



SUZUKI

TWO STROKE

Service Bulletin

Bulletin No.: SPECS-17J

Date: 6/5/81

Read and Initial

Manager _____

Parts Mgr. _____

Service Mgr. _____

Mechanics _____

MODEL: RM250X

SUBJECT: SPECIFICATIONS

ITEM	STANDARD	LIMIT
VALVE SPECS		
Valve Lift	IN: EX:	
Tappet Clearance or Valve Clearance	IN: EX:	
Valve Guide--Valve Stem	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/CYLINDER		
Compression Pressure		
Max. Difference Between Cylinders		
Piston--Cylinder Clearance	67.060-0.070mm	0.120mm
Cylinder Bore	67.000-67.015mm	67.070mm
Piston Dia./Measuring Point	66.935-66.950mm @ 23mm	66.880mm
Cylinder Warp		
Piston ring free end gap	1st approx R 6.5mm	0.05
Piston ring End Gap	0.20-0.40mm	6.0mm
Piston ring--Grove Clearance	0.010-0.050mm	0.85mm

ITEM	STANDARD	LIMIT
Piston Pin Bore I.D.	18.002-18.010mm	18.030mm
Piston Pin O.D.	17.995-18.000mm	17.980mm
CRANKSHAFT		
Con-rod Small End Hole	22.003-22.011mm	22.060mm
Big End Side Clearance		
Con-rod Big End Wear		
Crankshaft Runout	---	0.05mm
Crankshaft Web to Web Width	58.0 + 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	2.0 + 0.1mm	---
Driven Plate Warp		
Drive Plate Claw Width	15.8 16.0mm	15.9mm
Clutch Spring Free Length		
Pri. Drive--Driven Gear Backlash		38.6mm
TRANSMISSION		
Primary Reduction	2.727 (60/22)	
Final Reduction	3.571 (50/14)	
Gear Ratios, Low/2nd	2.076(27/13), 1.750(28/16)	
3rd/4th	1.352(23/17), 1.105(21/19)	
5th/Top	0.913 (21/23)	
Gear Backlash 1st/2nd		
3rd/4th		
5th/6th		
Shift Fork--Grove Clearance	#1 0.40-0.60mm	0.80mm
ance	#2,3 0.20-0.40mm	0.60mm
Shift Fork Groove Width	#1 4.45-4.55mm	
	#2,3 4.25-4.35mm	
Shift Fork Thickness	#1,2,3 3.95-4.05mm	---
Drive Chain Size	DID520TR, or Takasago RK520SM	318mm
21 Pin Length		

I T E M		S T A N D A R D		L I M I T	
C A R B U R E T O R		S T A N D A R D		L I M I T	
Idle RPM					
Carburetor Type		Mikuni VM38SS			
I.D. No.		14200			
Bore Size		38mm			
Float Height		10.7 ± 0.5mm			
Fuel Level		1½			
Air Screw					
Pilot Screw		#50			
Pilot Air Jet		2.0			
Pilot Jet		6FJ37-3			
Cut Away		R-8			
Needle Jet					
Secondary Air Jet		0.6			
Pilot Outlet		#320			
Main Jet					
ELECTRICAL					
Ignition		SUZUKI PEI			
Ignition Timing		8° + 2° BTDC @ 8,500rpm			
Firing Order					
Spark Plug		NGK B9EGV/Champion N-2G			
Spark Plug Gap		0.5-0.6mm			
Contact Point Gap					
Dwell Angle					
Spark Performance		over 8mm			
Condensor Capacity					
Ignition Coil Resistance (Pri.)		approx B-W/B1 0-1 ohm			
Ignition Coil Resistance (Sec.)		approx Plug Cap - B 12-14 ohms			
Pri. Ignition Coil Resistance					
Magnet Coil Resistance		B-B/R approx 350-450 ohms			
Exciter Coil Resistance		B/R-B/W approx 25-35 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: ---	
Brake Lining Thickness				Front: --- Rear: ---	
Brake Disc Thickness (Front & Rear)				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)				Front: 3.00-21 4PR Rear: 5.10-18 4PR	
Tire Size				Front: --- Rear: ---	
Tire Tread Depth				Front: --- Rear: ---	
Tire Pressure				SOLO FRONT DUAL SOLO REAR DUAL 10-16psi 10-16psi	
Normal Riding					
Continuous High					
Speed Riding					
Fork Spring Free Length				---	
Swinging Arm Pivot Shaft Runout				---	
FUEL & OILS					
Fuel Type		Premium			
Engine Oil Type		Suzuki CCI Super 2			
Engine Oil Capacity					
Transmission Oil Type/Cap		SAE 20W-40/chg 800ml/ovhl 850ml			
Front Fork Air Pressure					
Fork Oil Type/Cap./Level		SAE 5W-20 or ATF 430ml/167mm			
Rear Shock Air Pressure		142 psi			
Rear Shock Spring Pre-Set Length		280mm			



SUZUKI

TWO STROKE

Service Bulletin

Bulletin No.: SPECS-17K
 Date: 6/5/81
 Read and Initial
 Manager _____
 Parts Mgr. _____
 Service Mgr. _____
 Mechanics _____

