STANDARD BIG BORE KIT 108cc for 12V monkey

DISCHARGE : (BORE) x (STROKE)		STD108cc : Φ52x51mm (STROKE UP)	
CODE			
ALUMINUM CYLINDER	214-1083105	ALUMINUM HARD PLATING CYLINDER	215-1133121
ALUMINUM CYLINDER / SPL CAMSHAFT	214-1083115	ALUMINUM HARD PLATING CYLINDER / SPL CAMSHAFT	215-1133122

APPLICATION	
MONKEY / GORILLA	FNO,Z50J-2000001 ～
	FNO,AB27-1000001 ～ 1899999
MONKEY BAJA	
DAX50 (12V)	AB26
CD50 / BENLY50S / CL50	FNO,CD50-1500001 ～ (★)
JAZZ	AC09
MAGNA50	AC13 (★)
SUPER CUB50 *Cannot install to FI model.	FNO,C50-9000001 ～ 9399999
	FNO,C50-9400002 ～9501173(★ DXのみ)
	FNO,C50-9600001 ～ 0095210
	FNO,C50-0200001 ～ (★)
	FNO,AA01-1000001 ～ 1699999 (★)
PRESS CUB50	FNO,C50-9000001 ～ 9501323 (★)
	FNO,C50-9600001 ～0095210 (★)
	FNO,C50-0200001 ～ (★)
	FNO,AA01-1000001 ～ 1699999 (★)

LITTLE CUB	FNO,C50-4300001 ～ (★)
	FNO,AA01-3000001 ～ 3999999 (★)
CHALY ※1)	FNO,CF50-3400001 ～ (★)
SOLO	AC17 (★)
GIORCUB	AF53 (★)
XR50R/CRF50F	AE03

※Unable to install MONKEY R / RT, MOTRA, CHALY AND SUPER CUB with wide width camshaft.

※1) In case of CHALY, machining is required because cylinder fin and leg shield interrupt each other.

(★) models stock (thick) oil spindle might interrupt to crank shaft, please change to ultra thin spindle set. (In case of the stock is thin shape, do not need to change.)

Refer to the No.3 spindle detail illustration under [PACKING LIST 02].

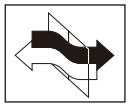
- Thank you for purchasing Kitaco product. Read and understand the instruction before installing.
- Special tools are required to install.
- After installation, please use this sheet as setting manual.

※Instruction sheet is not included to repair parts. Please keep this instruction safe.

ATTENTION (MUST READ)

- This product is for racing use. It is out of warranty. Unable to ride on public road with installed vehicle. We are not responsible for violation of law or damages and accidents caused by assembling mistake and improper setting.
- By installing this product, changing plug, gear, etc and setting is required. Please use Kitaco carburetor and exhaust. Using other company's product may cause of break. If riding with stock setting, it unables to power up, cause of burning and break. Please set up to match the engine. Please change stronger clutch.
- Please follow this instruction sheet. Do not modify the way which is not listed or it will cause burning, damage and trouble.
- Please ask authorized mechanic for assembling and setting. Ask a specialist at specialty shop if you do not understand the role of the surrounding parts.
- Change engine oil after break in (around 100km).
- Refer to the manufacturer service manual when installation.
- Bolts and nuts may get loosen by engine vibration. Make sure not to loosen any bolts and nuts before driving.
- Clean each parts by parts cleaner, etc and check the oil line is choked by using air duster.
- Oil the parts with engine oil when assembling.
- Do not use engine brake, etc burden the mission. When starting engine with kick, check the gear is engaged before kick.
- Please ride under 5,000rpm when break in.

This instruction sheet is for the person who has basic knowledge for maintenance. Do not operate if you do not have any skill and knowledge.



Toxic, high-volatile gasoline is used during operation. Be sure to ventilate the room. Please start engine under well-ventilated place.

FLAMMABLES
Inflammable high gasoline is used during operation. Using products causing fire or smoke is strictly prohibited.

