



SUZUKI

TWO STROKE

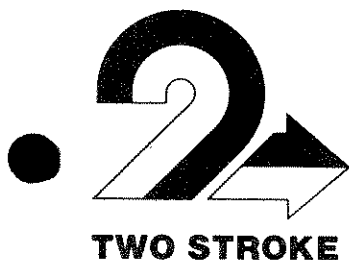
Service Bulletin

Bulletin No.: SPECS - 16Y
 Date: May 30, 1980
 Read and Initial _____
 Manager _____
 Parts Mgr. _____
 Service Mgr. _____
 Mechanics _____

MODEL: RS175T
 SUBJECT: SPECIFICATIONS

ITEM	STANDARD	LIMIT
VALVE SPECS		
Valve Lift	IN: _____ EX: _____	16.030mm
Tappet Clearance or Valve Clearance	IN: _____ EX: _____	15.980mm
Valve Guide--Valve Stem Clearance	IN: _____ EX: _____	21.003-21.011mm
Valve Guide I.D. (IN/EX)		3.0mm
Valve Stem O.D.		0.05mm
Valve Stem Deflection (IN & EX)		---
Valve Head Thickness (IN & EX)		---
Valve Seat Width (IN/EX)		---
Valve Head Radial Runout (IN & EX)		---
Valve Spring Free Length	INN: _____ OUT: _____	56.0 ± 0.1mm
Valve Spring Tension	INN: _____ OUT: _____	---
Rocker Arm I.D. (IN & EX)		---
Rocker Arm Shaft O.D. (IN & EX)		---
CAMSHAFT		
Cam Height	IN: _____ EX: _____	2.6mm
Camshaft--Journal Clearance (IN & EX)		0.2mm
Camshaft Journal I.D. (IN & EX)		0.1mm
Camshaft Journal O.D. (IN & EX)		11.0mm
Camshaft Deflection (IN & EX)		30.7mm
Cam Chain 20 Pitch Length		0.10mm
PISTON/RING/CLINDER		
Compression Pressure	---	---
Max. Difference Between Cylinders	---	---
Piston--Cylinder Clearance	0.06-0.07mm	0.12mm
Cylinder Bore	62.000-62.015mm	62.070mm
Piston Dia./Measuring Point	61.935-61.950mm/26mm	61.880mm
Cylinder Warp	---	0.05mm
Piston ring free end gap	approx. 6.5mm	5.2mm
Piston ring End Gap	0.20-0.40mm	0.85mm
Piston ring--Grove Clearance	0.02-0.06mm	---
CRANKSHAFT		
Con-rod Small End Hole		21.003-21.011mm
Con-rod Big End Wear		---
Crankshaft Runout		---
Crankshaft Web to Web Width		56.0 ± 0.1mm
OIL PUMP		
Oil Pressure		---
Tip Clearance		---
Outer Rotor Clearance		---
Side Clearance		---
Oil Pump Reduction Ratio		---
CCI Pump Discharge Rate		---
CLUTCH		
Drive Plate Thickness	2.9-3.1mm	2.6mm
Drive Plate Warp		0.2mm
Driven Plate Thickness	1.6 ± 0.06mm	---
Driven Plate Warp		0.1mm
Drive Plate Claw Width	11.8-12.0mm	11.0mm
Clutch Spring Free Length	29.3mm	30.7mm
Pri. Drive--Driven Gear Backlash	0.02-0.07mm	0.10mm
TRANSMISSION		
Primary Reduction	2.761 (58/21)	---
Final Reduction	3.833 (46/12)	---
Gear Ratios, Low/2nd	3.090 (34/11) / 2.214 (31/14)	---
3rd/4th	1.647 (28/17) / 1.300 (26/20)	---
5th/Top	1.045 (23/22) / 0.875 (21/24)	---
Gear Backlash	1st/2nd	---
3rd/4th	---	---
5th/6th	---	---
Shift Fork--Grove Clearance	0.05-0.25mm	0.45mm
Shift Fork Groove Width	4.45-4.55mm	---
Shift Fork Thickness	4.30-4.40mm	---
Drive Chain Size	D.I.D. 520UB, 106 links	---
21 Pin Length	317.5mm	324mm
Countershaft length (Low-2nd)	91.8-91.9mm	---
Drive Chain Slack	25-35mm	---

I T E M		S T A N D A R D		L I M I T		I T E M		S T A N D A R D		L I M I T	
CARBURETOR						Headlight (Low/High)		6V 15W/15W			
Idle RPM		1500 ± 150 rpm				Instrument Bulbs (Speedo/ Tach/Hi Beam/Turn Signal Oil Pressure)		--			
Carburetor Type		MIKUNI VM30SS				Tail light/Stop light		6V 5W/---			
I.D. No.		41530				Turn Signal Bulbs		--			
Bore Size		30mm				CHASSIS					
Float Height		7.8 ± 0.5mm				Axle Runout (Front/Rear)		--		0.25mm	
Fuel Level		--				Brake Drum I.D.		Front: -- Rear: --		130.7mm 120.7mm	
Air Screw		1 1/2				Brake Lining Thickness		Front: -- Rear: --		1.5mm 1.5mm	
Pilot Screw		--				Brake Disc Thickness (Front & Rear)		--		--	
Pilot Air Jet		#30				Master Cylinder Cylinder Bore		Front: -- Rear: --		--	
Pilot Jet		2.5				Master Cylinder Piston Diameter		Front: -- Rear: --		--	
Cut Away		5DP74-2				Brake Caliper Cylinder Bore		Front: -- Rear: --		--	
Jet Needle		R-4				Brake Caliper Piston Dia.		Front: -- Rear: --		--	
Needle Jet		2.5				Wheel Rim Runout (Radial & Axial)		--		2.0mm	
Secondary Air Jet		0.8				Tire Size		Front: 3.00-21-4PR Rear: 4.10-18-4PR		--	
Pilot Outlet		#150				Tire Tread Depth		Front: -- Rear: --		4.0mm 4.0mm	
Main Jet						Tire Pressure		FRONT SOLO DUAL SOLO DUAL		REAR SOLO DUAL	
ELECTRICAL		SUZUKI "PEI"				Normal Riding		14psi		14psi	
Ignition		17.5° ± 2° B.T.D.C. @ 8000 rpm				Continuous High		--		--	
Ignition Timing		--				Speed Riding		--		--	
Firing Order		NGK B9ES or ND W27ES				Fork Spring Free Length		--		571mm	
Spark Plug		0.6-0.8mm				Swinging Arm Pivot Shaft Runout		--		0.3mm	
Spark Plug Gap		--				FUEL & OILS					
Contact Point Gap		--				Fuel Type		Premium			
Dwell Angle		Over 8mm				Engine Oil Type		CCI Super 2 or equivalent			
Spark Performance		--				Engine Oil Capacity		20:1 fuel/oil ratio premix			
Condensor Capacity		B/W to W/BI approx. 0-1 ohm				Transmission Oil Type/Cap		SAE 20W/40 overhaul: 900ml			
Ignition Coil Resistance (Pri.)		Plug cap to B/W or W/BI approx. 10-11kohms				Front Fork Air Pressure		--			
Ignition Coil Resistance (Sec.)		R/W to B/W approx 180-240 ohms				Fork Oil Type/Cap./Level		High quality SAE 10 fork oil or A.T.F./ 284ml/240mm			
Magnet Coil Resistances		R/W to B/R approx 20-30 ohms									
		Y/R to B/W approx 0-1 ohm									
Exciter Coil Resistance		--									
Pulser Coil Resistance		--									
Charging Coil Resistance		--									
Lighting Coil Output		Over 5.5V @ 2500rpm/under 8.0V @ 8000rpm									
Battery		--									
Specific Gravity		--									
Regulated Amperage		--									
Regulated Voltage		--									
Fuse Capacity		--									



SUZUKI

TWO STROKE

Service Bulletin

MODEL: RS250T
SUBJECT: SPECIFICATIONS

Bulletin No.: SPECS - 16Z
Date: May 30, 1980
Read and Initial
Manager _____
Parts Mgr. _____
Service Mgr. _____
Mechanics _____

