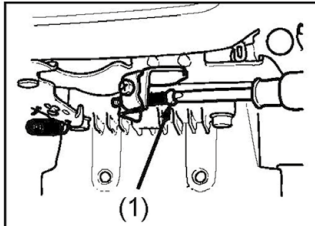


GOVERNOR

Start the engine and allow it to warm up to normal operating temperature.

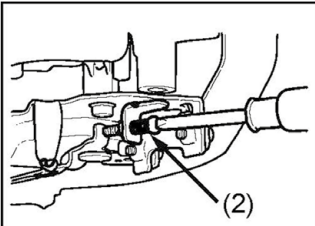
MAXIMUM SPEED



Turn the pan screw (1) of the control to obtain the specified maximum speed.

MAXIMUM SPEED
3,400 ±150min⁻¹ (rpm)

IDLE SPEED



Turn the pan screw (2) of the control to obtain the specified idle speed.

IDLE SPEED
1,400 ±150min⁻¹ (rpm)

GOVERNOR SPRING INSTALLATION

Install the governor arm (1) on the governor arm shaft (2) by aligning the cutout.

Tighten the governor arm nut (3).

TORQUE: 11 N·m

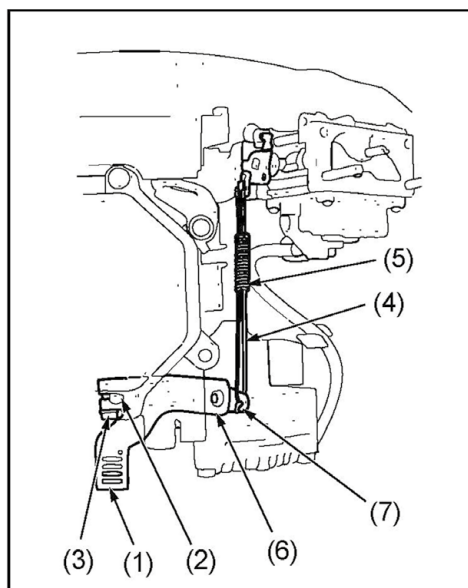
Connect the governor rod (4) and throttle return spring (5) to the governor arm and carburetor.

Loosen the governor sub arm nut (6).

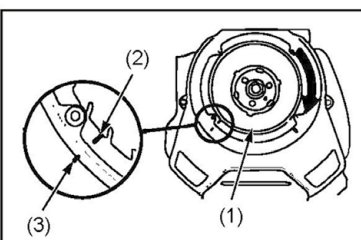
Rotate the governor arm counterclockwise to fully open the carburetor throttle valve.

Rotate the governor sub arm (7) counterclockwise as far as it will go.

Hold the governor arm and governor sub arm, and then tighten the governor sub arm nut securely.



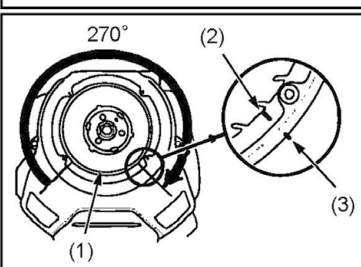
VALVE CLEARANCE



Set the piston of the No. 1 cylinder at the top dead center of the cylinder compression stroke (both valves fully closed) by rotating the flywheel (1) clockwise slowly.

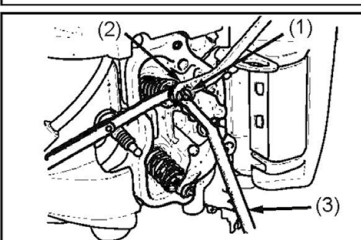
When the No. 1 piston is at the top dead center of the compression stroke, the "T" mark (2) on the cooling fan will align with the right side alignment mark (3) on the fan cover.

If the exhaust valve is opened, rotate the flywheel and align the "T" mark on the cooling fan with the alignment mark on the fan cover again.



Set the piston of the No. 2 cylinder at the top dead center of the cylinder compression stroke (both valves fully closed) by rotating the flywheel (1) 270 degrees clockwise slowly.

When the No. 2 piston is at the top dead center of the compression stroke, the "T" mark (2) on the cooling fan will align with the left side alignment mark (3) on the fan cover.



Insert a thickness gauge between the valve rocker arm and valve stem to measure the valve clearance.