MODEL: RM465X

SUBJECT: SPECIFICATIONS

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 VM38SS		Tail light/Stop light		
I.D. No.	14210		Turn Signal Bulbs		
Bore Size	38mm		CHASSIS		
Float Height	10.7 ± 0.5		Axle Runout (Front/Rear)		0.25mm
Fuel Level			Brake Drum I.D.	Front: Rear:	150.7mm 130.7mm
Air Screw	1 1/2		Brake Lining Thickness	Front: Rear:	1.5mm 1.5mm
Pilot Screw			Brake Disc Thickness (Front & Rear)		
Pilot Air Jet	#50		Master Cylinder Cylinder Bore	Front: Rear:	
Pilot Jet	2.0		Master Cylinder Piston Diameter	Front: Rear:	
Cut Away	6F37-3		Brake Caliper Cylinder Bore	Front: Rear:	
Jet Needle	R-8		Brake Caliper Piston Dia.	Front: Rear:	
Needle Jet	0.6		Wheel Rim Runout (Radial & Axial)		2.0mm
Secondary Air Jet	#310		Tire Size	Front: 3.00-21 4PR Rear: 5.10-18 4PR	-- --
Pilot Outlet			Tire Tread Depth	Front: --- Rear: ---	4.0mm 4.0mm
Main Jet			Tire Pressure	FRONT DUAL SOLO SOLO DUAL SOLO	10-16 psi 10-16 psi
ELECTRICAL			Normal Riding Continuous High Speed Riding		
Ignition	SUZUKI "PEI"		Fork Spring Free Length	---	482mm
Ignition Timing	15° ± 2° BTDC @ 6,000rpm		Swinging Arm Pivot Shaft Runout	---	0.3mm
Firing Order			FUEL & OILS		
Spark Plug	NGK B8EGV		Fuel Type	premium	
Spark Plug Gap	0.5-0.6mm		Engine Oil Type	SUZUKI CCI Super 2	
Contact Point Gap			Engine Oil Capacity		
Dwell Angle	over 8mm		Transmission Oil Type/Cap	SAE 20W/40 chg 1000ml/ovhl	1100ml
Spark Performance			Front Fork Air Pressure	0 psi	
Condensor Capacity			Fork Oil Type/Cap./Level	SAE 5W/20 or ATF 595ml/172mm	
Ignition Coil Resistance (Pri.)	approx W/B1-B/W 0-1 ohm		Rear Shock Air Pressure	142 psi	
Ignition Coil Resistance (Sec.)	approx Plug Cap-B/W or W/B1 10-11K ohms		Rear Shock Spring Pre-Set Length	280mm	
Pri. Ignition Coil Resistance					
Magneto Coil Resistance	R/W-B/W approx 230-350 ohms B/R-B/W approx 370-560 ohms R/W-B/R approx 140-210 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	
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.	IN:				
	EX:				
Valve Stem Deflection (IN & EX)	IN:				
	EX:				
Valve Head Thickness (IN & EX)	IN:				
	EX:				
Valve Seat Width (IN/EX)	IN:				
	EX:				
Valve Head Radial Runout (IN & EX)	IN:				
	EX:				
Valve Spring Free Length	IN:				
	OUT:				
Valve Spring Tension	IN:				
	OUT:				
Rocker Arm I.D. (IN & EX)	IN:				
	EX:				
Rocker Arm Shaft O.D. (IN & EX)	IN:				
	EX:				
CAMSHAFT					
Cam Height	IN:				
	EX:				
Camshaft--Journal Clearance (IN & EX)	IN:				
	EX:				
Camshaft Journal I.D. (IN & EX)	IN:				
	EX:				
Camshaft Journal O.D. (IN & EX)	IN:				
	EX:				
Camshaft Deflection (IN & EX)	IN:				
	EX:				
Cam Chain 20 Pitch Length	IN:				
	EX:				
PISTON/RING/CLYINDER					
Compression Pressure	IN:				
	EX:				
Max. Difference Between Cylinders	IN:				
	EX:				
Piston--Cylinder Clearance	IN:				
	EX:				
Cylinder Bore	IN:				
	EX:				
Piston Dia./ Measuring Point	IN:				
	EX:				
Cylinder Warp	IN:				
	EX:				
Piston ring free end gap	IN:				
	EX:				
Piston ring End Gap	IN:				
	EX:				
Piston ring--Grove Clearance	IN:				
	EX:				
ITEM		S T A N D A R D		L I M I T	
Piston Pin Bore I.D.		18.002-18.010mm		18.030mm	
Piston Pin O.D.		17.995-18.000mm		17.980mm	
CRANKSHAFT					
Con-rod Small End Hole		23.003-23.011mm		23.040mm	
Big End Side Clearance					
Con-rod Big End Wear					
Crankshaft Runout		---		0.05	
Crankshaft Web to Web Width		70.0 + 0.1			
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		1.6mm + 0.06mm		---	
Driven Plate Warp		---		0.15mm	
Drive Plate Claw Width		16.0-16.2mm		15.5mm	
Clutch Spring Free Length		---		38.5mm	
Pri. Drive--Driven Gear Backlash					
TRANSMISSION					
Primary Reduction		2.384 (62/26)			
Final Reduction		3.500 (49/14)			
Gear Ratios, Low/2nd 3rd/4th 5th/Top		2.000(28/14)1.625(26/16)			
		1.263(24/19)1.000(21/21)			
		0.869 (20/23)			
Gear Backlash 1st/2nd 3rd/4th 5th/6th					
Shift Fork--Grove Clearance		#1, 3 0.20-0.40mm		0.60mm	
		#2 0.30-0.60mm		0.80mm	
		#1, 3 4.25-4.35mm #2, 4.45-5.55mm		---	
Shift Fork Groove Width		#1, 2, 3 3.95-4.05mm		---	
Shift Fork Thickness		DID 520TR, or Takasago TRK520SM		112 links	
Drive Chain Size					
21 Pin Length					



