

groove. End gaps on all crankshaft seal rings must face toward crankcase cover. Apply a coat of Suzuki Bond 120TB or a suitable sealer to mating surfaces of crankcase and cylinder block, then position crankcase on cylinder block. Tighten crankcase screws in sequence shown in Fig. S218-23.

Install cylinders on crankcase and tighten cylinder screws snug. Install Suzuki cylinder-to-crankcase alignment tool (part 09912-68720) and tighten alignment tool screws in sequence shown in Fig. S218-24, to 20-26 N·m (15-19 ft.-lbs.). Then, tighten cylinder screws and nuts using Suzuki tool 09911-78790, or a suitable 8 mm Allen wrench to 20-26 N·m (15-19 ft.-lbs.). Remove cylinder alignment tool 09912-68720 and retighten cylinder screws and nuts to 46-54 N·m (34-39 ft.-lbs.).

Install lower oil seal housing and tighten screws to 20-26 N·m (15-19 ft.-lbs.). Install cylinder heads and tighten screws to 28-32 N·m (21-23 ft.-lbs.) in sequence shown in Fig. S218-25.

RINGS, PISTONS, PINS AND CYLINDERS. Refer to CONDENSED SERVICE DATA for service specifications. The pistons are fitted with two keystone type piston rings. The top ring is chrome plated. Piston rings must be installed with the manufacturer's marking facing piston crown. Rings are pinned in place to prevent rotation in ring grooves. Pistons and rings are available in standard size and 0.25 mm (0.010 in.) and 0.50 mm (0.020 in.) oversizes.

Measure piston diameter 5 mm (0.20 in.) up from bottom of piston skirt at a right angle to the piston pin bore. Install pistons on connecting rods so arrows on piston crowns are facing toward exhaust ports. Always renew piston pin retainers (7—Fig. S218-27) once removed. Install retainers (7) with gap facing top of piston.

Cylinder should be bored to the next oversize if taper, out-of-round or wear exceeds 0.10 mm (0.004 in.).

Crankcase, cylinder, exhaust cover and cylinder head mating surfaces must be flat to within 0.030 mm (0.0012 in.).

If not, mating surface should be lapped on a surface plate. Do not remove more stock than necessary to true surface.

CONNECTING RODS, BEARINGS AND CRANKSHAFT. Connecting rods, rod bearings and crankshaft are a press-together unit. Crankshaft should be disassembled **ONLY** by experienced service personnel using the correct service equipment.

Crankshaft is supported by a caged roller bearing at top position, a split caged roller bearing at the bottom position and a ball bearing at the bottom position. Determine connecting rod, rod bearing and crankpin wear by measuring connecting rod small end side-to-side movement as shown at (A)—Fig. S218-28. Normal movement (A) is 5 mm (0.20 in.) or less. Maximum allowable crankshaft runout is 0.05 mm (0.002 in.) measured with crankshaft ends supported.

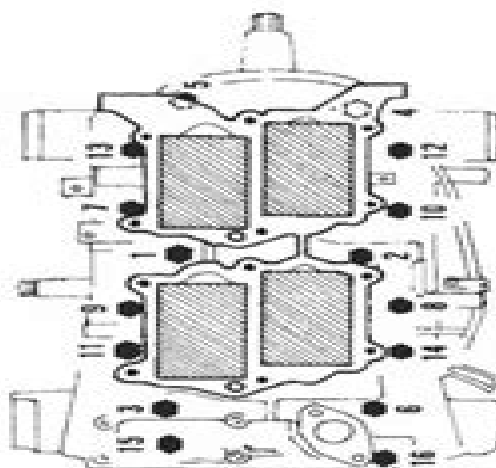


Fig. S218-23—Crankcase screw tightening sequence. Tighten 8 mm screws to 8-12 N·m (6-8 ft.-lbs.), 6 mm screws to 20-26 N·m (15-19 ft.-lbs.) and 10 mm screws to 46-54 N·m (34-39 ft.-lbs.).

When installing crankshaft, lubricate all friction surfaces and bearings with a recommended engine oil.

ELECTRIC STARTER

All models are equipped with the electric starter motor shown in Fig. S218-30. Disassembly is evident after inspection of unit and referral to exploded view. Standard commutator diameter is 33 mm (1.30 in.) and minimum diameter is 32 mm (1.26 in.). Commutator segments should be under cut to 0.5-0.8 mm (0.020-0.031 in.) deep. Standard brush length is 16.0 mm (0.63 in.). Renew brushes if worn to 11.5 mm (0.45 in.). Match marks are provided on frame head (5), frame (6) and end frame (12) for correct alignment during reassembly. Tighten starter through-bolts to 15-20 N·m (11-14 ft.-lbs.).

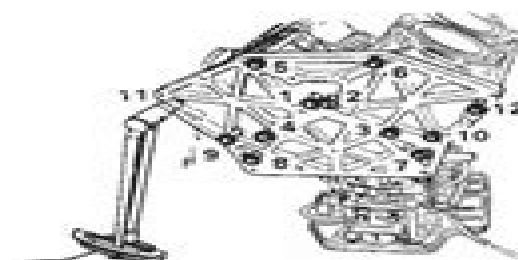


Fig. S218-24—To properly align cylinders to crankcase, install Suzuki cylinder/crankcase alignment tool 09912-68720, and tighten screws in sequence shown to 20-26 N·m (15-19 ft.-lbs.).