IN: 0.08 ± 0.02 mm EX: 0.10 ± 0.02 mm

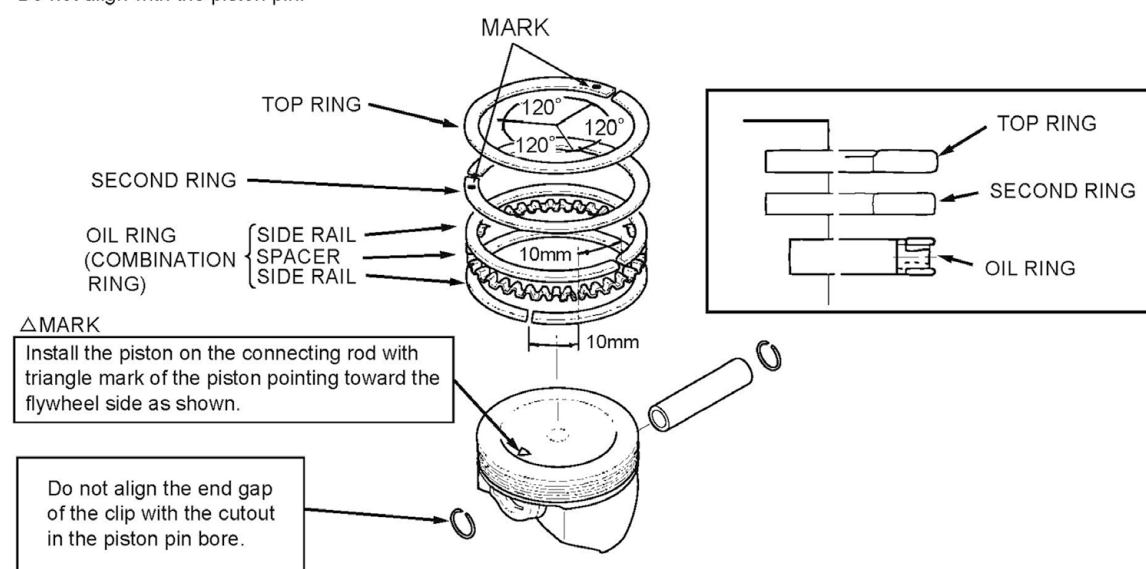
If adjustment is necessary, proceed as follows.

Hold the tappet adjusting screw (1) and loosen the tappet adjusting nut (2). Turn the tappet adjusting screw to obtain the specified clearance.

TOOL: Tappet adjusting wrench 3 mm (3) 07908-KE90200

PISTON DISASSEMBLY/REASSEMBLY

Stagger the piston ring end gaps 120° apart. Do not align with the piston pin.



