



Fig. 39

Fan housing

Fig. 39

Place fan housing (1, Fig. 39) with wires into the engine (4, Fig. 39).

Place fan housing (5) into covering device on crankshaft and secure it with 4 fan head screws (2) M 8 x 25.

Tightening torque 1.5...20 kgm (108...144 N, lb.)



Fig. 40

Cylinder covers

Fig. 41

Secure cylinder cover without end (single side (1 and 3) to the fan housing (3) with 2 filler head cap screws (4) M 6 x 35 and 1 filler head cap screw (2) M 6 x 75 with spring washers (note: make sure that the covers are properly seated).

Tightening torque for filler head screw M 6 x 35 0.5...0.6 kgm (3.4...4.3 N, lb.)

Tightening torque for filler head cap screw M 6 x 75 1.3...1.6 kgm (9.8...11.4 N, lb.)



Fig. 41

Fig. 42

Secure both cylinder cover halves together with threaded bolt (2) M 8 x 100 locked with 2 nuts M 8 and 1 self-locking nut (3) M 8 and washers.

Secure both cylinder cover halves to the cylinder heads with 4 cam-washer, filler head cap screws (3) M 8 x 75 and spring washers.

Fig. 42

Lead insulating slipring (1) with wires towards the terminals and connect as follows:

Terminal block 2:

Lighting leads (yellow)

to terminal 1 and 2

Terminal block 3:

Primary lead (blue/yellow)

to terminal 1

Primary lead (blue)

to terminal 2

Ground wire (brown)

to terminal 2



Fig. 42

Magneto flywheel

Insert Woodruff key into crankpin.

Attention

If new contact breakers have been fitted or if the contact breaker gap is not within 0.4 (± 0.05 mm (0.01575 ± 0.00196 in)), adjust contact breakers before fitting the magneto flywheel in such a way that the rollers of the contact breaker arms have the greatest distance from the crankpin.

Depress the taper of the crankshaft end of the magneto flywheel.

Fit magneto flywheel with flanged hub, making sure that the Woodruff key engages accurately with the groove in the flanged hub.

Use retaining lever to hold the magneto flywheel, as shown in Fig. 4, and secure it with washer and nut M 14 x 1.5 (the chamfered side of the washer facing towards crankpin taper).

Tightening torque 11.8...12.0 kgm (79.6...88.3 N, lb.)

Ignition timing

Fig. 43

Firing point:

Stopped engine

0.25...0.30 mm (0.0098...0.0118 in.) before TDC

Running engine

0.5...0.6 mm (0.0196...0.0236 in.) before TDC

Contact breaker gap:

0.4 ± 0.05 mm (0.01575 ± 0.00196 in.)

Fuel shoe gap:

Stopped engine

25...29 mm (0.9843...1.1417 in.)

Running engine

7...11 mm (0.2756...0.4331 in.)

Measuring instruments:

Ignition timing gauge (repair tool no. 8), adjusting pin for flyweight (repair tool no. 9), feeler gauge 0.4 mm (0.016 in.)

The flanged hub is provided with two punched marks:

"O-100" is for piston 1 (p. 1, 4 side), "O-10" is for piston 2.

"O" coincides with the marking (2, Fig. 43) on the fan housing when the piston is at top dead center.

"10" indicates the firing position.



Fig. 43

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S Marginson



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