TWO STROKE

SUZUKI

TWO STROKE

Service Bulletin

Bulletin No.: SPECS-17L

Date: 6-12-81

Read and Initial

Manager _____

Parts Mgr. _____

Service Mgr. _____

Mechanics _____

MODEL: PE175X
SUBJECT: SPECIFICATIONS

VALVE SPECS	FAHDAKD	LIMIT	ITEM	STANDARD	LIMIT
Valve Lift	IN: EX:		Piston Pin Bore I.D.	16.002-16.010mm	16.030mm
Tappet Clearance or Valve Clearance	IN: EX:		Piston Pin O.D.	15.995-16.000mm	15.980mm
Valve Guide--Valve Stem Clearance	IN: EX:		CRANKSHAFT		
Valve Guide I.D. (IN/EX)			Con-rod Small End Hole	21.003-21.011mm	21.040mm
Valve Stem O.D.			Big End Side Clearance		
Valve Stem Deflection (IN & EX)			Con-rod Big End Wear		
Valve Head Thickness (IN & EX)			Crankshaft Runout	---	0.05mm
Valve Seat Width (IN/EX)			Crankshaft Web to Web Width	56 ± 0.1mm	---
Valve Head Radial Runout (IN & EX)			OIL PUMP		
Valve Spring Free Length	INN: OUT:		Oil Pressure		
Valve Spring Tension	INN: OUT:		Tip Clearance		
Rocker Arm I.D. (IN & EX)			Outer Rotor Clearance		
Rocker Arm Shaft O.D. (IN & EX)			Side Clearance		
CAMSHAFT			Oil Pump Reduction Ratio		
Cam Height	IN: EX:		CCI Pump Discharge Rate		
Camshaft--Journal Clearance (IN & EX)			CLUTCH		
Camshaft Journal I.D. (IN & EX)			Drive Plate Thickness	2.9-3.1mm	2.6mm
Camshaft Journal O.D. (IN & EX)			Drive Plate Warp		
Camshaft Deflection (IN & EX)			Driven Plate Thickness	1.6 ± 0.1mm	---
Cam Chain 20 Pitch Length			Driven Plate Warp		0.1mm
PISTON/RING/CYLINDER			Drive Plate Claw Width	11.8-12.0mm	11.0mm
Compression Pressure			Clutch Spring Free Length		32.6mm
Max. Difference Between Cylinders			Pri. Drive--Driven Gear Backlash		
Piston--Cylinder Clearance	0.060-0.070mm	0.120mm	TRANSMISSION		
Cylinder Bore	62.000-62.015mm	62.070mm	Primary Reduction	2.671 (58/21)	
Piston Dia./Measuring Point	61.935-61.950mm	61.880mm	Final Reduction	4.000 (48/12)	
Cylinder Warp	---	0.05mm	Gear Ratios, Low/2nd	3.090 (34/11)	2.214 (31/14)
Piston ring free end gap	1st & 2nd Approx. 4.5mm	3.6mm	3rd/4th	1.847 (28/17)	1.300 (26/20)
Piston ring End Gap	0.20-0.35mm @22mm	0.85mm	5th/Top	1.045 (23/22)	0.875 (21/24)
Piston ring--Grove Clearance	1st & 2nd 0.02-0.06mm	---	Gear Backlash 1st/2nd		
			3rd/4th		
			5th/6th		
			Shift Fork--Grove Clearance		
			Shift Fork Groove Width	1,2,3 0.05-0.25mm	0.45mm
			Shift Fork Thickness	1,2,3 4.45-4.55mm	---
			Drive Chain Size	1,2,3 4.30-4.40mm	---
			21 pin Length	DD 520UB 106 links	324mm

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									
Idle RPM									
Carburetor Type									
I.D. No.									
Bore Size									
Float Height									
Fuel Level									
Air Screw									
Pilot Screw									
Pilot Air Jet									
Pilot Jet									
Cut Away									
Jet Needle									
Needle Jet									
Secondary Air Jet									
Pilot Outlet									
Main Jet									
ELECTRICAL									
Ignition									
Ignition Timing									
Firing Order									
Spark Plug									
Spark Plug Gap									
Contact Point Gap									
Dwell Angle									
Spark Performance									
Condensor Capacity									
Ignition Coil Resistance (Pri.)									
Ignition Coil Resistance (Sec.)									
Pri. Ignition Coil Resistance									
High Speed Coil Resistance									
Low Speed Coil Resistance									
Exciter Coil Resistance									
Pulser Coil Resistance									
Charging Coil Resistance									
Lighting Coil Output									
Battery									
Specific Gravity									
Regulated Amperage									
Regulated Voltage									
Fuse Capacity									
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)									
Brake Drum I.D.									
Brake Lining Thickness									
Brake Disc Thickness (Front & Rear)									
Master Cylinder									
Master Cylinder Bore									
Master Cylinder									
Piston Diameter									
Brake Caliper Cylinder Bore									
Brake Caliper Piston Dia.									
Wheel Rim Runout (Radial & Axial)									
Tire Size									
Tire Tread Depth									
Tire Pressure									
Normal Riding									
Continuous High									
Speed Riding									
Fork Spring Free Length									
Swinging Arm Pivot Shaft Runout									
FUEL & OILS									
Fuel Type									
Engine Oil Type									
Engine Oil Capacity									
Transmission Oil Type/Cap									
Front Fork Air Pressure									
Fork Oil Type/Cap./Level									



