



SUZUKI

TWO STROKE

Service Bulletin

Bulletin No.: SPECS-17T
 Date: 6-19-81
 Read and Initial
 Manager _____
 Parts Mgr. _____
 Service Mgr. _____
 Mechanics _____

MODEL: TS100X
 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	0.040-0.050mm	0.120mm
Cylinder Bore	50.000-50.015mm	50.090mm
Piston Dia./Measuring Point	49.955-49.970mm @23mm	49.880mm
Cylinder Warp		0.05mm
Piston ring free end gap	N: Approx. 5.0mm T: Approx. 4.5mm	4.0mm, 3.6mm
Piston ring End Gap	0.15-0.35mm	0.80mm
Piston ring--Groove Clearance	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(57/16x29/17x17/29)	
CCI Pump Discharge Rate	1.28-1.38ml @2000rpm for 2 minutes	
CLUTCH		
Drive Plate Thickness	2.9-3.1mm	2.6mm
Drive Plate Warp		
Driven Plate Thickness	No.1: 1.6 ± 0.06mm No.2: 2.0 ± 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	3.285 (46/14)	
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--Groove Clearance	0.05-0.25mm	0.45mm
Shift Fork Groove Width	No.1: 4.45-4.55mm No.2: 5.45-5.55mm	
Shift Fork Thickness	No.1: 4.30-4.40mm No.2: 5.30-5.40mm	
Drive Chain Size	D10428D 116 link	
21 pin length	---	259mm

I T E M		S T A N D A R D		L I M I T	
CARBURETOR					
Idle RPM		1300 $\pm$ 100rpm			
Carburetor Type		Mikuni VM24SH			
I.D. No.		48160			
Bore Size		24mm			
Float Height		25.8 $\pm$ 1.0mm			
Fuel Level		5.0 $\pm$ 0.5mm			
Air Screw		PRE-SET			
Pilot Screw					
Pilot Air Jet					
Pilot Jet		#17.5			
Cut Away		2.0			
Jet Needle		5E20			
Needle Jet		0-6			
Secondary Air Jet					
Pilot Outlet		0.7			
Main Jet		#115			
ELECTRICAL					
Ignition		Suzuki "PE1"			
Ignition Timing		20° $\pm$ 2° BTDC @6000rpm			
Firing Order					
Spark Plug		NGK RBES or ND W24S			
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 650-800ohm			
Ignition Coil Resistance (Sec.)		PlugCap-Ground Approx. 15-17Kohm			
Pri. Ignition Coil Resistance					
Magnetto Coil Resistance					
		Y/R-Ground Approx. 0-1ohm			
		B/Y-Ground Approx. 1.5-2ohm			
		R/W-Ground Approx. 25-30ohm			
Charging Coil Resistance		Y/W-Ground Approx. 0-1ohm			
Lighting Coil Output		Above: 5.8V at 2500rpm Below: 8.7V at 8000rpm			
Battery		6N4B-2A			
Specific Gravity		1.26 @20°C			
Regulated Amperage					
Regulated Voltage		7.7-8.0V			
Fuse Capacity		(1) 10A			
I T E M		S T A N D A R D		L I M I T	
Headlight (Low/High)		6v30w/30w			
Instrument Bulbs (Speedo/Tach/Hi Beam/Turn Signal Oil Pressure)		6v3w/3w/1.7w/3w			
Tail light/Stop light		6v5/3w/25w			
Turn Signal Bulbs		6v17 $\frac{1}{2}$			
CHASSIS					
Axle Runout (Front/Rear)		---		0.25mm	
Brake Drum I.D.		Front: --- Rear: ---		130.7mm	
Brake Lining Thickness		Front: --- Rear: ---		130.7mm	
Brake Disc Thickness (Front & Rear)		Front: --- Rear: ---		1.5mm	
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: 2.75-19 4PR Rear: 3.00-18 4PR		2.0mm	
Tire Size		Front: --- Rear: ---		---	
Tire Tread Depth		Front: --- Rear: ---		4.0mm	
Tire Pressure		SOLO FRONT SOLO REAR			
Normal Riding					
Continuous High					
Speed Riding					
Fork Spring Free Length		---		517mm	
Swinging Arm Pivot Shaft Runout		---		0.6mm	
FUEL & OILS					
Fuel Type		Low-Lead or Unleaded			
Engine Oil Type		Suzuki CCI Super 2			
Engine Oil Capacity		CCI Tank 1.2L			
Transmission Oil Type/Cap		SAE20w/40/chg800ml/ovrhl 850ml			
Front Fork Air Pressure		High Quality SAE#10 or ATF			
Fork Oil Type/Cap./level		130ml/197mm			



