

magneto drive seal - 23/32 deep

**Bearing OD and spread**

Front and rear - inches . . . . . 1.777 + .020  
Center - inches . . . . . 1.777 + .002 to .015

**Camshaft**

Drive . . . . . Helical gear  
Cam lobe lift (total) - inch . . . . . .232 ± .002

**Diameter at bearing areas**

Front - inches . . . . . 1.871 - 1.872  
Center - inches . . . . . 1.746 - 1.747  
Rear - inch . . . . . .872 - .873

Thrust taken by . . . . . Thrust plate  
Number of bearings . . . . . 3 (bored in crankcase)

**Bearing running clearance**

Front and center - inch . . . . . .002 - .0045  
Rear - inch . . . . . .001 - .0035

End clearance - inch . . . . . .003 - .012

**Connecting Rods**

Type . . . . . I-Beam  
Side clearance - inch . . . . . .005 - .012  
Bearing running clearance - inch . . . . . .002 - .003

**Bearing type**

Upper end . . . . . Bronze bushing  
Lower end . . . . . Tri-metal, precision

Bearing OD and spread - inches . . . . . 1.625 + .025  
Piston pin bushing (installed and bored) ID - inch . . . . . .6879 - .6882

**Pistons**

Type . . . . . Full skirt  
Material . . . . . Grey iron  
Overall length - inches . . . . . 2.875  
Diameter - inches . . . . . 2.6230 - 2.6234  
\*Skirt clearance, bottom - inch . . . . . .0016 - .0024  
(measured at 90° from pin hole)  
Number of rings per piston . . . . . 3  
Piston pin hole bore - inch . . . . . .6877 - .6880

\*See "Piston Fit in Bore", page 1-31.

ring gap .004 per inch of bore