SUZUKI

TWO STROKE

Service Bulletin

Bulletin No. **SPCS-17M**
 Date: **6-12-81**
 Read and Initial

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

MODEL: PE250X
 SUBJECT: SPECIFICATIONS

ITEM	STANDARD	LIMIT
VALVE SPECS		
Valve Lift	IN: EX:	18.030mm 17.980mm
Tappet Clearance or Valve Clearance	IN: EX:	
Valve Guide--Valve Stem Clearance	IN: EX:	
Valve Guide I.D. (IN/EX)		23.003-23.011mm
Valve Stem O.D.		23.040mm
Valve Stem Deflection (IN & EX)		0.05mm
Valve Head Thickness (IN & EX)		---
Valve Seat Width (IN/EX)		62.0 ± 0.1
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)		2.6mm
CAMSHAFT		
Cam Height	IN: EX:	---
Camshaft--Journal Clearance (IN & EX)		0.1mm
Camshaft Journal I.D. (IN & EX)		15.0mm
Camshaft Journal O.D. (IN & EX)		38.5mm
Camshaft Deflection (IN & EX)		
Cam Chain 20 Pitch Length		
PISTON/RING/CYLINDER		
Compression Pressure		
Max. Difference Between Cylinders		
Piston--Cylinder Clearance	0.60-0.70mm	0.6mm
Cylinder Bore	67.000-67.015mm	---
Piston Dia./Measuring Point	66.935-66.950mm @20mm	---
Cylinder Warp	---	---
Piston ring free end gap	Approx. 6.5mm	---
Piston ring End Gap	0.20-0.40mm	---
Piston ring--Grove Clearance	1st and 2nd 0.01-0.05mm	324mm

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)	15w/15w				
Idle RPM						Instrument Bulbs (Speedo/ Tach/Hi Beam/Turn Signal Oil Pressure)					
Carburetor Type		Mikuni VM36SS				Tail Light/Stop Light	5w/--				
I.D. No.		40620				Turn Signal Bulbs					
Bore Size		36mm				CHASSIS					
Float Height		10.7 ± 0.5				Axle Runout (Front/Rear)			0.25mm		
Fuel Level						Brake Drum I.D.			Front: 150.7mm		
Air Screw		1 1/4							Rear: 150.7mm		
Pilot Screw						Brake Lining Thickness			Front: 1.5mm		
Pilot Air Jet									Rear: 1.5mm		
Pilot Jet		#37.5				Brake Disc Thickness (Front & Rear)					
Cut Away		2.5				Master Cylinder Cylinder Bore					
Jet Needle		6DH20-2							Front: 2.0mm		
Needle Jet		Q-0				Master Cylinder Piston Diameter			Rear: ---		
Secondary Air Jet									Front: ---		
Pilot Outlet		0.6				Brake Caliper Cylinder Bore			Rear: ---		
Main Jet		#250							Front: ---		
ELECTRICAL						Brake Caliper Piston Dia.			Front: ---		
Ignition		Suzuki "PEI"							Rear: ---		
Ignition Timing		13.5° BTDC @6000rpm				Wheel Rim Runout (Radial & Axial)			2.0mm		
Firing Order		NGK 810KCV				Tire Size			Front: 3.00-21 4PR ---		
Spark Plug		CHAMPION N-596							Rear: 5.10-18 4PR ---		
Spark Plug Gap		0.5-0.6				Tire Tread Depth			Front: --- 4.0mm		
Contact Point Gap									Rear: --- 4.0mm		
Dwell Angle						Tire Pressure			SOLO FRONT DUAL SOLO REAR DUAL		
Spark Performance		Over 8mm				Normal Riding			SOLO 14psi		
Condensor Capacity						Continuous High			14psi		
Ignition Coil Resistance (Pri.)		B/W-W/B1 Approx. 0-1ohm				Speed Riding					
Ignition Coil Resistance (Sec.)		PlugCap-B/W or W/B1 Approx 10-11k ohm				Fork Spring Free Length			571mm		
Pri. Ignition Coil Resistance						Swinging Arm Pivot Shaft Runout			0.3mm		
High Speed Coil Resistance						FUEL & OILS					
Low Speed Coil Resistance						Fuel Type			Premium		
Exciter Coil Resistance		B/R-R/W Approx 30-40ohm				Engine Oil Type			Suzuki CCI Super 2		
Pulsar Coil Resistance		R/W-B/W Approx 215-270oh				Engine Oil Capacity					
Charging Coil Resistance		Y/R-B/W Approx. 1-2 ohm				Transmission Oil Type/Cap			SAE20W-40/chg800ml/evh/ 900ml		
Lighting Coil Output		Above 5.5 V at 2500rpm Below 8.0 V at 800rpm				Front Fork Air Pressure			8.5 psi		
Battery						Fork Oil Type/Cap./Level			SAE 5W-20 or ATF 308ml/180mm		
Specific Gravity											
Regulated Amperage											
Regulated Voltage											
Fuse Capacity											