ITEM	STANDARD	LIMIT
VALVE SPECS		
Valve Lift	IN: EX:	---
Tappet Clearance or Valve Clearance	IN: EX:	---
Valve Guide--Valve Stem Clearance	IN: EX:	---
Valve Guide I.D. (IN/EX)		
Valve Stem O.D.		
Valve Stem Deflection (IN & EX)		
Valve Head Thickness (IN & EX)		
Valve Seat Width (IN/EX)		
Valve Head Radial Runout (IN & EX)		
Valve Spring Free Length	INN: OUT:	---
Valve Spring Tension	INN: OUT:	---
Rocker Arm I.D. (IN & EX)		
Rocker Arm Shaft O.D. (IN & EX)		
CAMSHAFT		
Cam Height	IN: EX:	---
Camshaft--Journal Clearance (IN & EX)		
Camshaft Journal I.D. (IN & EX)		
Camshaft Journal O.D. (IN & EX)		
Camshaft Deflection (IN & EX)		
Cam Chain 20 Pitch Length		
PISTON/RING/CYLINDER		
Compression Pressure	---	---
Max. Difference Between Cylinders	---	---
Piston--Cylinder Clearance	0.06 - 0.07mm	0.12mm
Cylinder Bore	67.000 - 67.015mm	67.070mm
Piston Dia./Measuring Point	66.935 - 66.950mm/22mm	66.880mm
Cylinder Warp	---	0.05mm
Piston ring free end gap	Approx. 6.5mm	5.2mm
Piston ring End Gap	0.2 - 0.4mm	0.85mm
Piston ring--Grove Clearance	0.01 - 0.05mm	---
ITEM	STANDARD	LIMIT
Piston Pin Bore I.D.	17.998 - 18.006mm	18.030mm
Piston Pin O.D.	17.995 - 18.000mm	17.980mm
CRANKSHAFT		
Con-rod Small End Hole	23.003 - 23.011mm	23.040mm
Con-rod Deflection	---	3.0mm
Big End Side Clearance	---	---
Con-rod Big End Wear	---	---
Crankshaft Runout	---	0.05mm
Crankshaft Web to Web Width	62.0 ± 0.1mm	---
OIL PUMP		
Oil Pressure	---	---
Tip Clearance	---	---
Outer Rotor Clearance	---	---
Side Clearance	---	---
Oil Pump Reduction Ratio	---	---
CCI Pump Discharge Rate	---	---
CLUTCH		
Drive Plate Thickness	2.9 - 3.1mm	2.6mm
Drive Plate Warp	---	0.2mm
Driven Plate Thickness	2.0 ± 0.06mm	---
Driven Plate Warp	---	0.1mm
Drive Plate Claw Width	15.8 - 16.0mm	15.0mm
Clutch Spring Free Length	40.5mm	38.5mm
Pri. Drive--Driven Gear Backlash	0.02 - 0.07mm	0.10mm
TRANSMISSION		
Primary Reduction	2727 (60/22)	
Final Reduction	4.000 (52/13)	
Gear Ratios, Low/2nd	2.384 (31/13) / 1.750 (28/16)	
3rd/4th	1.352 (23/17) / 1.095 (23/21)	
5th/Top	0.904 (19/21) / 0.760 (19/25)	
Gear Backlash 1st/2nd	---	
3rd/4th	---	
5th/6th	---	
Shift Fork--Grove Clearance	0.2 - 0.4mm	0.6mm
Shift Fork Groove Width	4.25 - 4.35mm	---
Shift Fork Thickness	3.95 - 4.05mm	---
Drive Chain Size	Takasago RK520SU	110 links
21 Pin Length	317.5mm	324mm
Drive Chain Slack	25 - 35mm	

I T E M		S T A N D A R D		L I M I T		I T E M		S T A N D A R D		L I M I T	
CARBURETOR						Headlight (Low/High)		6V 15W/15W			
Idle RPM		1500 $\pm$ 150 rpm				Instrument Bulbs (Speedo/ Tach/Hi Beam/Turn Signal Oil Pressure)		---			
Carburetor Type		MIKUNI VM36SS				Tail light/Stop light		6V 5W/-			
I.D. No.		40610				Turn Signal Bulbs		---			
Bore Size		36mm				CHASSIS					
Float Height		10.7 $\pm$ 0.5mm				Axle Runout (Front/Rear)		---		.25mm	
Fuel Level		---				Brake Drum I.D.		Front: --- Rear: ---		130.7mm 150.7mm	
Air Screw		1 1/4				Brake Lining Thickness		Front: --- Rear: ---		1.5mm 1.5mm	
Pilot Screw		---				Brake Disc Thickness (Front & Rear)		---		---	
Pilot Air Jet		#37.5				Master Cylinder Cylinder Bore		Front: --- Rear: ---		---	
Pilot Jet		2.0				Master Cylinder Piston Diameter		Front: --- Rear: ---		---	
Cut Away		60H20-2				Brake Caliper Cylinder Bore		Front: --- Rear: ---		---	
Jet Needle		P-8				Brake Caliper Piston Dia.		Front: --- Rear: ---		---	
Needle Jet		2.5				Wheel Rim Runout (Radial & Axial)		---		2.0mm	
Secondary Air Jet		0.6				Tire Size		Front: 3.00 - 21 - 4PR Rear: 5.10 - 18 - 4PR		---	
Pilot Outlet		#260				Tire Tread Depth		Front: --- Rear: ---		4.0mm 4.0mm	
Main Jet						Tire Pressure		SOLO FRONT DUAL SOLO REAR			
ELECTRICAL						Normal Riding		11 psi		11 psi	
Ignition		SUZUKI "PEI"				Continuous High		---		---	
Ignition Timing		13.5 $^{\circ}$ $\pm$ 2 $^{\circ}$ B.T.D.C. @ 6000rpm				Speed Riding		---		---	
Firing Order		---				Fork Spring Free Length		---		571mm	
Spark Plug		NGK B9ES or ND W27ES				Swinging Arm Pivot Shaft Runout		---		0.3mm	
Spark Plug Gap		0.6 - 0.8mm				FUEL & OILS					
Contact Point Gap		---				Fuel Type		Premium			
Dwell Angle		---				Engine Oil Type		CCI Super 2 or equivalent			
Spark Performance		Over 8mm				Engine Oil Capacity		20:1 fuel/oil ratio premix			
Condensor Capacity		---				Transmission Oil Type/Cap		SAE 20W/40 / chq 800 ml ovhl 900 ml			
Ignition Coil Resistance (pri.)		B/W-W/B1 approx 0-1 ohm				Front Fork Air Pressure		---		---	
Ignition Coil Resistance (Sec.)		Plug cap-B/W or W/B1 approx 10-11K ohms				Fork Oil Type/Cap./Level		High quality SAE 10 fork oil or A.T.F./ 248ml/ 220mm			
Magnet Coil Resistances		B/R - B/W approx 195-245 ohms R/W - B/R approx 35-45 ohms Y/R - B/W approx 0-2 ohms									
Exciter Coil Resistance		---									
Pulser Coil Resistance		---									
Charging Coil Resistance		---									
Lighting Coil Output		Over 5.5V @ 2500rpm/under 8.0V @ 8000rpm									
Battery		---									
Specific Gravity		---									
Regulated Amperage		---									
Regulated Voltage		---									
Fuse Capacity		---									