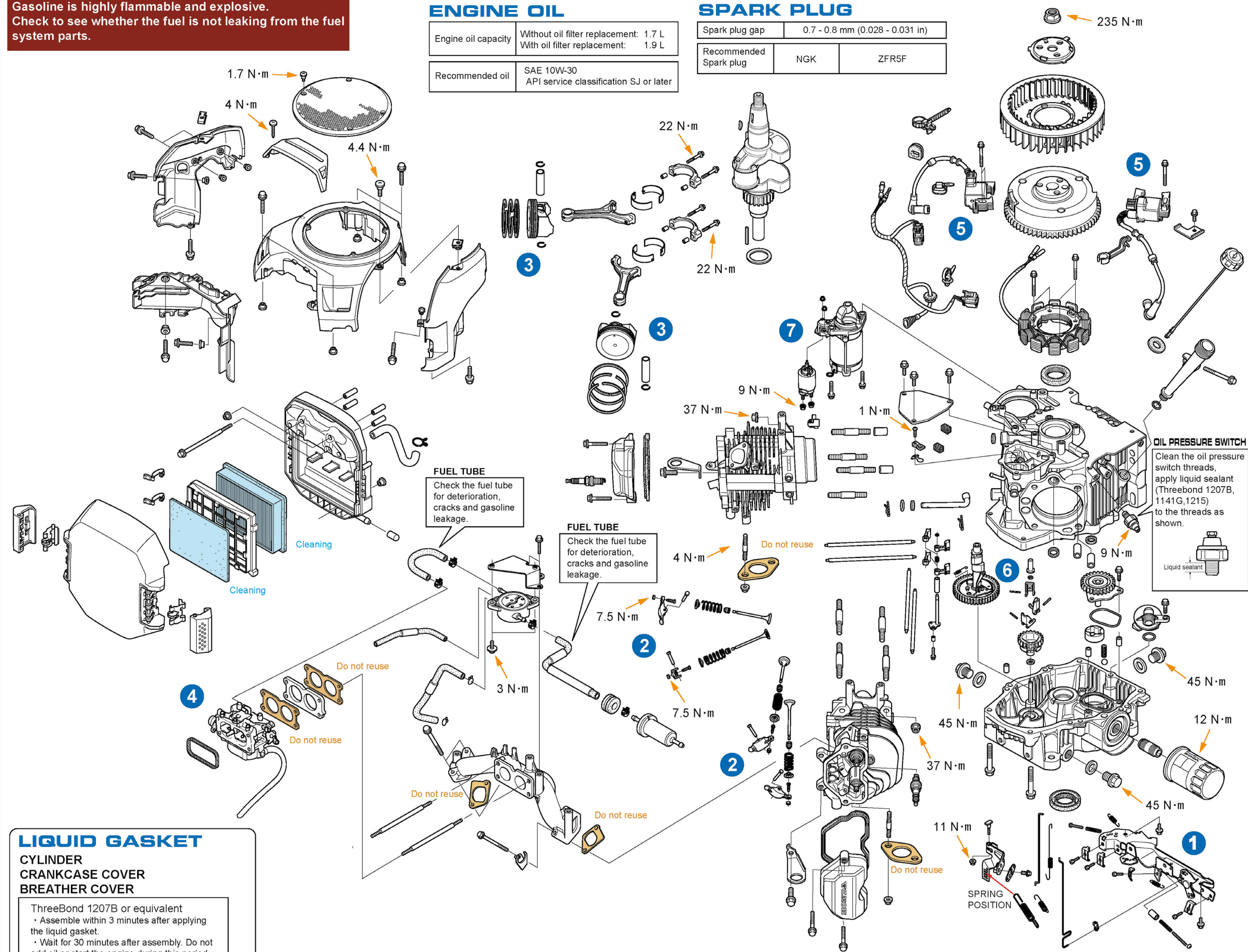
Gasoline is highly flammable and explosive. Check to see whether the fuel is not leaking from the fuel system parts.

ENGINE OIL

Engine oil capacity	Without oil filter replacement: 1.7 L With oil filter replacement: 1.9 L
Recommended oil	SAE 10W-30 API service classification SJ or later

SPARK PLUG

Spark plug gap	0.7 - 0.8 mm (0.028 - 0.031 in)
Recommended Spark plug	NGK ZFR5F

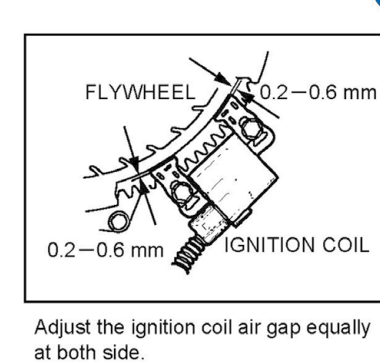


LIQUID GASKET

CYLINDER CRANKCASE COVER BREATHER COVER

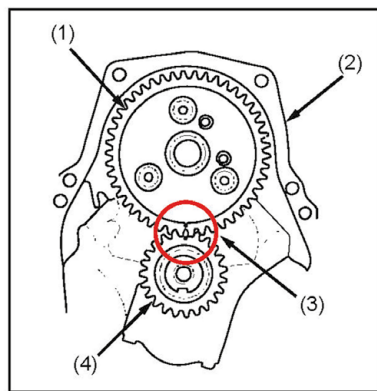
- ThreeBond 1207B or equivalent
- Assemble within 3 minutes after applying the liquid gasket.
- Wait for 30 minutes after assembly. Do not add oil or start the engine during this period.

IGNITION COIL AIR GAP



Adjust the ignition coil air gap equally at both side.

CAM SHAFT ASSEMBLY



Open the valve lifters in the crankcase.

Install the camshaft (1) to the crankcase (2) by aligning the punch marks (3) on the camshaft and the crankshaft (4) (marked on the timing gear).

CARBURETOR

CLEANING

Clean the carburetor body with non-flammable solvent. Clean thoroughly the following passages and ports with low compressed air.

MAIN JET

MAIN JET NUMBER:	
GXV630R	
L side (No. 1 cylinder) #105	
R side (No. 2 cylinder) #110	
GXV660R	
L side (No. 1 cylinder) #110	
R side (No. 2 cylinder) #115	
GXV690R	
L side (No. 1 cylinder) #115	
R side (No. 2 cylinder) #125	

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