SUZUKI

TWO STROKE

Service Bulletin

Bulletin No.: SPECS-17U

Date: 6-19-81

Read and Initial

Manager _____

Parts Mgr. _____

Service Mgr. _____

Mechanics _____

MODEL: TS125X

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	0.45-0.55mm	0.120mm
Cylinder Bore	56.000-56.015mm	56.085mm
Piston Dia./Measuring Point	55.950-55.965mm @ 23mm	55.880mm
Cylinder Warp		0.05mm
Piston ring free end gap	Approx. 7.5mm	6.0mm
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.	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	---	0.05
Crankshaft Runout	---	---
Crankshaft Web to Web Width	56.0 ± 0.1mm	---
OIL PUMP		
Oil Pressure		2.6mm
Tip Clearance		---
Outer Rotor Clearance		0.1mm
Side Clearance		11.3mm
Oil Pump Reduction Ratio	3.562(57/16x29/17x17/29)	32.6mm
CCI Pump Discharge Rate	1.28-1.58ml @ 2000rpm for 2 minutes	
CLUTCH		
Drive Plate Thickness	2.9-3.1mm	
Drive Plate Warp	No.1: 1.6 ± 0.06mm No.2: 2.0 ± 0.06mm	
Driven Plate Thickness	---	
Driven Plate Warp	---	
Drive Plate Claw Width	11.8-12.0mm	
Clutch Spring Free Length	---	
Pri. Drive--Driven Gear Backlash		
TRANSMISSION		
Primary Reduction	3.562 (57/16)	
Final Reduction	3.066 (46/15)	
Gear Ratios, Low/2nd	3.090(34/11) 2.000(30/15)	
3rd/4th	1.368(26/19) 1.095(23/21)	
5th/Top	0.956(22/23) 0.840(21/25)	
Gear Backlash 1st/2nd		
3rd/4th		
5th/6th		
Shift Fork--Grove Clearance	0.05-0.25mm	0.45mm
Shift Fork Groove Width	No.1: 4.45-4.55mm No.2: 5.45-5.55mm	
Shift Fork Thickness	No.1: 4.30-4.40mm No.2: 5.30-5.40mm	
Drive Chain Size	DID428D 116 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 30w/30w			
Idle RPM		1300 $\pm$ 100rpm				Instrument Bulbs (Speedo/ Tach/HI Beam/Turn Signal Oil Pressure)		6v 3w/3w/1.7w/3w			
Carburetor Type		Mikuni VM24SH				Tail light/Stop light		6v 5.3w/25w			
I.D. No.		48030				Turn Signal Bulbs		6v 17w			
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 130.7mm	
Air Screw		PRE-SET				Brake Lining Thickness		Front: --- Rear: ---		1.5mm 1.5mm	
Pilot Screw						Brake Disc Thickness (Front & Rear)					
Pilot Air Jet						Master Cylinder Cylinder Bore		Front: --- Rear: ---			
Pilot Jet		#17.5				Master Cylinder Piston Diameter		Front: --- Rear: ---			
Cut Away		2.0				Brake Calliper Cylinder Bore		Front: --- Rear: ---			
Jet Needle		5F41				Brake Calliper Piston Dia.		Front: --- Rear: ---			
Needle Jet		0-4				Wheel Rim Runout (Radial & Axial)		---		2.0mm	
Secondary Air Jet						Tire Size		Front: 2.75-21 4PR Rear: 4.10-18 4PR		---	
Pilot Outlet		0.7				Tire Tread Depth		Front: --- Rear: ---		4.0mm 4.0mm	
Main Jet		#120				Tire Pressure		SOLO FRONT DUAL SOLO REAR			
ELECTRICAL						Normal Riding		21psi		21psi	
Ignition		Suzuki "PEI"				Continuous High					
Ignition Timing		20° $\pm$ 2° BTDC @6000rpm				Speed Riding					
Firing Order						Fork Spring Free Length		---		539.5mm	
Spark Plug		NGK B8ES or ND W24ES				Swinging Arm Pivot Shaft Runout		---		0.6mm	
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 CCI Super 2			
Spark Performance						Engine Oil Capacity		CCI Tank 1.2L			
Condensor Capacity						Transmission Oil Type/Cap		SAE20w/40/chg700ml/ovrhl 750ml			
Ignition Coil Resistance (Pri.)		B/Y-Ground Approx. 650-800 ohms				Front Fork Air Pressure					
Ignition Coil Resistance (Sec.)		PlugCap-Ground Approx. 15-17kohm				Fork Oil Type/Cap./Level		High Quality SAE10 or ATF 177ml/175mm			
Pri. Ignition Coil Resistance											
Magnetto Coil Resistance											
		Y/R-Ground Approx. 0-1ohm									
		B/Y-Ground Approx. 1.5-2ohm									
		R/W-Ground Approx. 25-30ohm									
		Y/W-Ground Approx. 0-1ohm									
Charging Coil Resistance											
Lighting Coil Output											
Battery		6N4B-2A									
Specific Gravity		1.26 @20°C									
Regulated Amperage											
Regulated Voltage		7.7-8.0v									
Fuse Capacity		(1) 10a									