SUZUKI

TWO STROKE

Service Bulletin

Bulletin No.: SPEC-17A
 Date: 6-12-81
 Read and Initial

Manager _____
 Parts Mgr. _____
 Service Mgr. _____
 Mechanics _____

MODELS: FA50X & FA50MX
 SUBJECT: SPECIFICATIONS

ITEM	STANDARD	LIMIT
VALVE SPECS		
Valve Lift	IN: EX:	
Tapet Clearance or Valve Clearance	IN: EX:	
Valve Guide--Valve Stem Clearance	IN: EX:	
Valve Guide I.D. (IN/EX)		
Valve Stem O.D.		
Valve Stem Deflection (IN & EX)		
Valve Head Thickness (IN & EX)		
Valve Seat Width (IN/EX)		
Valve Head Radial Runout (IN & EX)		
Valve Spring Free Length	INN: OUT:	
Valve Spring Tension	INN: OUT:	
Rocker Arm I.D. (IN & EX)		
Rocker Arm Shaft O.D. (IN & EX)		
CAMSHAFT		
Cam Height	IN: EX:	
Camshaft--Journal Clearance (IN & EX)		
Camshaft Journal I.D. (IN & EX)		
Camshaft Journal O.D. (IN & EX)		
Camshaft Deflection (IN & EX)		
Cam Chain 20 Pitch Length		
PISTON/RING/CLYINDER		
Compression Pressure		
Max. Difference Between Cylinders		
Piston--Cylinder Clearance	0.55-0.85mm	0.120mm
Cylinder Bore	41.000-41.015mm	41.065mm
Piston Dia./Measuring Point	40.930-40.945mm @2.3mm	40.880
Cylinder Warp	---	0.05mm
Piston ring free end gap	R:Approx4.5mm T:Approx5.0mm	3.6mm 4.0mm
Piston ring End Gap	0.10-0.25mm	0.75mm
Piston ring--Grove Clearance	0.020-0.060mm	
ITEM	STANDARD	LIMIT
Piston Pin Bore I.D.	11.998-12.006mm	12.030mm
Piston Pin O.D.	11.996-12.000mm	11.980mm
CRANKSHAFT		
Con-rod Small End Hole	16.003-16.011mm	16.040mm
Big End Side Clearance		
Con-rod Big End Wear		
Crankshaft Runout		0.05mm
Crankshaft Web to Web Width	40.0 ± 0.1mm	
OIL PUMP		
Oil Pressure		
Tip Clearance		
Outer Rotor Clearance		
Side Clearance		
Oil Pump Reduction Ratio	7.000 (14/2)	
CCI Pump Discharge Rate	0.97-1.14ml @2000rpm for 6 minutes	
CLUTCH		
Clutch Wheel ID	87.00-87.15mm	87.40mm
Clutch Shoe OD	86.9-87.0mm	No groove at any part
Drive Plate Claw Width		
Clutch Spring Free Length	below 28mm	over 28mm
Pri. Drive--Driven Gear Backlash		
TRANSMISSION		
Primary Reduction	1.000	FA50
Final Reduction	5.364	FA50M
Gear Ratios, Low/2nd	Chain: 2.384 (31/13)	
3rd/4th	Gear: 2.333 (56/14)	FA50
5th/Top	Gear: 2.636 (58/22)	FA50M
Gear Backlash	1st/2nd	
3rd/4th		
5th/6th		
Shift Fork--Grove Clearance		
Shift Fork Groove Width		
Shift Fork Thickness		
Drive Chain Size	64 links	
21 Pin Length	DL270H 170mm	173.7mm

I T E M		S T A N D A R D		L I M I T		I T E M		S T A N D A R D		L I M I T	
CARBURETOR		FA50		FA50M		Headlight (Low/High)		6V20w/20w			
Idle RPM		1500 ± 150 rpm				Instrument Bulbs (Speedo/ Tach/Hi Beam/Turn Signal)					
Carburetor Type		Mikuni VM12SH				Oil Pressure		6V1.5w/3w/1.7w			
I.D. No.		02340		02370		Tail light/Stop light		6V5.3w/17w			
Bore Size		12mm				Turn Signal Bulbs		6V17w			
Float Height		22.4 ± 1.0mm				CHASSIS					
Fuel Level						Axle Runout (Front/Rear)		---		0.25mm	
Air Screw		1 3/4				Brake Drum I.D.		Front: ---		80.5mm	
Pilot Screw						Brake Lining Thickness		Front: ---		80.5mm	
Pilot Air Jet						Brake Disc Thickness (Front & Rear)		Front: ---		1.5mm	
Pilot Jet		#15				Master Cylinder Cylinder Bore		Front: ---		1.5mm	
Cut Away		2.0				Master Cylinder Piston Diameter		Front: ---			
Jet Needle		3F13-3		3D18		Brake Calliper Cylinder Bore		Front: ---			
Needle Jet		E6				Brake Calliper Piston Dia.		Front: ---			
Secondary Air Jet						Wheel Rim Runout (Radial & Axial)		---		2.0mm	
Pilot Outlet		0.7				Tire Size		Front: 2.25 4PR		---	
Main Jet		77.5				Tire Tread Depth		Rear: 2.25 4PR		---	
ELECTRICAL						Tire Pressure		Front: ---		1.6mm	
Ignition		Suzuki "PEI"				Normal Riding		SOLO		FRONT	
Ignition Timing		25° ± 2° BTDC @4000rpm				Continuous High		DUAL		SOLO	
Firing Order						Speed Riding				21 psi	
Spark Plug		NGK BP4HA or ND W14FP-UL				Fork Spring Free Length				28 psi	
Spark Plug Gap		0.6-0.8mm				Engine Mount Pivot Shaft Runout				---	
Contact Point Gap						FUEL & OILS				0.6mm	
Dwell Angle						Fuel Type		Low-lead or Unleaded			
Spark Performance		Over 8mm				Engine Oil Type		Suzuki CCI Super 2			
Condensor Capacity						Engine Oil Capacity		CCI Tank: 0.7L			
Ignition Coil Resistance (Pri.)		B/Y-Ground Approx. 0-1ohm				Transmission Oil Type/Cap		SAE20w/40/chg500ml/ovrhl 550ml			
Ignition Coil Resistance (Sec.)		PlugCap-Ground approx 16-18k ohms				Front Fork Air Pressure					
Pri. Ignition Coil Resistance						Fork Oil Type/Cap./Level					
Magnet Coil Resistance		Y/R-W/R Approx. 0-1ohm W/R-B/W Approx. 0-1ohm Y/R-B/W Approx. 0-1ohm R/B-B/W Approx. 90-110 ohm R/B-B/R Approx. 90-110 ohm Above 5.5V at 2300rpm Below 8.7V at 8000rpm									
Lighting Coil Output											
Battery		6N2-2A-4 1.28 @20°C									
Specific Gravity											
Regulated Amperage		Below 2.5A @8000rpm									
Regulated Voltage											
Fuse Capacity		(1) 10A									



SUZUKI

TWO STROKE

Service Bulletin

Bulletin No.: SPECS-17C

Date: 6-12-81

Read and Initial

Manager _____

Parts Mgr. _____

Service Mgr. _____

Mechanics _____

MODEL: FS50X

SUBJECT: SPECIFICATIONS

ITEM	STANDARD	LIMIT
VALVE SPECS		
Valve Lift	IN: EX:	
Tappet Clearance or Valve Clearance	IN: EX:	
Valve Guide--Valve Stem Clearance	IN: EX:	
Valve Guide I.D. (IN/EX)		
Valve Stem O.D.		
Valve Stem Deflection (IN & EX)		
Valve Head Thickness (IN & EX)		
Valve Seat Width (IN/EX)		
Valve Head Radial Runout (IN & EX)		
Valve Spring Free Length	INN: OUT:	
Valve Spring Tension	INN: OUT:	
Rocker Arm I.D. (IN & EX)		
Rocker Arm Shaft O.D. (IN & EX)		
CAMSHAFT		
Cam Height	IN: EX:	
Camshaft--Journal Clearance (IN & EX)		
Camshaft Journal I.D. (IN & EX)		
Camshaft Journal O.D. (IN & EX)		
Camshaft Deflection (IN & EX)		
Cam Chain 20 Pitch Length		
PISTON/RING/CYLINDER		
Compression Pressure		
Max. Difference Between Cylinders		
Piston--Cylinder Clearance	0.065-0.075mm	0.120mm
Cylinder Bore	41.000-41.015mm	41.065mm
Piston Dia. / Measuring Point	40.930-40.945mm@23mm	40.880mm
Cylinder Warp	---	0.05mm
Piston ring free end gap	1st, 2nd APPROX. 5mm	2.6mm
Piston ring End Gap	1st, 2nd APPROX. 0mm	4.0mm
Piston ring--Groove Clearance	0.10-0.25mm	0.75mm
	0.020-0.060mm	---
CRANKSHAFT		
Con-rod Small End Hole	16.003-16.011mm	16.040mm
Big End Side Clearance		
Con-rod Big End Wear		
Crankshaft Runout	---	0.05mm
Crankshaft Web to Web Width	40.0 ± 0.1mm	---
OIL PUMP		
Oil Pressure		
Tip Clearance		
Outer Rotor Clearance		
Side Clearance		
Oil Pump Reduction Ratio	7.00 (14/2)	
CCI Pump Discharge Rate	0.97-1.14ml for 6 min. @2000 RPM	
CLUTCH		
CLUTCH WHEEL ID LOW	87.00-87.15mm	87.40mm
HIGH	105.00-105.15mm	105.50mm
LOW	---	NO GROOVE AT
HIGH	---	ANY PART
Clutch Spring Free Length	High:	28mm
Pri. Drive--Driven Gear Backlash		
TRANSMISSION		
Primary Reduction	1.000	---
Final Reduction	7.530	
Gear Ratios, Low/2nd	2.137(62/29)	1.421(54/38)
3rd/4th		
5th/Top		
Gear Backlash 1st/2nd		
3rd/4th		
5th/6th		
Shift Fork--Groove Clearance		
Shift Fork Groove Width		
Shift Fork Thickness		
Drive Chain Size	DID 270H	64 Links
21 Pin Length		173.7mm