SUZUKI

TWO STROKE

Service Bulletin

Bulletin No.: SPECS-17N
Date: 6-12-81

Read and Initial

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

MODEL: PE400X
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	85.000-85.015mm	85.070mm
Piston Dia./Measuring Point	84.935-84.950mm @26mm	84.880mm
Cylinder Warp		0.05mm
Piston ring free end gap	1st and 2nd approx 9.5mm	7.6mm
Piston ring End Gap	0.30-0.50mm	0.90mm
Piston ring--Grove Clearance	1st and 2nd 0.03-0.07	---
ITEM	STANDARD	LIMIT
Piston Pin Bore I.D.	20.002-20.010mm	20.030mm
Piston pin O.D.	19.995-19.998mm	19.980mm
CRANKSHAFT		
Con-rod Small End Hole	25.003-25.011mm	25.040mm
Big End Side Clearance		
Con-rod Big End Wear		
Crankshaft Runout	---	0.05mm
Crankshaft Web to Web Width	70.0+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	2.0-0.06mm	---
Driven Plate Warp		
Drive Plate Claw Width	15.8-16.0mm	0.1mm
Clutch Spring Free Length	---	15.0mm
Pri. Drive--Driven Gear Backlash		38.4mm
TRANSMISSION		
Primary Reduction	2.280 (57/25)	
Final Reduction	3.066 (46/15)	
Gear Ratios, Low/2nd	2.636 (29/11)	2.000 (26/13)
3rd/4th	1.562 (25/16)	1.222 (22/18)
5th/top	1.000 (20/20)	
Gear Backlash 1st/2nd		
3rd/4th		
5th/6th		
Shift Fork--Grove Clearance	1.3, 3 0.2-0.4mm	0.6mm
Shift Fork Groove Width	1.3 4.2-5.3mm	---
Shift Fork Thickness	1.3 2.85-3.03	---
Drive Chain Size	DID 520 UB or Takasago RK520SU	108 links
21 Pin Length	---	323mm



SUZUKI

TWO STROKE

Service Bulletin

Bulletin No.: SPECS-170
Date: 6-12-81
Read and Initial

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

MODEL: RS175X
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	0.06-0.07mm	0.120mm
Cylinder Bore	52.000-62.015mm	62.070mm
Piston Dia./Measuring Point	51.935-61.950mm@26mm	61.880mm
Cylinder Warp	---	0.05mm
Piston ring free end gap	Approx. 6.5mm	5.2mm
Piston ring End Gap	0.20-0.35mm	0.85mm
Piston ring--Grove Clearance	0.02-0.06mm	---
ITEM	STANDARD	LIMIT
Piston Pin Bore I.D.	15.998-16.006mm	16.030mm
Piston Pin O.D.	15.995-16.000mm	15.980mm
CRANKSHAFT		
Con-rod Small End Hole	21.003-21.011mm	21.040mm
Big End Side Clearance		
Con-rod Big End Wear	---	0.05mm
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	2.0-3.1mm	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 (36/11) 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		324mm

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)		6V 15w/15w			
Idle RPM		1500 + 150 RPM		Instrument Bulbs (Speedo/ Tach/Hi Beam/Turn Signal Oil Pressure)					
Carburetor Type		MIKUNI VM3055		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 1/4		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:			
Cut Away		2.5		Master Cylinder Piston Diameter		Front: Rear:			
Jet Needle		5DP74-2		Brake Caliper Cylinder Bore		Front: Rear:			
Needle Jet		R-4		Brake Caliper Piston Dia.		Front: Rear:			
Secondary Air Jet		2.5		Wheel Rim Runout (Radial & Axial)		---		2.0mm	
Pilot Outlet		0.8		Tire Size		Front: 1.00-21 4PR Rear: 4.10-18 4PR		---	
Main Jet		#150		Tire Tread Depth		Front: Rear:		4mm 4mm	
ELECTRICAL				Tire Pressure		FRONT DUAL SOLO SOLO 14PSI 14PSI			
Ignition		SUZUKI "PEI"		Normal Riding					
Ignition Timing		17.5° + 2° BTDC@8000RPM		Continuous High					
Firing Order		NGK 89ES OR MD W27ES		Speed Riding					
Spark Plug		0.6-0.8mm		Fork Spring Free Length		---		571mm	
Spark Plug Gap				Swinging Arm Pivot Shaft Runout		---		0.3mm	
Contact Point Gap				FUEL & OILS					
Dwell Angle				Fuel Type		Premium			
Spark Performance		Over 8mm		Engine Oil Type		Suzuki CCI Super 2			
Condensor Capacity				Engine Oil Capacity					
Ignition Coil Resistance (Pri.)		B/W to W/B1 Approx. 0-1ohm		Transmission Oil Type/Cap		SAE 20W/40 Change: 800 ml Overhaul: 900ml			
Ignition Coil Resistance (Sec.)		Plug Cap to B/W or W/B1 approx 10-11k ohms		Front Fork Air Pressure					
MAGNETO COIL RESISTANCE		R/W-B/W Approx. 180-240 ohms R/W-B/R Approx. 20-30 ohms Y/R-B/W Approx. 0-1 ohm		Fork Oil Type/Cap./Level		High Quality SAE #10 Fork Oil 248 ml /240mm			
Exciter Coil Resistance									
Pulser Coil Resistance									
Charging Coil Resistance									
Lighting coil Output		Over 5.5V @2500 RPM Under 8.0V @8000 RPM							
Battery									
Specific Gravity									
Regulated Amperage									
Regulated Voltage									
Fuse Capacity									



SUZUKI

TWO STROKE

Service Bulletin

Bulletin No.: SPECS-17P
 Date: 6-12-81
 Read and Initial
 Manager _____
 Parts Mgr. _____
 Service Mgr. _____
 Mechanics _____