SUZUKI

TWO STROKE

Service Bulletin

Bulletin No.: SPECS-17V

Date: 6-19-81

Read and Initial

Manager _____

Parts Mgr. _____

Service Mgr. _____

Mechanics _____

MODEL: TS185X

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	0.050-0.060mm	0.120mm
Cylinder Bore	64.000-64.015mm	64.080mm
Piston Dia./Measuring Point	63.945-63.960mm @26mm	63.850mm
Cylinder Warp	---	0.05mm
Piston ring free end gap	Approx. 8.0mm	6.4mm
Piston ring End Gap	0.15-0.35mm	0.80mm
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		
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	5.529(61/19x29/18x31/29)	
CCI Pump Discharge Rate	1.27-1.55ml @2000rpm 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	3.210(61/19)	
Final Reduction	3.250(29/12)	
Gear Ratios, Low/2nd	2.750(31/12)	1.812(29/16)
3rd/4th	1.250(25/20)	1.000(23/23)
5th/Top	0.800(20/25)	
Gear Backlash 1st/2nd		
3rd/4th		
5th/6th		
Shift Fork--Grove Clearance	0.20-0.40mm	0.60mm
Shift Fork Groove Width	5.60-5.70mm	---
Shift Fork Thickness	5.30-5.40mm	---
Drive Chain Size	DID520K or TAKASAGO BX520	96 links
21 Pin Length	---	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)		6v30w/30w			
Idle RPM		1300 ± 100rpm				Instrument Bulbs (Speedo/ Tach/Hi Beam/Turn Signal Oil Pressure)		6v3w/32/1.7w/3w			
Carburetor Type		Mikuni VM29SS				Tail light/Stop light		6v5.3w/25w			
I.D. No.		29900				Turn signal Bulbs		6v17w			
Bore Size		29mm				CHASSIS					
Float Height		24.0 ± 1.0mm				Axle Runout (Front/Rear)				0.25mm	
Fuel Level		4.5 ± 0.5mm				Brake Drum I.D.		Front: 130.7mm Rear: 130.7mm			
Air Screw		PRE-SET				Brake Lining Thickness		Front: 1.5mm Rear: 1.5mm			
Pilot Screw						Brake Disc Thickness (Front & Rear)					
Pilot Air Jet		#27.5				Master Cylinder Cylinder Bore		Front: 30mm Rear: 30mm			
Pilot Jet		2.5				Master Cylinder Piston Diameter		Front: 30mm Rear: 30mm			
Cut Away		5DH55				Brake Caliper Cylinder Bore		Front: 30mm Rear: 30mm			
Jet Needle		0-9				Brake Caliper Piston Dia.		Front: 30mm Rear: 30mm			
Needle Jet		0.7				Wheel Rim Runout (Radial & Axial)		Front: 2.75-21 4PR Rear: 4.10-18 4PR		2.0mm	
Secondary Air Jet		#195				Tire Size		Front: 2.75-21 4PR Rear: 4.10-18 4PR		---	
Pilot Outlet						Tire Tread Depth		Front: --- Rear: ---		4.0mm	
Main Jet						Tire Pressure		Front: --- Rear: ---		4.0mm	
ELECTRICAL						Normal Riding		SOLO DUAL DUAL		25psi 25psi 28psi	
Ignition		Suzuki "PEI"				Continuous High					
Ignition Timing		21.5° ± BTDC @6000rpm				Speed Riding					
Firing Order		NGK BP7ES or ND W22EP				Fork Spring Free Length		---		473mm	
Spark Plug		0.6-0.8mm				Swinging Arm Pivot Shaft Runout		---		0.6mm	
Spark Plug Gap						FUEL & OILS					
Contact Point Gap		Over 8mm				Fuel Type		Low-Lead or Unleaded			
Dwell Angle						Engine Oil Type		Suzuki CCI Super 2			
Spark Performance						Engine Oil Capacity		CCI/Tank 1.2L			
Condensor Capacity						Transmission Oil Type/Cap		SAE20w/40/chg700ml/ovrhl 750ml			
Ignition Coil Resistance (Pri.)		B/W-B/L Approx. 0-1ohm				Front Fork Air Pressure					
Ignition Coil Resistance (Sec.)		PlugCap-Ground Approx. 20-21K ohm				Fork Oil Type/Cap./Level		High Quality SAE10 or ATF 166ml/167mm			
Magnetto Coil Resistance											
Charging Coil Resistance		R/W-B/R Approx. 30-40ohm									
Lighting Coil Output		R/W-B/W Approx. 160-240ohm									
Battery		Y/R-B/W Approx. 0-1ohm									
Specific Gravity		Y/W-B/W Approx. 1-2ohm									
Regulated Amperage		Above 5.5V at 2500rpm Below 5.0V at 8000rpm									
Regulated Voltage		6N4B-2A									
Fuse Capacity		1.26 @20°C									
		6.7-7.3v									
		(1) 15A									