I T E M		S T A N D A R D	L I M I T
CARBURETOR			
Idle RPM	1600 $\pm$ 150 RPM		
Carburetor Type	MIKUNI VM12SH		
I.D. No.	02510		
Bore Size	12mm		
Floater Height	22.4 $\pm$ 1.0mm		
Fuel Level			
Air Screw	1 3/4		
Pilot Screw			
Pilot Air Jet			
Pilot Jet	#15		
Cut Away	2.0		
Jet Needle	3F13-3		
Needle Jet	E-6		
Secondary Air Jet			
Pilot Outlet	0.7		
Main Jet	#77.5		
ELECTRICAL			
Ignition			
Ignition Timing	20 $\pm$ 2 BTDC@4000 RPM		
Firing Order			
Spark Plug	*NGK BP4HA or ND W14FP-UL		
Spark Plug Gap	0.6-0.8mm		
Contact Point Gap			
Dwell Angle			
Spark Performance	Over 8mm		
Condensor Capacity			
Ignition Coil Resistance (Pri.)			
Ignition Coil Resistance (Sec.)			
Pri. Ignition Coil Resistance			
MAGNETO COIL RESISTANCE	B/R-B/W Approx. 290-330 ohms		
	R/B-B/W Approx. 0-2 ohms		
	W/R-B/W Approx. 0-1 ohm		
	Y/R-B/W Approx. 0-1 ohm		
Charging Coil Resistance			
Lighting Coil Output			
Battery	6V14.4KC		
Specific Gravity	1.26 @20°C		
Regulated Amperage			
Regulated Voltage	Above 5.5V at 4000RPM Below 8.5V at 8000RPM		
Fuse Capacity	(1) 10A		
I T E M		S T A N D A R D	L I M I T
Headlight (Low/High)		6V20W/20W	
Instrument Bulbs (Speedo/Tach/Hi Beam/Turn Signal)			
Oil Pressure		6V1.5w/1.7w/3w	
Tail Light/Stop Light		6V5.3w/17w	
Turn Signal Bulbs		6V17w	
CHASSIS			
Axle Runout (Front/Rear)		---	0.25mm
Brake Drum I.D.		Front: --- Rear: ---	80.5mm
Brake Lining Thickness		Front: --- Rear: ---	80.5mm
Brake Disc Thickness (Front & Rear)		Front: --- Rear: ---	1.5mm
Master Cylinder Bore		Front: --- Rear: ---	1.5mm
Master Cylinder Piston Diameter		Front: --- Rear: ---	
Brake Caliper Cylinder Bore		Front: --- Rear: ---	
Brake Caliper Piston Dia.		Front: --- Rear: ---	
Wheel Rim Runout (Radial & Axial)		---	2.0mm
Tire Size		Front: 2.75-10 2PR Rear: 2.75-10 2PR	---
Tire Tread Depth		Front: --- Rear: ---	1.6mm
Tire Pressure		FRONT SOLO DUAL SOLO DUAL	REAR SOLO DUAL
Normal Riding		18 psi	25 psi
Continuous High			
Speed Riding			
Fork Spring Free Length		---	214.0mm
Swinging Arm Pivot Shaft Runout		---	0.6mm
FUEL & OILS			
Fuel Type		Unleaded or Low Lead	
Engine Oil Type		Suzuki CCI Super 2	
Engine Oil Capacity		CCI Tank: 1.2L	
Transmission Oil Type/Cap		SAE20w/40, chg.800ml/ovrhl850MI	
Front Fork Air Pressure			
Fork Oil Type/Cap./Level		HIGH QUALITY SAE#10 85 ML/190mm	



SUZUKI

TWO STROKE

Service Bulletin

Bulletin No.: SPEC-17D
Date: 6-12-81
Read and Initial

Manager _____
Parts Mgr. _____
Service Mgr. _____
Mechanics _____

MODEL FZ50X
SUBJECT: SPECIFICATIONS

ITEM	STANDARD	LIMIT
VALVE SPECS		
Valve Lift	IN: _____ EX: _____	
Tapet Clearance or Valve Clearance	IN: _____ EX: _____	
Valve Guide--Valve Stem Clearance	IN: _____ EX: _____	
Valve Guide I.D. (IN/EX)		
Valve Stem O.D.		
Valve Stem Deflection (IN & EX)		
Valve Head Thickness (IN & EX)		
Valve Seat Width (IN/EX)		
Valve Head Radial Runout (IN & EX)		
Valve Spring Free Length	INN: _____ OUT: _____	
Valve Spring Tension	INN: _____ OUT: _____	
Rocker Arm I.D. (IN & EX)		
Rocker Arm Shaft O.D. (IN & EX)		
CAMSHAFT		
Cam Height	IN: _____ EX: _____	
Camshaft--Journal Clearance (IN & EX)		
Camshaft Journal I.D. (IN & EX)		
Camshaft Journal O.D. (IN & EX)		
Camshaft Deflection (IN & EX)		
Cam Chain 20 Pitch Length		
PISTON/RING/CYLINDER		
Compression Pressure		
Max. Difference Between Cylinders		
Piston--Cylinder Clearance	0.070-0.080mm	0.120mm
Cylinder Bore	41.000-41.015mm	41.060
Piston Dia./Measuring Point	40.925-50.940mm @23mm	40.880
Cylinder Warp	---	0.03mm
Piston ring free end gap	R: Approx 4.5mm I: Approx 5.0mm	3.6mm 4.0mm
Piston ring End Gap	0.10-0.25mm	0.75mm
Piston ring--Grove Clearance	0.020-0.060mm	---
ITEM	STANDARD	LIMIT
Piston Pin Bore I.D.	11.998-12.006mm	12.030mm
Piston Pin O.D.	11.996-12.000mm	11.980mm
CRANKSHAFT		
Con-rod Small End Hole	16.003-16.011mm	16.040mm
Big End Side Clearance		
Con-rod Big End Wear		
Crankshaft Runout	---	0.05mm
Crankshaft Web to Web Width	40.0 ± 0.1 mm	---
OIL PUMP		
Oil Pressure		
Tip Clearance		
Outer Rotor Clearance		
Side Clearance		
Oil Pump Reduction Ratio	7.000 (14/2)	
CCI Pump Discharge Rate	1.02-1.26ml @2000rpm for 6 minutes	
CLUTCH		
Clutch Wheel I.D.	Low: 87.00-87.15mm High: 105.00-105.15mm	87.40mm 105.50mm
Clutch Shoe O.D.	Low: 86.9-87.0mm High: 104.7-104.8mm	No Groove AT ANY PART
Drive Plate Claw Width		Low: 28mm High: 35mm
Clutch Spring Free Length		
Pri. Drive--Driven Gear Backlash		
TRANSMISSION		
Primary Reduction	1.000	
Final Reduction	8.696 (31/13 x 62/17)	
Gear Ratios, Low/2nd 3rd/4th 5th/Top	2.137(62/29)1.421(54/38)	
Gear Backlash 1st/2nd 3rd/4th 5th/6th		
Shift Fork--Grove Clearance	0.05-0.10mm	0.15mm
Shift Fork Groove Width		
Shift Fork Thickness		
Drive Chain Size	DID 270 H 64 links	
21 Pin Length	170.0mm	173.0mm