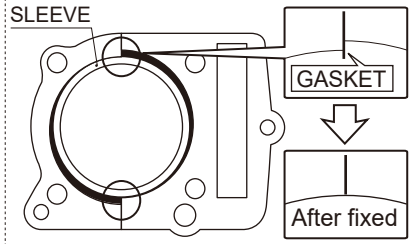
Do not touch cylinder, crank case, exhaust, etc during or right after engine operation. It is high temperature.

Do not spark the plug outside the cylinder for spark check. It might cause of fire and explosion.

ATTENTION WHEN INSTALLING

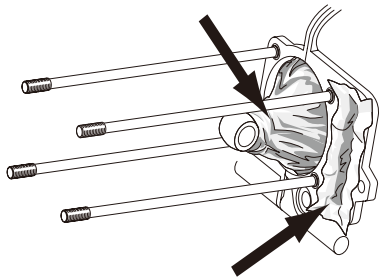
The clearance between cylinder sleeve and crank case through hole.

When installing cylinder, make sure that there is a gap more than 0.5mm all around cylinder sleeve and crank case side through hole. Because of the crank case tolerance, 0.5mm or less gap might interrupt the sleeve. In that case, shave crank case through hole sharply to make clearance more than 0.5mm. If the gasket sticks out from crank case matching surface, cylinder sleeve might touch the gasket because of deformation by thermal expansion, and it might cause of burning piston and oil leaking. Crank case hardness is more than tolerance, processing and assembling require extreme caution.



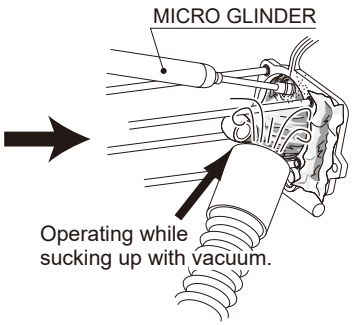
CRANK CASE FLAT SURFACE

In case of unable to insert cylinder sleeve into crank case, ○ is out of the hole, please shave. Make sure that there is a gap more than 0.5mm all around cylinder sleeve and crank case through hole.



Stuff clean cloth inside crank case to prevent attaching shaving powder to inside crank case, conrod and cam chain.

※When changing crank shaft, disassemble crank case before shaving.