SUZUKI

TWO STROKE

Service Bulletin

Bulletin No.: SPECS-17W
 Date: 6-19-81
 Read and Initial

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

MODEL: TS250X
 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	0.120
Cylinder Bore	70.000-70.015mm	70.070mm
Piston Dia./Measuring Point	69.935-69.950mm @26mm	69.880mm
Cylinder Warp	---	0.05mm
Piston ring free end gap	Approx. 7.5mm	6.0mm
Piston ring End Gap	0.2-0.4mm	0.85mm
Piston ring--Grove Clearance	0.03-0.07mm	---
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	60.0±0.1mm	---
OIL PUMP		
Oil Pressure		
Tip Clearance		
Outer Rotor Clearance		
Side Clearance		
Oil Pump Reduction Ratio	2.658 (67/21 x 27/18 x 15/27)	
CCI Pump Discharge Rate	1.58-1.87ml @ 2000rpm for 2 minutes	
CLUTCH		
Drive Plate Thickness	3.4-3.6mm	3.1mm
Drive Plate Warp		
Driven Plate Thickness	2.0 ± 0.06mm	---
Driven Plate Warp	---	0.1mm
Drive Plate Claw Width	15.8-16.0mm	15.3mm
Clutch Spring Free Length	---	36.5mm
Pri. Drive--Driven Gear Backlash		
TRANSMISSION		
Primary Reduction	3.190 (67/21)	
Final Reduction	2.666 (40/15)	
Gear Ratios, Low/2nd 3rd/4th 5th/top	1.277 (29/18) 1.888 (27/15)	
Gear Backlash 1st/2nd 3rd/4th 5th/6th	0.826 (19/23)	
Shift Fork--Grove Clearance	0.40-0.60mm	0.80mm
Shift Fork Groove Width	3.95-4.05mm	---
Shift Fork Thickness	3.45-3.55mm	---
Drive Chain Size	DID 525TR 100 links	
21 Pin Length		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)	6v 30w/30w	
Idle RPM	1300+ 100rpm		Instrument Bulbs (Speedo/ Tach/Hi Beam/Turn Signal Oil Pressure)	6v 3w/3w/1.7w/3w 6v 5.3w/25w	
Carburetor Type	Mikuni 29SS		Tail light/Stop light		
I.D. No.	30900		Turn Signal Bulbs	6v 17w	
Bore Size	29mm		CHASSIS		
Float Height	24-1.0 mm		Axle Runout (Front/Rear)		0.25mm
Fuel Level	4.5-0.5 mm		Brake Drum I.D.	Front: --- Rear: ---	150.7mm