I T E M		S T A N D A R D		I T E M		S T A N D A R D		L I M I T	
CARBURETOR				Headlight (Low/High)		6V20w/20w			
Idle RPM		1500 $\pm$ 150rpm		Instrument Bulbs (Speedo/					
Carburetor Type		Mikuni VM14SH		Tach/Hi Beam/Turn Signal					
I.D. No.		02421		Oil Pressure		6V1.7w/3w			
Bore Size		14mm		Tail light/Stop light		6V5.3w/17w			
Float Height		22.4 $\pm$ 1.0mm		Turn Signal Bulbs		6V17w			
Fuel Level				CHASSIS					
Air Screw		1 3/4		Axle Runout (Front/Rear)		---		0.25mm	
Pilot Screw				Brake Drum I.D.		Front: ---		100.7mm	
Pilot Air Jet				Brake Lining Thickness		Rear: ---		100.7mm	
Pilot Jet		#15		Brake Disc Thickness		Front: ---		1.5mm	
Cut Away		2.0		Brake Disc Thickness		Rear: ---		1.5mm	
Jet Needle		3D13-3		Master Cylinder		Front: ---			
Needle Jet		E-2		Cylinder Bore		Rear: ---			
Secondary Air Jet				Master Cylinder		Front: ---			
Pilot Outlet		0.9		Piston Diameter		Rear: ---			
Main Jet		#57.5		Brake Caliper Cylinder		Front: ---			
ELECTRICAL				Bore		Rear: ---			
Ignition		Suzuki "PEI"		Brake Caliper Piston Dia.		Front: ---			
Ignition Timing		25° $\pm$ 2° BTDC @4000rpm		Rear:		Rear: ---		2.0mm	
Firing Order				Wheel Rim Runout (Radial		---		---	
Spark Plug		NGK BP4HA or ND W14FP-UL		& Axial)		Front: 3.00-12 4PR		---	
Spark Plug Gap		0.6-0.8mm		Tire Size		Rear: 3.00-12 4PR		---	
Contact Point Gap				Tire Tread Depth		Front: ---		1.6mm	
Dwell Angle				Rear:		Rear: ---		1.6mm	
Spark Performance		Over 8mm		Tire Pressure		FRONT		REAR	
Condensor Capacity				Normal Riding		SOLO	DUAL	SOLO	DUAL
Ignition Coil Resistance		B/Y-Ground Approx. 0-1ohm		Continuous High		18psi		21psi	
Ignition Coil Resistance				Speed Riding					
Ignition Coil Resistance				Fork Spring Free Length		---		---	
Pri. Ignition Coil Resistance		PlugCap-Ground Approx. 4-6kohm		Engine Mount Pivot Shaft		---		0.6mm	
High Speed Coil Resistance				Runout					
Low Speed Coil Resistance				FUEL & OILS					
Magneto Coil Resistance		B/W-Y Approx. 0.4ohm		Fuel Type		Low-Lead or Unleaded			
Charging Coil Resistance		B/R-R/S Approx. 230ohm		Engine Oil Type		Suzuki CCI Super 2			
Lighting Coil Output		B/W-W/R Approx. 0.75ohm		Engine Oil Capacity		CCI Tank: 1.2L			
Battery		Above 5.7V at 2500rpm		Transmission Oil Type/Cap		SAE20w/40/chg800ml/cvrhl 850ml			
Specific Gravity		1.26 @20°C		Front Fork Air Pressure					
Regulated Amperage				Fork Oil Type/Cap./Level					
Regulated Voltage									
Fuse Capacity		(1) 10A							



SUZUKI

TWO STROKE

Service Bulletin

Bulletin No.: SPECS-17E

Date: 6/5/81

Read and Initial

Manager _____

Parts Mgr. _____

Service Mgr. _____

Mechanics _____

MODEL: JR50X

SUBJECT: SPECIFICATIONS

ITEM	STANDARD	LIMIT
VALVE SPECS		
Valve Lift	IN: EX:	
Tappet Clearance or Valve Clearance	IN: EX:	
Valve Guide--Valve Stem Clearance	IN: EX:	
Valve Guide I.D. (IN/EX)		
Valve Stem O.D.		
Valve Stem Deflection (IN & EX)		
Valve Head Thickness (IN & EX)		
Valve Seat Width (IN/EX)		
Valve Head Radial Runout (IN & EX)		
Valve Spring Free Length	INN: OUT:	
Valve Spring Tension	INN: OUT:	
Rocker Arm I.D. (IN & EX)		
Rocker Arm Shaft O.D. (IN & EX)		
CAMSHAFT		
Cam Height	IN: EX:	
Camshaft--Journal Clearance (IN & EX)		
Camshaft Journal I.D. (IN & EX)		
Camshaft Journal O.D. (IN & EX)		
Camshaft Deflection (IN & EX)		
Cam Chain 20 Pitch Length		
PISTON/RING/CYLINDER		
Compression Pressure		
Max. Difference Between Cylinders		
Piston--Cylinder Clearance	0.065-0.075mm	0.120mm
Cylinder Bore	41.000-41.015mm	41.065mm
Piston Dia./Measuring Point	40.930-40.945mm @23mm	40.880mm
Cylinder Warp		0.05
Piston ring free end gap	R: Approx 4.5mm T: Approx 5.0mm	3.6mm 4.0mm
Piston ring End Gap	0.10-0.25mm	0.75mm
Piston ring--Grove Clearance	0.02-0.06mm	---
ITEM	STANDARD	LIMIT
Piston Pin Bore I.D.	12.002-12.010mm	12.030mm
Piston Pin O.D.	11.995-12.000mm	11.980mm
CRANKSHAFT		
Con-rod Small End Hole	16.003-16.011mm	16.040mm
Big End Side Clearance		
Con-rod Big End Wear		
Crankshaft Runout	---	0.05mm
Crankshaft Web to Web Width	32 ± 0.1mm	---
OIL PUMP		
Oil Pressure		
Tip Clearance		
Outer Rotor Clearance		
Side Clearance		
Oil Pump Reduction Ratio	60.95 (53/20 x 23/1)	
CCI Pump Discharge Rate	0.63-0.85ml @2000rpm for 6 minutes	
CLUTCH		
Drive Plate Thickness	2.3-2.5mm	2.0mm
Drive Plate Warp		
Driven Plate Thickness	1.60 ± 0.08mm	---
Driven Plate Warp	---	0.15mm
Drive Plate Claw Width	15.65-15.95mm	14.85
Clutch Spring Free Length	---	10.07
Pri. Drive--Driven Gear Backlash		
TRANSMISSION		
Primary Reduction	2.650 (53/20)	
Final Reduction	2.153 (28/13)	
Gear Ratios, Low/2nd 3rd/4th 5th/Top	Drive Position: 2.230(29/13)	
Gear Backlash 1st/2nd 3rd/4th 5th/6th		
Shift Fork--Grove Clearance	0.20-0.40mm	0.60mm
Shift Fork Groove Width	6.60-6.70mm	---
Shift Fork Thickness	6.30-6.40mm	---
Drive Chain Size	DU420 or TAKASAGO BK 420 78 links	
21 pin Length	---	259mm

I T E M	S T A N D A R D	L I M I T	I T E M	S T A N D A R D	L I M I T
CARBURETOR			Headlight (Low/High)		
Idle RPM	1500 $\pm$ 100 rpm		Instrument Bulbs (Speedo/ Tach/Hi Beam/Turn Signal Oil Pressure)		
Carburetor Type	Mikuni VM12SC		Tail light/Stop light		
I.D. No.	04410		Turn Signal Bulbs		
Bore Size	12mm		CHASSIS		
Float Height	24.5-25.0mm		Axle Runout (Front/Rear)	---	0.25mm
Fuel Level	5.0 $\pm$ 0.5mm		Brake Drum I.D.	Front: --- Rear: ---	90.7mm 90.7mm
Air Screw	1 $\frac{1}{2}$		Brake Lining Thickness	Front: --- Rear: ---	1.5mm 1.5mm
Pilot Screw			Brake Disc Thickness (Front & Rear)		
Pilot Air Jet	#15		Master Cylinder Cylinder Bore	Front: Rear:	
Pilot Jet	3.0		Master Cylinder Piston Diameter	Front: Rear:	
Cut Away	3E3-3		Brake Caliper Cylinder Bore	Front: Rear:	
Jet Needle	E-4		Brake Caliper Piston Dia.	Front: Rear:	
Needle Jet			Wheel Rim Runout (Radial & Axial)	---	2.0mm
Secondary Air Jet			Tire Size	Front: 2.50-10 2 PR Rear: 2.50-10 2 PR	---
Pilot Outlet	0.7		Tire Tread Depth	Front: --- Rear: ---	1.6mm 1.6mm
Main Jet	#52.5		Tire Pressure	FRONT DUAL SOLO SOLO 21psi 21psi	
ELECTRICAL			Normal Riding Continuous High Speed Riding		
Ignition	Magneto		Fork Spring Free Length	---	441mm
Ignition Timing	24° $\pm$ 2° BTDC		Swinging Arm Pivot Shaft Runout	---	0.6mm
Firing Order			FUEL & OILS		
Spark Plug	NGKBP4H or ND W14FP		Fuel Type	Low-lead or Unleaded	
Spark Plug Gap	0.6-0.8mm		Engine Oil Type	Suzuki CCI Super 2	
Contact Point Gap	0.30-0.40mm		Engine Oil Capacity	CCI Tank 0.3L	
Dwell Angle	215°		Transmission Oil Type/Cap	SAE 20W/40/chg650ml/ovrhl 500ml	
Spark Performance	Over 8mm		Front Fork Air Pressure		
Condensor Capacity	0.18 $\pm$ 0.02uf		Fork Oil Type/Cap./Level		
Ignition Coil Resistance (Pri.)	B-Ground Approx. 1-2ohm				
Ignition Coil Resistance (Sec.)	PlugCap-B Approx. 4-6Kohm				
Pri. Ignition Coil Resistance					
MAGNETO					
Coil Resistance	B-Ground Approx 0-1ohm				
Low Speed Coil Resistance					
Exciter Coil Resistance					
Pulsar Coil Resistance					
Charging Coil Resistance					
Lighting Coil Output					
Battery					
Specific Gravity					
Regulated Amperage					
Regulated Voltage					
Fuse Capacity					



