5512)	13.97 (0.550)
	Pin-to-pin bore clearance		0.002 – 0.018 (0.0001 – 0.0008)	0.04 (0.002)
Piston ring	Ring side clearance	Top	0.025 – 0.055 (0.0010 – 0.0022)	0.1 (0.004)
		Second	0.025 – 0.055 (0.0010 – 0.0022)	0.1 (0.004)
		Oil	0.055 – 0.14 (0.0022 – 0.006)	0.2 (0.008)
	Ring end gap	Top	0.15 – 0.3 (0.006 – 0.012)	0.5 (0.02)
		Second	0.35 – 0.50 (0.014 – 0.020)	0.7 (0.03)
		Oil	0.30 – 0.80 (0.008 – 0.031)	1.0 (0.04)
	Ring thickness	Top	1.175 – 1.190 (0.0463 – 0.0469)	1.08 (0.043)
		Second	1.175 – 1.190 (0.0463 – 0.0469)	1.08 (0.043)
Cylinder/cylinder head	Cylinder sleeve I.D.		58.000 – 58.015 (2.2835 – 2.2841)	58.05 (2.2856)
	Distortion of cylinder head		0.05 (0.002)	0.1 (0.004)
	I.D. of camshaft journal	# 1	20.000 – 20.021 (0.7874 – 0.7882)	20.05 (0.789)
		# 2	30.000 – 30.025 (1.1811 – 1.1821)	30.05 (1.183)
	Oil pump journal	# 3	18.000 – 18.027 (0.7087 – 0.7097)	18.05 (0.711)

Bf25 Shop Manual

Joacim Rocklöv



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