Air Screw	PRE-SET		Brake Lining Thickness	Front: --- Rear: ---	150.7mm 1.5mm
Pilot Screw			Brake Disc Thickness (Front & Rear)		1.5mm
Pilot Air Jet	#25		Master Cylinder Cylinder Bore	Front: --- Rear: ---	
Pilot Jet	2.5		Master Cylinder Piston Diameter	Front: --- Rear: ---	
Cut Away	5DH55		Brake Caliper Cylinder Bore	Front: --- Rear: ---	
Jet Needle	0-7		Brake Caliper Piston Dia.	Front: --- Rear: ---	
Needle Jet	0.7		Wheel Rim Runout (Radial & Axial)	--- ---	2.0mm
Secondary Air Jet	0.7		Tire Size	Front: 3.00-21 4PR Rear: 4.60-18 4PR	---
Pilot Outlet	#200		Tire Tread Depth	Front: --- Rear: ---	4.0mm
Main Jet			Tire Pressure	FRONT SOLO DUAL REAR SOLO DUAL	4.0mm
ELECTRICAL			Normal Riding	21psi 21psi 25psi 28psi	
Ignition	SUZUKI "PEI"		Continuous High		
Ignition Timing	24°±2° BTDC @6000rpm		Speed Riding		
Firing Order	NGK BP7ES or ND W22EP		Fork Spring Free Length	---	487mm
Spark Plug	0.6-0.8mm		Swinging Arm Pivot Shaft Runout	---	0.6mm
Spark Plug Gap			FUEL & OILS		
Contact Point Gap			Fuel Type	Low-lead or Unleaded	
Dwell Angle	over 8mm		Engine Oil Type	Suzuki CCI Super 2	
Spark Performance			Engine Oil Capacity	CCI Tank: 1.2L	
Condensor Capacity			Transmission Oil Type/Cap	SAE 20w/40/chg 850ml/ovrhl 900ml	
Ignition Coil Resistance (Pri.)	B/W-B/W approx. 0-1 ohm		Front Fork Air Pressure		
Ignition Coil Resistance (Sec.)	Plug cap - Ground approx. 22-24k ohms		Fork Oil Type/Cap./Level	High Quality SAE 10 or ATF/242ml/177mm	
Magneto Coil Resistance	B-B/R approx 1-3 ohms B/R-B/W approx 130-165 ohms Y/R-B/W approx 0-1 ohm Y/W-B/W 0-1.5 ohms G-B/W 0-1 ohm				
Lighting Coil Output	Above 3.0v at 4380rpm below 9.0v at 8080rpm				
Battery	6N4B-2A				
Specific Gravity	1.26 @ 20°C				
Regulated Amperage					
Regulated Voltage	7.7-8.0v				
Fuse Capacity	(1) 15A				