SUZUKI

TWO STROKE

Service Bulletin

Bulletin No.: SPECS-171

Date: 6/5/81
Read and Initial

Manager _____

Parts Mgr. _____

Service Mgr. _____

Mechanics _____

MODEL: RM125X

SUBJECT: SPECIFICATIONS

ITEM	STANDARD	LIMIT	ITEM	STANDARD	LIMIT
VALVE SPECS			Piston Pin Bore I.D.	14.002-14.010mm	14.030mm
Valve Lift	IN: EX:		Piston Pin O.D.	13.995-14.000mm	13.980mm
Tappet Clearance or Valve Clearance	IN: EX:		CRANKSHAFT		
Valve Guide--Valve Stem Clearance	IN: EX:		Con-rod Small End Hole	18.003-18.011mm	18.040mm
Valve Guide I.D. (IN/EX)			Big End Side Clearance		
Valve Stem O.D.			Con-rod Big End Wear		0.05mm
Valve Stem Deflection (IN & EX)			Crankshaft Runout		
Valve Head Thickness (IN & EX)			Crankshaft Web to Web Width	56.0 + 0.1mm	
Valve Seat Width (IN/EX)			OIL PUMP		
Valve Head Radial Runout (IN & EX)			Oil Pressure		
Valve Spring Free Length	INN: OUT:		Tip Clearance		
Valve Spring Tension	INN: OUT:		Outer Rotor Clearance		
Rocker Arm I.D. (IN & EX)			Side Clearance		
Rocker Arm Shaft O.D. (IN & EX)			Oil Pump Reduction Ratio		
CAMSHAFT			CCI Pump Discharge Rate		
Cam Height	IN: EX:		CLUTCH		
Camshaft--Journal Clearance (IN & EX)			Drive Plate Thickness	2.7-2.9mm	2.4mm
Camshaft Journal I.D. (IN & EX)			Drive Plate Warp		
Camshaft Journal O.D. (IN & EX)			Driven Plate Thickness	1.6 + 0.1mm	
Camshaft Deflection (IN & EX)			Driven Plate Warp		.01mm
Cam Chain 20 Pitch Length			Drive Plate Claw Width	11.8-12.0mm	11.3mm
PISTON/RING/CYLINDER			Clutch Spring Free Length		36.3mm
Compression Pressure			Pri. Drive--Driven Gear Backlash		
Max. Difference Between Cylinders			TRANSMISSION		
Piston--Cylinder Clearance	0.055-0.065mm	0.120mm	Primary Reduction	3.157 (60/19)	
Cylinder Bore	54.000-54.015mm	54.060mm	Final Reduction	4.250 (51/12)	
Piston Dia. / Measuring Point	53.940-53.955mm @18mm	53.880mm	Gear Ratios, Low/2nd 3rd/4th 5th/Top	2.333(28/12), 1.750(28/16) 1.411(24/17), 1.190(25/21) 1.045(23/22), 0.956(22/23)	
Cylinder Warp		0.05mm	Gear Backlash 1st/2nd 3rd/4th 5th/6th		
Piston ring free end gap	R. appr 7.0mm/R. appr 7.0mm	5.6mm	Shift Fork--Grove Clearance	0.05-0.25mm	0.45mm
Piston ring End Gap	1.2-1.5mm	2.0mm	Shift Fork Groove Width	4.45-4.55mm, 5.45-5.55mm	
Piston ring--Grove Clearance	R .010-.060mm		Shift Fork Thickness	4.30-4.40mm, 5.30-5.40mm	
			Drive Chain Size	DAIDO 520DS, Takasago 520k	112 links
			21 Pin Length		332mm

I T E M		S T A N D A R D		I T E M		S T A N D A R D		L I M I T	
CARBURETOR				Headlight (Low/High)					
Idle RPM		---		Instrument Bulbs (Speedo/ Tach/Hi Beam/Turn Signal Oil Pressure)					
Carburetor Type		Mikuni VM32SS		Tail light/stop light					
I.D. No.		14100		Turn Signal Bulbs					
Bore Size		32mm		CHASSIS					
Float Height		12.5 ± 0.5		Axle Runout (Front/Rear)		---		0.25mm	
Fuel Level		---		Brake Drum I.D.		---		130.7mm	
Air Screw		1 1/2		Brake Lining Thickness		---		1.5mm	
Pilot Screw		---		Brake Disc Thickness (Front & Rear)		---		1.5mm	
Pilot Air Jet		---		Master Cylinder Cylinder Bore		Front: Rear:			
Pilot Jet		30		Master Cylinder Piston Diameter		Front: Rear:			
Cut Away		2.0		Brake Caliper Cylinder Bore		Front: Rear:			
Jet Needle		6FP35-2		Brake Caliper Piston Dia.		Front: Rear:			
Needle Jet		Q-6		Wheel Rim Runout (Radial & Axial)		2.0mm			
Secondary Air Jet		---		Tire Size		Front: 3.90x21 4PR Rear: 4.10x21 4PR		---	
Pilot Outlet		0.8		Tire Tread Depth		Front: --- Rear: ---		4.0mm 4.0mm	
Main Jet		250		Tire Pressure		SOLO FRONT DUAL SOLO DUAL			
ELECTRICAL				Normal Riding		10-16 psi		10-16 psi	
Ignition		SUZUKI PEI		Continuous High					
Ignition Timing		17° ± 1° BTDC @ 10,000r/min		Speed Riding					
Firing Order				Fork Spring Free Length		---		544mm	
Spark Plug		NGK B8EGV or Nippon Denso		Swinging Arm Pivot Shaft Runout		---		0.3mm	
Spark Plug Gap		0.5-0.6mm		FUEL & OILS					
Contact Point Gap				Fuel Type		Premium			
Dwell Angle				Engine Oil Type		Suzuki CCI Super 2			
Spark Performance		over 8mm		Engine Oil Capacity					
Condensor Capacity				Transmission Oil Type/Cap		SAE 20W-40/chg 800ml/ovhl 850ml			
Ignition Coil Resistance (Pri.)		B/W-W/Bl approx 0-1 ohm		Front Fork Air Pressure		High Quality SAE 10 Fork Oil or ATF/430ml/167mm			
Ignition Coil Resistance (Sec.)		Plug Cap - B/W approx 10-11 ohms		Rear Shock Air Pressure		142 psi			
Pri. Ignition Coil Resistance				Rear Shock Spring Pre-Set Length		280mm			
Magneto Coil Resistance		R/W-B/W approx 90-140 ohms R/W-B/R approx 100-160 ohms		Cooling Solution Capacity		980ml			
Exciter Coil Resistance									
Pulser Coil Resistance									
Charging Coil Resistance									
Lighting Coil Output									
Battery									
Specific Gravity									
Regulated Amperage									
Regulated Voltage									
Fuse Capacity									



SUZUKI

TWO STROKE

Service Bulletin

SPECS-17G
Bulletin N6/5/81

Date:

Read and Initial

Manager

Parts Mgr.

Service Mgr.