MODEL: RS250X
 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	0.060-0.070mm	0.120mm
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
Big End Side Clearance		
Con-rod Big End Wear		0.05mm
Crankshaft Runout		
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 ± 0.6mm	---
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	2.72(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	D.I.D. 520UB 110 Links	
21 Pin Length		324mm

I T E M	S T A N D A R D	L I M I T
CARBURETOR		
Idle RPM	1500 $\pm$ 150 RPM	
Carburetor Type	MIKUNI UM36SS	
I.D. No.	40610	
Bore Size	36mm	
Float Height	10.7 $\pm$ 0.5mm	
Fuel Level		
Air Screw	1 1/2	
Pilot Screw		
Pilot Air Jet		
Pilot Jet	#37.5	
Cut Away	2.0	
Jet Needle	6DH20-2	
Needle Jet	P-8	
Secondary Air Jet	2.5	
Pilot Outlet	0.6	
Main Jet	#260	
ELECTRICAL		
Ignition	SUZUKI "PEI"	
Ignition Timing	13° $\pm$ 2° BTDC @6000RPM	
Firing Order		
Spark Plug	NGK B9ES OR ND W27ES	
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. 0-1ohm	
Ignition Coil Resistance (Sec.)	PlugCap-B/W or W/B1 approx 10-11k ohms	
MAGNETO COIL RESISTANCE	B/R-B/N Approx. 195-245ohm	
	R/W-B/R Approx. 35-45ohm	
	Y/R-B/W Approx. 0-2 ohm	
Exciter Coil Resistance		
Pulser Coil Resistance		
Charging Coil Resistance		
Lighting Coil Output	Over 5.5V @3500 RPM Under 8.0V @8000 RPM	
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)	6V 15w/15w	
Instrument Bulbs (Speedo/Tach/Hi Beam/Turn Signal Oil Pressure)		
Tail Light/Stop light	6V5W/---	
Turn Signal Bulbs		
CHASSIS		
Axle Runout (Front/Rear)	---	0.25mm
Brake Drum I.D.	Front: --- Rear: ---	130.7mm 150.7mm
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: 3.00-21 4 PR Rear: 5.10-18 4 PR	---
Tire Tread Depth	Front: --- Rear: ---	4.0mm 4.0mm
Tire Pressure	FRONT DUAL SOLO 14 PSI	REAR DUAL SOLO 14 PSI
Normal Riding		
Continuous High Speed Riding		
Fork Spring Free Length	---	571mm
Swinging Arm Pivot Shaft Runout	---	0.3mm
FUEL & OILS		
Fuel Type	Premium	
Engine Oil Type	Suzuki CCI Super 2	
Engine Oil Capacity		
Transmission Oil Type/Cap	SAE20W/40, chg. 800ml	
Front Fork Air Pressure		
Fork Oil Type/Cap./Level	HIGH QUALITY SAE #10 248ml/220mm	



SUZUKI

TWO STROKE

Service Bulletin

Bulletin # SPECS-17Q

Date: 6-19-81

Read and Initial

Manager _____

Parts Mgr. _____

Service Mgr. _____

Mechanics _____

MODEL: DS80X

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/CLYINDER		
Compression Pressure		
Max. Difference Between Cylinders		
Piston--Cylinder Clearance	0.040-0.050mm	0.120mm
Cylinder Bore	49.000-49.015mm	49.090mm
Piston Dia./Measuring Point	48.955-48.970mm ϕ 18mm	48.880mm
Cylinder Warp	---	0.05mm
Piston ring free end gap	APPROX. 4.5mm	3.6mm
Piston ring End Gap	0.15-0.35mm	0.80mm
Piston ring--Grove Clearance	0.01-0.05mm	---
ITEM	STANDARD	LIMIT
Piston Pin Bore I.D.	11.998-12.006mm	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	---	0.05mm
Crankshaft Runout	---	---
Crankshaft Web to Web Width	40.0 $\pm$ 0.1mm	---
OIL PUMP		
Oil Pressure		
Tip Clearance		
Outer Rotor Clearance		
Side Clearance		
Oil Pump Reduction Ratio	6.461 (73/19 x 37/22)	
CCI Pump Discharge Rate	0.65-0.79ml for 2 min. @2000 RPM	
CLUTCH		
Drive Plate Thickness	2.9-3.1mm	2.6mm
Drive Plate Warp		
Driven Plate Thickness	1.6 $\pm$ 0.06mm	---
Driven Plate Warp	---	0.1mm
Drive Plate Claw Width	11.8-12.0mm	11.3mm
Clutch Spring Free Length	---	33.7mm
Pri. Drive--Driven Gear Backlash		
TRANSMISSION		
Primary Reduction	3.842 (73/19)	
Final Reduction	2.333 (34/12)	
Gear Ratios, Low/2nd 3rd/4th 5th/Top	2.333(35/15)1.684(32/19) 1.318(29/22)1.083(26/24) 0.923 (24/26)	
Gear Backlash 1st/2nd 3rd/4th 5th/6th		
Shift Fork--Grove Clearance	0.10-0.30mm	0.60mm
Shift Fork Groove Width	4.45-4.55mm	---
Shift Fork Thickness	4.25-4.35mm	---
Drive Chain Size	DID428 or TAKASAGO RK428B	88 link
21 Pin Length	---	259mm