SUZUKI

TWO STROKE

Service Bulletin

Bulletin No.: SPECS-8K

Date: 6/5/81

Read and Initial

Manager _____

Parts Mgr. _____

Service Mgr. _____

Mechanics _____

MODEL: GS550TX

SUBJECT: SPECIFICATIONS

ITEM	STANDARD	LIMIT
VALVE SPECS		
Valve Lift	IN: 7.2mm EX: 7.0mm	---
Tapet Clearance or Valve Clearance	IN: 0.03 - 0.08mm EX: 0.03 - 0.08mm	---
Valve Guide--Valve Stem Clearance	IN: 0.02 - 0.05mm EX: 0.03 - 0.06mm	0.35mm
Valve Guide I.D. (IN/EX)	7.000-7.015mm	---
Valve Stem O.D.	6.965-6.980mm	---
Valve Stem Deflection (IN & EX)	---	0.05
Valve Head Thickness (IN & EX)	---	0.5
Valve Seat Width (IN/EX)	0.9-1.1mm	---
Valve Head Radial Runout (IN & EX)	---	0.03
Valve Spring Free Length	INN: --- OUT: ---	33.9 41.3
Valve Spring Tension	INN: 8.9-12.5kg (19.6-27.6lbs) @ 31mm OUT: 22.1-27.1kg (48.7-59.7lb) @ 35mm	
Rocker Arm I.D. (IN & EX)		
Rocker Arm Shaft O.D. (IN & EX)		
CAMSHAFT		
Cam Height	IN: 35.485-35.515mm EX: 35.285-35.315mm	35.190mm 34.990mm
Camshaft--Journal Clearance (IN & EX)	0.020-0.054mm	0.150mm
Camshaft Journal I.D. (IN & EX)	22.000-22.013mm	---
Camshaft Journal O.D. (IN & EX)	21.959-21.980mm	---
Camshaft Deflection (IN & EX)	---	0.10
Cam Chain 20 Pitch Length	---	157.8mm
PISTON/RING/CYLINDER		
Compression Pressure	9.0-13.0kg/cm ² (128-185psi)	7.0kg/cm ² (100psi)
Max. Difference Between Cylinders	---	2kg/cm ² (28psi)
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 @ 15mm	55.880mm
Cylinder Warp	---	0.26mm
Piston ring free end gap	1st & 2nd Approx. 6.5mm	5.2mm
Piston ring End Gap	1st & 2nd 0.1-0.3mm	0.70mm 0.180mm
Piston ring--Grove Clearance		2nd: 0.150mm
STANDARD		
Piston Pin Bore I.D.	16.002-16.008mm	16.030mm
Piston Pin O.D.	15.995-16.000mm	15.980mm
CRANKSHAFT		
Con-rod Small End Hole	16.006-16.014mm	16.040mm
Big End Side Clearance	0.10-0.65mm	1.0mm
Con-rod Big End Wear	---	0.10mm
Crankshaft Runout	---	---
Crankshaft Web to Web Width	---	---
OIL PUMP		
Oil Pressure @ 60°C	Above 0.1kg/cm ² (1.42psi)	@ 3000 rpm
Tip Clearance	Below 0.5kg/cm ² (7.11psi)	0.20mm
Outer Rotor Clearance	---	0.25mm
Side Clearance	---	0.15mm
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 ± 0.06mm	---
Driven Plate Warp	---	0.1mm
Drive Plate Claw Width	11.8-12.0mm	11.0mm
Clutch Spring Free Length	---	36.5mm
Pri. Drive--Driven Gear Backlash	---	---
TRANSMISSION		
Primary Reduction	1.977 (87/44)	---
Final Reduction	3.333 (50/15)	---
Gear Ratios, Low/2nd	2.666 (32/12)	---
3rd/4th	1.777 (32/18)	---
5th/Top	1.380 (29/21)	---
1st/2nd	1.045 (23/22)	---
3rd/4th	---	---
5th/6th	---	---
Gear Backlash	0.1-0.3mm	0.5mm
Shift Fork--Grove Clearance	---	---
Shift Fork Groove Width	5.5-5.6mm	---
Shift Fork Thickness	5.3-5.4mm	---
Drive Chain Size	DID 50RDL TAKASAGO RK50SHO	110 Link
21 Pin Length	---	320.0mm