Mechanics

MODEL: RM80X

SUBJECT: SPECIFICATIONS

ITEM	STANDARD	LIMIT
VALVE SPECS		
Valve Lift	IN: EX:	
Tappet Clearance or Valve Clearance	IN: EX:	
Valve Guide--Valve Stem Clearance	IN: EX:	
Valve Guide I.D. (IN/EX)		
Valve Stem O.D.		
Valve Stem Deflection (IN & EX)		
Valve Head Thickness (IN & EX)		
Valve Seat Width (IN/EX)		
Valve Head Radial Runout (IN & EX)		
Valve Spring Free Length	INN: OUT:	
Valve Spring Tension	INN: OUT:	
Rocker Arm I.D. (IN & EX)		
Rocker Arm Shaft O.D. (IN & EX)		
CAMSHAFT		
Cam Height	IN: EX:	
Camshaft--Journal Clearance (IN & EX)		
Camshaft Journal I.D. (IN & EX)		
Camshaft Journal O.D. (IN & EX)		
Camshaft Deflection (IN & EX)		
Cam Chain 20 Pitch Length		
PISTON/RING/CYLINDER		
Compression Pressure		
Max. Difference Between Cylinders		
Piston--Cylinder Clearance	.060-.070mm	0.120mm
Cylinder Bore	49.000-49.015mm	49.070mm
Piston Dia./Measuring Point	48.935-48.950mm @ 18mm	48.880mm
Cylinder Warp	---	0.05mm
Piston ring free end gap	1st & 2nd: approx. 5.0mm	4.0mm
Piston ring End Gap	1.2-1.5mm	2.0mm
Piston ring--Grove Clearance	1st & 2nd: approx. 0.015-0.065mm	---
ITEM	STANDARD	LIMIT
Piston Pin Bore I.D.	12.000-12.010mm	12.030mm
Piston Pin O.D.	11.995-12.000mm	11.980mm
CRANKSHAFT		
Con-rod Small End Hole	16.003-16.011mm	16.060mm
Big End Side Clearance		
Con-rod Big End Wear		
Crankshaft Runout	---	0.05mm
Crankshaft Web to Web Width	52.0 + 0.1mm	---
OIL PUMP		
Oil Pressure		
Tip Clearance		
Outer Rotor Clearance		
Side Clearance		
Oil Pump Reduction Ratio		
CCI Pump Discharge Rate		
CLUTCH		
Drive Plate Thickness	2.9-3.1mm	2.6mm
Drive Plate Warp		
Driven Plate Thickness	1.6 + 0.1mm	---
Driven Plate Warp	---	0.1mm
Drive Plate Claw Width	11.8-12.0mm	11.3mm
Clutch Spring Free Length	---	33.6mm
Pri. Drive--Driven Gear Backlash		
TRANSMISSION		
Primary Reduction	3.842 (73/19)	---
Final Reduction	3.571 (50/14)	---
Gear Ratios, Low/2nd	2.571 (36/14)	1.888 (34/14)
3rd/4th	1.500 (30/20)	1.250 (25/20)
5th/Top	1.083 (26/24)	0.961 (25/26)
Gear Backlash 1st/2nd		
3rd/4th		
5th/6th		
Shift Fork--Grove Clearance	0.10-0.30mm	---
Shift Fork Groove Width	4.45-4.55mm	---
Shift Fork Thickness	4.25-4.35mm	---
Drive Chain Size	DID 428 GM, 112 links	---
21 Pin Length		259mm

I T E M	S T A N D A R D	L I M I T
CARBURETOR		
Idle RPM	---	
Carburetor Type	Mikuni VM26SS	
I.D. No.	46920	
Bore Size	26mm	
Float Height	23 + 1.0mm	
Fuel Level	---	
Air Screw	2.0	
Pilot Screw	---	
Pilot Air Jet	---	
Pilot Jet	#35	
Cut Away	2.0	
Jet Needle	5DP39-2	
Needle Jet	P-4	
Secondary Air Jet	---	
Pilot Outlet	0.6	
Main Jet	#155	
ELECTRICAL		
Ignition	SUZUKI "PEI"	
Ignition Timing	13° + 1° @ 12,000 rpm	
Firing Order		
Spark Plug	NCK B8ES, ND H24ES	
Spark Plug Gap	0.6-0.8mm	
Contact Point Gap		
Dwell Angle		
Spark Performance	over 8mm	
Condensor Capacity		
Ignition Coil Resistance (Pri.)	B/W - W/B1 approx. 0-1 ohm	
Ignition Coil Resistance (Sec.)	plug Cap - B/W approx. 10-12 K ohms	
Magneto Coil Resistance	B/W-R/W approx 250-300 ohms B/W-B1 approx 50-60 ohms B/R-R/W approx 70-80 ohms	
Pulser Coil Resistance		
Charging Coil Resistance		
Lighting Coil Output		
Battery		
Specific Gravity		
Regulated Amperage		
Regulated Voltage		
Fuse Capacity		
I T E M	S T A N D A R D	L I M I T
Headlight (Low/High)		
Instrument Bulbs (Speedo/Tach/Hi Beam/Turn Signal Oil Pressure)		
Tail light/Stop light		
Turn Signal Bulbs		
CHASSIS		
Axle Runout (Front/Rear)		0.25mm
Brake Drum I.D.	Front: --- Rear: ---	110.7mm 110.7mm
Brake Lining Thickness	Front: --- Rear: ---	1.5mm 1.5mm
Brake Disc Thickness (Front & Rear)		
Master Cylinder Cylinder Bore	Front: --- Rear: ---	
Master Cylinder Piston Diameter	Front: --- Rear: ---	
Brake Caliper Cylinder Bore	Front: --- Rear: ---	
Brake Caliper Piston Dia.	Front: --- Rear: ---	
Wheel Rim Runout (Radial & Axial)	---	2.0mm
Tire Size	Front: 2.75 x 17 4PR Rear: 4.10 x 14 4PR	---
Tire Tread Depth	Front: --- Rear: ---	4.0mm 4.0mm
Tire Pressure	FRONT DUAL SOLO DUAL SOLO DUAL	REAR DUAL
Normal Riding		
Continuous High		
Speed Riding		
Fork Spring Free Length		512mm
Swinging Arm Pivot Shaft Runout		0.6mm
FUEL & OILS		
Fuel Type	Premium	
Engine Oil Type	SUZUKI CCI Super 2	
Engine Oil Capacity		
Transmission Oil Type/Cap	SAE 20W-40, Change 700ml/ovhl 750ml	
Front Fork Air Pressure		
Fork Oil Type/Cap./Level	SAE 5W-20 or ATF 166ml/170mm	



SUZUKI

TWO STROKE

Service Bulletin

Bulletin No.: SPECS-17F

Date: 6/5/81

Read and Initial

Manager _____

Parts Mgr. _____

Service Mgr. _____

Mechanics _____

MODEL: RM60X

SUBJECT: SPECIFICATIONS

ITEM	STANDARD	LIMIT
VALVE SPECS		
Valve Lift	IN: EX:	
Tappet Clearance or Valve Clearance	IN: EX:	
Valve Guide--Valve Stem Clearance	IN: EX:	
Valve Guide I.D. (IN/EX)	IN: EX:	
Valve Stem O.D.		
Valve Stem Deflection (IN & EX)		
Valve Head Thickness (IN & EX)		
Valve Seat Width (IN/EX)		
Valve Head Radial Runout (IN & EX)		
Valve Spring Free Length	INN: OUT:	
Valve Spring Tension	INN: OUT:	
Rocker Arm I.D. (IN & EX)		
Rocker Arm Shaft O.D. (IN & EX)		
CAMSHAFT		
Cam Height	IN: EX:	
Camshaft--Journal Clearance (IN & EX)		
Camshaft Journal I.D. (IN & EX)		
Camshaft Journal O.D. (IN & EX)		
Camshaft Deflection (IN & EX)		
Cam Chain 20 Pitch Length		
PISTON/RING/CLINDER		
Compression Pressure		
Max. Difference Between Cylinders		
Piston--Cylinder Clearance	0.060-0.070mm	0.120mm
Cylinder Bore	42.000-42.015mm	42.070mm
Piston Dia./ Measuring Point	41.935-41.950mm @ 18mm	41.880mm
Cylinder Warp		0.05mm
Piston ring free end gap	1st & 2nd: approx. 4.0mm	3.2mm
Piston ring End Gap	0.10-0.30mm	0.75mm
Piston ring--Grove Clearance	1st & 2nd: 0.01-0.05mm	---
ITEM	STANDARD	LIMIT
Piston Pin Bore I.D.	12.002-12.010mm	12.030mm
Piston Pin O.D.	11.996-12.000mm	11.980mm
CRANKSHAFT		
Con-rod Small End Hole	16.003-16.011mm	16.040mm
Big End Side Clearance		
Con-rod Big End Wear	---	0.05mm
Crankshaft Runout		
Crankshaft Web to Web width	40 + 0.1mm	---
OIL PUMP		
Oil Pressure		
Tip Clearance		
Outer Rotor Clearance		
Side Clearance		
Oil Pump Reduction Ratio		
CCI Pump Discharge Rate		
CLUTCH		
Drive Plate Thickness	2.9-3.1mm	2.6mm
Drive Plate Warp		
Driven Plate Thickness	1.6 + 0.1mm	---
Driven Plate Warp		
Drive Plate Claw Width	11.8 - 12.0mm	0.1mm
Clutch Spring Free Length	---	11.3mm
Pri. Drive--Driven Gear Backlash	---	33.6mm
TRANSMISSION		
Primary Reduction	3.842 (73/19)	---
Final Reduction	3.500 (42/12)	---
Gear Ratios, Low/2nd	2.571 (36/14)	1.888 (34/18)
3rd/4th	1.500 (30/20)	1.250 (25/20)
5th/Top	1.083 (26/24)	0.961 (25/26)
Gear Backlash 1st/2nd		
3rd/4th		
5th/6th		
Shift Fork--Grove Clearance	0.10-0.30mm	0.50mm
Shift Fork Groove Width	4.45-4.55mm	---
Shift Fork Thickness	4.25-4.35mm	---
Drive Chain Size	DID 420W 92 links	
21 Pin Length	---	259mm