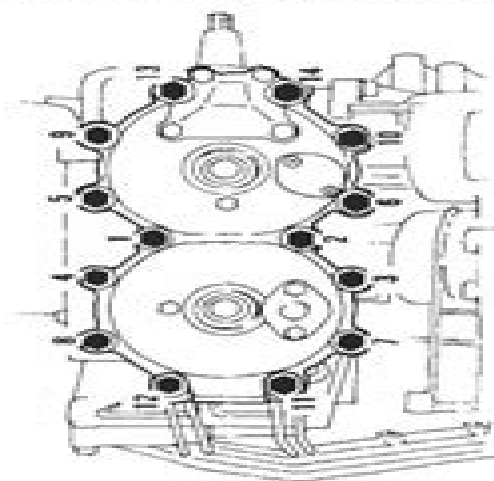


Fig. S218-25—Tighten cylinder head screws in sequence shown.

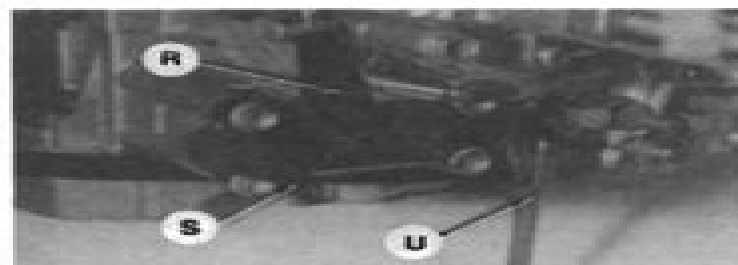


Fig. S218-22—Detach clutch lever rod connector (R) and upper shift rod (U) from clutch shaft (S) during power head removal. Refer to text.

Suzuki Dt140 Workshop Manual

Richard Stone, Stone Richard Staff

A red circular graphic with a gradient, appearing as a partial circle or a stylized arrow pointing to the right, located to the right of the author's name.

Suzuki Dt140 Workshop Manual:

Outboard Motor Service Manual Intertec Publishing,1987 Detailed tips on periodic servicing troubleshooting general maintenance and repair are explicitly outlined in this manual Repair is easy with the specifications and step by step repair procedures included for hundreds of models Volume II covers models with 30hp and above **Suzuki** Suzuki, Motor Co. Ltd,1977 **SUZUKI 2-STROKE TWINS 125cc TO 500cc - 1962 ONWARDS - WORKSHOP MANUAL** Floyd Clymer,2020-03-11 This Workshop Manual is a compilation of various Suzuki Factory Manuals for the 125cc 150cc 200cc 250cc 305cc 315cc 500cc 2 Stroke twins from 1962 onwards Specific models covered are T125 S32 Olympian T200 T10 TC250 El Camino T20 T250 T21 X 6R T305 T350 T500 Cobra Titan **Suzuki 2-225 HP OB & Jt D85-91** Penton Staff,2000-05-24 DT 2 DT 4 DT 6 DT 8 DT 8 SAIL DT 9 9 DT 9 9 SAIL DT 15 DT 20 DT 25 DT 30 DT 35 DT 40 DT 55 DT 65 DT 75 DT 85 DT 90 DT 100 DT 100 SUPER FOUR DT 115 DT 140 DT 150 DT 150 SUPER SIX DT 175 DT 200 DT 200 EXANTE DT 225 *Suzuki Trail Bikes Owners Workshop Manual* Mansur Darlington,1975 **Suzuki GP100 & 125 Owners Workshop Manual** Chris Rogers,Pete Shoemark,1991-01-01 **Suzuki TS50 X Owners Workshop Manual** Richard Stone,Suzuki Motorcycles,1995-09-01 **Suzuki: Service Manual** Suzuki Motor Corporation (Hamamatsu), *Suzuki GT, ZR & TS50* Jeremy Churchill,1984 **Suzuki Trail Bikes Owners Workshop Manual** Chris Rogers (Writer on automotive engineering),1982 Suzuki Ts 50x Owner S Workshop Manual Richard Stone,Stone Richard Staff,1994-12-01 *Suzuki GP 100 & 125 Owners Workshop Manual* Chris Rogers,1982-01-01 Veloce Suzuki T20 & T200 1965-1969 Factory Workshop Manual Floyd Clymer,Velocepress,2009-06-01 A faithful reproduction of the 1970 Floyd Clymer publication of the official factory Suzuki Workshop Manual for the T20 and T200 series of motorcycles including the 250cc Super Six and X6 Hustler and the 200cc X5 Invader and Sting Ray Scrambler There are comprehensive tables of technical data tolerances and fits and all of the expected data from a factory publication for the repair and overhaul of all major and minor mechanical and electrical components making it an invaluable resource for collectors and restorers of these classic Suzuki motorcycles There are 177 illustrations and each procedure is explained in a step by step method using an appropriate illustration The translation from Japanese to English is at times a little quirky but the illustrations make up for any difficulty in understanding what needs to be done Out of print and unavailable for many years this book is highly sought after on the secondary market and we are pleased to be able to offer this reproduction as a service to all Suzuki enthusiasts worldwide *Suzuki GT, ZR & TS50 Owners Workshop Manual* Jeremy Churchill,1986 **Suzuki Student Owners Workshop Manual** Stewart Wilkins,1976-01-01 **Suzuki C550 & 80 Roadie Owners Workshop Manual** Jeremy Churchill,1984 *Suzuki 250 and 350 Twins* ,1973 Suzuki GS & GSX 250, 400 & 450 Twins Owners Workshop Manual Chris Rogers,Pete Shoemark,1983 Suzuki FZ50 Suzy Owners Workshop Manual Martyn Meek,Pete Shoemark,1987 *Suzuki FZ50* Martin Meek,1980

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