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)	12V-55W/60W	
Idle RPM	1100 ± 100rpm			Instrument Bulbs (Speedo/ Tach/Hi Beam/Turn Signal Oil Pressure)	12V 3.4w/3.4/3.4w/3.4w/3.4w 12V 8/23w	
Carburetor Type	Mikuni BS32SS			Tail Light/Stop Light		
I.D. No.	47070			Turn Signal Bulbs		
Bore Size	32mm			CHASSIS		
Float Height	22.4 ± 1.0mm			Axle Runout (Front/Rear)	---	0.25
Fuel Level	5.0 ± 1.0mm			Brake Drum I.D.	Front: --- Rear: ---	
Air Screw				Brake Lining Thickness	Front: --- Rear: ---	
Pilot Screw	PRE-SET			Brake Disc Thickness (Front & Rear)	Front: 6.0-0.2mm Rear: 6.7-0.2mm	5.5mm 6.0mm
Pilot Air Jet	#150			Master Cylinder Cylinder Bore	Front: 14.000-14.043mm Rear: 14.000-14.043mm	---
Pilot Jet	#40			Master Cylinder Cylinder Bore	Front: 13.941-13.968mm Rear: 13.957-13.984mm	---
Cut Away				Piston Diameter	Front: 42.860-42.899mm Rear: 38.180-38.256mm	---
Jet Needle	5BE12			Brake Caliper Cylinder Bore	Front: 42.785-42.810mm Rear: 38.098-38.148mm	---
Needle Jet	X-6			Wheel Rim Runout (Radial & Axial)	---	2.0mm
Secondary Air Jet				Tire Size	Front: 3.25H19 4PR Rear: 4.25H17 4PR	
Pilot Outlet	0.7			Tire Tread Depth	Front: --- Rear: ---	1.6mm 2.0mm
Main Jet	#92.5			Tire Pressure	FRONT SOLO DUAL SOLO DUAL 25psi 25psi 28psi 36psi	
ELECTRICAL				Normal Riding		
Ignition	TRANSISTORIZED			Continuous High		
Ignition Timing	150BTDC Below 1300 ± 100rpm 400BTDC Above 2350 ± 100rpm			Speed Riding	28psi 32psi 40psi	
Firing Order	1, 2, 4, 3			Fork Spring Free Length	Short: 92.9mm Long: 96.4mm	
Spark Plug	NKG B8ES or ND.W24ES-U			Swinging Arm Pivot Shaft Runout	---	0.3mm
Spark Plug Gap	0.6-0.8mm			FUEL & OILS		
Contact Point Gap				Fuel Type	Low-Lead or Unleaded	
Dwell Angle				Engine Oil Type	SAE 10W/40	
Spark Performance	Over 8mm			Engine Oil Capacity	chg 2400ml / filter chg 2600ml / overhl 2700ml	
Signal Coil Resistance	Approx. 60-80ohm			Transmission Oil Type/Cap	---	
Ignition Coil Resistance (Pri.)	D/W-W or B/V Approx. 3-5ohm			Front Fork Air Pressure	---	
Ignition Coil Resistance (Sec.)	PlugCap/PlugCap Approx. 30-35 Kohm			Fork Oil Type/Cap./Level	SAE #15/190ml/201mm	
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	YB10L-A2					
Specific Gravity	1.28 @20°C					
Regulated Amperage						
Regulated Voltage	14.0-15.5V@5000rpm					
Fuse Capacity	1 15A, 4 10A					