ITEM	STANDARD	LIMIT
CARBURETOR		
Idle RPM	1300 + 150mm	
Carburetor Type	MIKUNI UM20SS	
I.D. No.	46410	
Bore Size	20mm	
Float Height	26.0 + 1.0mm	
Fuel Level	1 1/8	
Air Screw		
Pilot Screw		
Pilot Air Jet		
Pilot Jet	#22.5	
Cut Away	1.5	
Jet Needle	4F22-4	
Needle Jet	0-4	
Secondary Air Jet		
Pilot Outlet	0.6	
Main Jet	#65	
ELECTRICAL		
Ignition	MAGNETO	
Ignition Timing	23° + 2° BTDC @4000RPM	
Firing Order		
Spark Plug	NGK B7ES or ND W22ES	
Spark Plug Gap	0.6-0.8mm	
Contact Point Gap		
Dwell Angle		
Spark Performance	Over 8mm	
Condensor Capacity	0.18 + 0.02 μ F	
Ignition Coil Resistance (Pri.)	B/Y-Ground Approx. 0-1	
Ignition Coil Resistance (Sec.)	PlugCap-Ground Approx. 15-20	
Pri. Ignition Coil Resistance	B/Y-Ground Approx. 2-3 ohms	
Magneto Coil Resistance	Y/R-Ground Approx. 0-1 ohm	
Exciter Coil Resistance		
Pulser Coil Resistance		
Charging Coil Resistance		
Lighting Coil Output	Above 6V at 2500 RPM Below 9V at 8000 RPM	
Battery		
Specific Gravity		
Regulated Amperage		
Regulated Voltage		
Fuse Capacity		



SUZUKI

TWO STROKE

Service Bulletin

Bulletin No.: SPECS-17R

Date: 6-19-81

Read and Initial

Manager _____

Parts Mgr. _____

Service Mgr. _____

Mechanics _____

MODEL: DS100X

SUBJECT: SPECIFICATIONS

ITEM	STANDARD	LIMIT
VALVE SPECS		
Valve Life	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	0.040-0.050mm	0.120mm
Cylinder Bore	50.000-50.015	50.090mm
Piston Dia./Measuring Point	49.955-49.970mm @23mm	49.880mm
Cylinder Warp	---	0.05mm
Piston ring free end gap 1st & 2nd "N"	approx 4.5mm	3.6mm
Piston ring End Gap 1st & 2nd "N"	approx 5.0mm	4.0mm
Piston ring--Grove Clearance	0.15-0.35mm	0.80mm
	0.02-0.06mm	---

ITEM	STANDARD	LIMIT
Piston Pin Bore I.D.	13.998-14.006mm	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		
Crankshaft Runout	---	0.05mm
Crankshaft Web to Web Width	56.0 ± 0.1mm	---
OIL PUMP		
Oil Pressure		
Tip Clearance		
Outer Rotor Clearance		
Side Clearance		
Oil Pump Reduction Ratio	3.562 (57/16 x 29/17 x 17/29)	
CCI Pump Discharge Rate	1.28-1.58ml @2000rpm for 2 minutes	
CLUTCH		
Drive Plate Thickness	2.9-3.1mm	2.6mm
Drive Plate Warp		
Driven Plate Thickness	1.6 ± 0.06	---
Driven Plate Warp		
Drive Plate Claw Width	11.8-12.0mm	11.3mm
Clutch Spring Free Length	---	32.6mm
Pri. Drive--Driven Gear Backlash		
TRANSMISSION		
Primary Reduction	3.562 (57/16)	
Final Reduction	3.142 (44/14)	
Gear Ratios, Low/2nd 3rd/4th 5th/Top	1.090 (34/11) 2.000 (30/15) 1.368 (26/19) 1.095 (23/21) 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	#1:4.45-4.55mm #2:5.45-5.55mm	
Shift Fork Thickness	#1:4.30-4.40mm #2:5.30-5.40mm	
Drive Chain Size	DID 428D 114 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)	6v 15w/15w	
Idle RPM	1300 $\pm$ 100rpm		Instrument Bulbs (Speedo/ Tach/Hi Beam/Turn Signal Oil Pressure)		
Carburetor Type	Mikuni VM24SH		Tail light/Stop light	6v 5w	
I.D. No.	4811		Turn Signal Bulbs		
Bore Size	24mm		CHASSIS		
Float Height	25.8 $\pm$ 1.0mm		Axle Runout (Front/Rear)	---	0.25mm
Fuel Level	5.0 $\pm$ 0.5mm		Brake Drum I.D.	Front: --- Rear: ---	130.7mm
Air Screw	1.0		Brake Lining Thickness	Front: --- Rear: ---	130.7mm 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	1.5		Brake Caliper Cylinder Bore	Front: Rear:	
Jet Needle	4DH7-2		Brake Caliper Piston Dia.	Front: Rear:	
Needle Jet	N-8		Wheel Rim Runout (Radial & Axial)	---	2.0mm
Secondary Air Jet			Tire Size	Front: 2.75-19 4PR Rear: 3.00-18 4PR	---
Pilot Outlet	1.4		Tire Tread Depth	Front: --- Rear: ---	4.0mm
Main Jet	#85		Tire Pressure	---	4.0mm
ELECTRICAL			Normal Riding	SOLO DUAL SOLO DUAL	
Ignition	SUZUKI "PEI"		Continuous High	14 psi	14 psi
Ignition Timing	20° $\pm$ 2° BTDC @6000rpm		Speed Riding	---	Upper: 28mm Lower: 28mm
Firing Order			Fork Spring Free Length	---	0.6mm
Spark Plug	NGK B8ES or ND W24ES		Swinging Arm Pivot Shaft Runout		
Spark Plug Gap	0.6-0.8mm		FUEL & OILS		
Contact Point Gap			Fuel Type	Low-lead or Unleaded	
Dwell Angle	over 8mm		Engine Oil Type	Suzuki OCL Super 2	
Spark Performance			Engine Oil Capacity	OCL Tank: 1.2L (1.3 qt)	
Condensor Capacity			Transmission Oil Type/Cap	SAE 20W-40/chg 800ml/ovrhl 850ml	
Ignition Coil Resistance (Pri.)	B/Y-Ground approx 650-800 ohms		Front Fork Air Pressure		
Ignition Coil Resistance (Sec.)	Plug Cap-Ground 15-17k ohms		Fork Oil Type/Cap./Level	SAE 20 or ATF/73ml/197mm	
Pri. Ignition Coil Resistance					
High Speed Coil Resistance					
Low Speed Coil Resistance					
Exciter Coil Resistance	B/Y - Ground 1.5-2 ohms				
Pulser Coil Resistance	R/W - Ground 25-30 ohms				
Lighting Coil Resistance	Y/R - Ground 0-1 ohm				
Lighting Coil Output	above 6v at 2500rpm below 8.5v at 800rpm				
Battery					
Specific Gravity					
Regulated Amperage					
Regulated Voltage					
Fuse Capacity					