I T E M		S T A N D A R D		L I M I T		I T E M		S T A N D A R D		L I M I T	
CARBURETOR						Headlight (Low/High)					
Idle RPM						Instrument Bulbs (Speedo/ Tach/Hi Beam/Turn Signal Oil Pressure					
Carburetor Type		Mikuni VM20SS				Tail light/Stop light					
I.D. No.		46630				Turn Signal Bulbs					
Bore Size		20mm				CHASSIS					
Float Height		21 + 1.0mm				Axle Runout (Front/Rear)				0.25mm	
Fuel Level						Brake Drum I.D.				110.7mm	
Air Screw		2.0								110.7mm	
Pilot Screw						Brake Lining Thickness				1.5mm	
Pilot Air Jet										1.5mm	
Pilot Jet		#17.5				Brake Disc Thickness (Front & Rear)					
Cut Away		2.0				Master Cylinder Cylinder Bore					
Jet Needle		4J29-3				Master Cylinder Piston Diameter					
Needle Jet		P-0				Brake Caliper Cylinder Bore					
Secondary Air Jet						Brake Caliper Piston Dia.					
Pilot Outlet		0.6				Wheel Rim Runout (Radial & Axial)				2.0mm	
Main Jet		#115				Tire Size				Front: 2.50 x 14 4PR Rear: 3.00 x 12 4PR	
ELECTRICAL						Tire Tread Depth				Front: 4.0mm Rear: 4.0mm	
Ignition		SUZUKI "PEI"				Tire Pressure				FRONT SOLO DUAL SOLO DUAL 10-14 psi 10-14 psi 10-14 psi	
Ignition Timing		16° + 2° @ 10,000 rpm				Normal Riding					
Firing Order						Continuous High					
Spark Plug		NGK B8HS, ND 424FS				Speed Riding					
Spark Plug Gap		0.6 - 0.8mm				Fork Spring Free Length				422mm	
Contact Point Gap						Swinging Arm Pivot Shaft Runout				0.6mm	
Dwell Angle						FUEL & OILS					
Spark Performance		over 8mm				Fuel Type				Premium	
Condensor Capacity						Engine Oil Type				SUZUKI CCI Super 2	
Ignition Coil Resistance (pri.)		B/V - Ground				Engine Oil Capacity					
Ignition Coil Resistance (sec.)		approx. 0.5-1.5 ohms Plug Cap - Ground approx. 5-7 ohms				Transmission Oil Type/Cap				chg 700ml/ovhl 750ml	
Magnetto Coil Resistance		B/R - B/W approx. 400-450 ohms				Front Fork Air Pressure					
High Speed Coil Resistance						Fork Oil Type/Cap./Level				SAE 5W-20 or ATF 72ml/146mm	
Low Speed Coil Resistance						Battery					
Exciter Coil Resistance						Specific Gravity					
Pulser Coil Resistance						Regulated Amperage					
Charging Coil Resistance						Regulated Voltage					
Lighting Coil Output						Fuse Capacity					



TWO STROKE

SUZUKI

TWO STROKE

Service Bulletin

Bulletin No.: SPECS-17H

Date: 6/5/81

Read and Initial

Manager _____

Parts Mgr. _____

Service Mgr. _____

Mechanics _____

MODEL: RM100X

SUBJECT: SPECIFICATIONS

ITEM	STANDARD	LIMIT
VALVE SPECS		
Valve Lift	IN: EX:	
Tappet Clearance or Valve Clearance	IN: EX:	
Valve Guide--Valve Stem Clearance	IN: EX:	
Valve Guide I.D. (IN/EX)		
Valve Stem O.D.		
Valve Stem Deflection (IN & EX)		
Valve Head Thickness (IN & EX)		
Valve Seat Width (IN/EX)		
Valve Head Radial Runout (IN & EX)		
Valve Spring Free Length	INN: OUT:	
Valve Spring Tension	INN: OUT:	
Rocker Arm I.D. (IN & EX)		
Rocker Arm Shaft O.D. (IN & EX)		
CAMSHAFT		
Cam Height	IN: EX:	
Camshaft--Journal Clearance (IN & EX)		
Camshaft Journal I.D. (IN & EX)		
Camshaft Journal O.D. (IN & EX)		
Camshaft Deflection (IN & EX)		
Cam Chain 20 Pitch Length		
PISTON/RING/CYLINDER		
Compression Pressure		
Max. Difference Between Cylinders		
Piston--Cylinder Clearance	0.060-0.070mm	0.120mm
Cylinder Bore	50.000-50.015mm	50.070mm
Piston Dia./Measuring Point	49.935-49.950mm @ 18mm	49.880mm
Cylinder Warp	---	0.05mm
Piston ring free end gap	1st & 2nd: approx. 4.0mm	3.2mm
Piston ring End Gap	0.15-0.35mm	0.80mm
Piston ring--Grove Clearance	1st & 2nd: 0.010-0.050mm	---
ITEM	STANDARD	LIMIT
Piston Pin Bore I.D.	14.002-14.010mm	14.030mm
Piston Pin O.D.	13.995-14.000mm	13.980mm
CRANKSHAFT		
Con-rod Small End Hole	18.003-18.011mm	18.040mm
Big End Side Clearance		
Con-rod Big End Wear	---	0.05mm
Crankshaft Runout		
Crankshaft Web to Web Width	52 ± 0.1mm	---
OIL PUMP		
Oil Pressure		
Tip Clearance		
Outer Rotor Clearance		
Side Clearance		
Oil Pump Reduction Ratio		
CCI Pump Discharge Rate		
CLUTCH		
Drive Plate Thickness	2.9-3.1mm	2.6mm
Drive Plate Warp		
Driven Plate Thickness	1.6 ± 0.1mm	---
Driven Plate Warp		
Drive Plate Claw Width	11.8 - 12.0mm	0.1mm
Clutch Spring Free Length	---	11.3mm
Pri. Drive--Driven Gear Backlash	---	31.7mm
TRANSMISSION		
Primary Reduction	3.444 (62/18)	---
Final Reduction	4.615 (60/13)	---
Gear Ratios, Low/2nd	2.333 (28/12)	1.750 (28/16)
3rd/4th	1.411 (24/17)	1.190 (25/21)
5th/Top	1.045 (23/22)	0.956 (22/23)
Gear Backlash 1st/2nd		
3rd/4th		
5th/6th		
Shift Fork--Grove Clearance	#1 and #2 0.05-0.25mm	0.45mm
Shift Fork Groove Width	#1 4.45-4.55mm	---
Shift Fork Thickness	#2 5.45-5.55mm	---
Drive Chain Size	#1 4.3-4.4mm	---
21 Pin Length	#2 5.3-5.4mm	---
	D10428DSM, Takasago 428FD	132 links
	---	259mm