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SUZUKI

TWO STROKE

Service Bulletin

Bulletin No.: SPECS-17S
Date: 6-19-81

Read and Initial

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

MODEL: DS125X
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	0.045-0.055mm	0.120mm
Cylinder Bore	56.000-56.015mm	56.085mm
Piston Dia./Measuring Point	55.950-55.965mm @23mm	56.880mm
Cylinder Warp	---	0.05mm
Piston ring free end gap	1,2 approx 7.5mm	6.0mm
Piston ring End Gap	0.15-0.35mm	0.80mm
Piston ring--Grove Clearance	1,2 0.01-0.05mm	---
ITEM	STANDARD	LIMIT
Piston Pin Bore I.D.	13.998-14.006mm	14.030mm
Piston Pin O.D.	13.995-14.000mm	13.980mm
CRANKSHAFT		
Con-rod Small End Hole	18.003-18.011	18.040
Big End Side Clearance		
Con-rod Big End Wear		
Crankshaft Runout	---	0.05mm
Crankshaft Web to Web Width	56.0 ± 0.1	---
OIL PUMP		
Oil Pressure		
Tip Clearance		
Outer Rotor Clearance		
Side Clearance		
Oil Pump Reduction Ratio	3.562 (57/16 x 29/17 x 17/29)	
CCI Pump Discharge Rate	1.28-1.58ml @ 2,000 rpm for 2 minutes	
CLUTCH		
Drive Plate Thickness	2.9-3.1mm	2.6mm
Drive Plate Warp		
Driven Plate Thickness	1.6 ± 0.06mm	---
Driven Plate Warp	---	0.1mm
Drive Plate Claw Width	11.8-12.0mm	11.3mm
Clutch Spring Free Length	---	32.6mm
Pri. Drive--Driven Gear Backlash		
TRANSMISSION		
Primary Reduction	3.562 (57/16)	
Final Reduction	2.933 (44/15)	
Gear Ratios, Low/2nd	3.090 (34/11)	2.000 (30/15)
3rd/4th	1.368 (26/19)	1.095 (23/21)
5th/Top	0.875 (21/24)	
Gear Backlash 1st/2nd		
3rd/4th		
5th/6th		
Shift Fork--Grove Clearance	1,2 0.05-0.25mm	0.45
Shift Fork Groove Width	1,4,45-4.55	2.5,45-5.55
Shift Fork Thickness	1,4,30-4.40	2.5,30-5.40
Drive Chain Size	DID 428D 114 links	---
21 Pin Length		259mm

ITEM	STANDARD	LIMIT
CARBURETOR		
Idle RPM	1300 $\pm$ 100rpm	
Carburetor Type	Mikuni VM24SH	
I.D. No.		
Bore Size	24mm	
Floate Height	25.8 $\pm$ 1.0	
Fuel Level	5.0 $\pm$ 0.5	
Air Screw	1	
Pilot Screw		
Pilot Air Jet		
Pilot Jet	#30	
Cut Away	1.5	
Jet Needle	4DH7-2	
Needle Jet	N-8	
Secondary Air Jet		
Pilot Outlet	1.4	
Main Jet	#85	
ELECTRICAL		
Ignition	SUZUKI "PEI"	
Ignition Timing	20° $\pm$ 2° BTDC @6000rpm	
Firing Order		
Spark Plug	NGK BBS Nippon DENSO WZ4ES	
Spark Plug Gap	0.6-0.8mm	
Contact Point Gap		
Dwell Angle		
Spark Performance	over 8mm	
Condensor Capacity		
Ignition Coil Resistance (Pri.)	B/Y-Ground approx 650-800 ohms	
Ignition Coil Resistance (Sec.)	Plug Cap-Ground approx 15-17k ohms	
Pri. Ignition Coil Resistance		
High Speed Coil Resistance		
Low Speed Coil Resistance		
Magneto Coil Resistance	B/Y - Ground approx 1.5-2 ohms R/W-Ground approx 25-30 ohms	
Lighting Coil Output	Y/R-Ground approx 0-1 ohm above 5.7v @2500rpm below 9v @8000rpm	
Battery		
Specific Gravity		
Regulated Amperage		
Regulated Voltage		
Fuse Capacity		