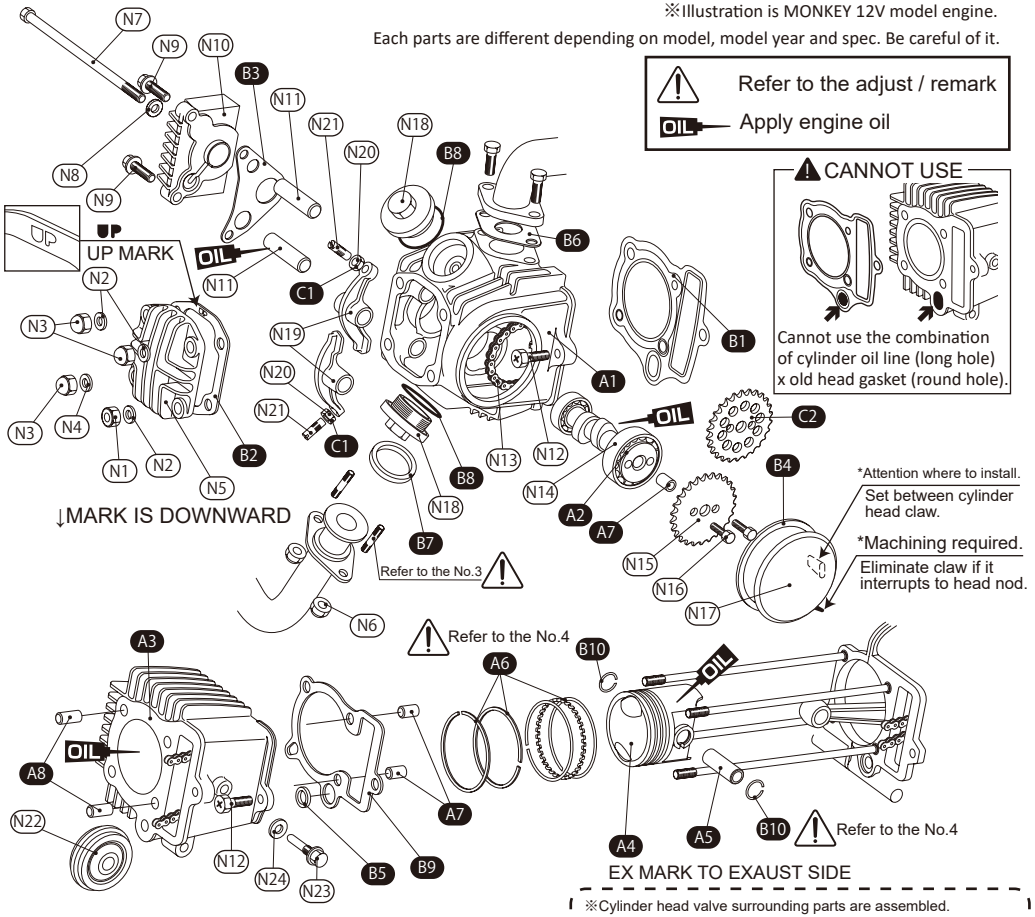
OPTION PARTS (Sold separately. Please purchase in need.)			
▼By installing big bore kit, reinforcing clutch, high geared, installing oil cooler, etc are required.			
OIL SURROUNDINGS	SUPER OIL COOLER KIT (3ROW CONDENSER)		CODE : 360-1133200
	ULTRA OIL PUMP KIT (For application C)		331-1083400
CLUTCH	3 DISK DRIVE UNIT		307-1123500
	MANUAL CLUTCH KIT (3DISK)		307-1123000
▼Changing intake parts are requied.			
CARBURETOR (Specified for each model.)	MONKEY / GORILLA	KEIHIN PCΦ20 BIG CARBURETOR	110-1015516
		KEIHIN PEΦ24	110-1123408
		MIKUNI VMΦ26 (Left side / SHORT / LONG TYPE)	110-1123203/110-1013013
CDI (Specified for each model.)	MONKEY / GORILLA (Not for 6V model.)	POWER REV2	766-1123300
		REV CON *Recommend map : 3	764-1123100
▼General and special tools are required.			
KITACO SPECIAL TOOLS	FLY WHEEL PULLER		674-0500120
	CENTER LOCK NUT WRENCH		674-1432900
	UNIVERSAL HOLDER		674-0500000
	TAPPET ADJUST WRENCH		674-0900200
COMMERCIAL	THICKNESS GAUGE		-
OTHERS	SPL HIGH CAMSHAFT (For application C)		300-1083100
	LOCKER ARM (TITANUM) NUT		303-1013711
	CAP NUT & WASHER SET		313-0600000

OTHER ATTENTION

- Please use unleaded premium gasoline. This is high pressure, regular gasoline may cause of knocking and breaking vehicle.

■CYLINDER PARTS / Refer to the illustration when assembling. (Please use when maintenance.)

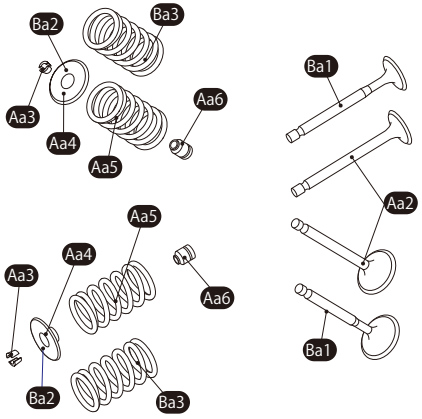
※Illustration is MONKEY 12V model engine.
Each parts are different depending on model, model year and spec. Be careful of it.



※() is 1set QTY.

FIGURE	CODE	NAME	QTY
-	313-1133010	STD CYLINDER HEAD COMP	× 1
Aa2 ↓	302-1013011	STD VALVE SET	× 1
	302-1013100	IN VALVE・STD	(× 1)
	302-1013200	EX VALVE・STD	(× 1)
Aa3	303-1013502	VALVE COTTER	× 4
Aa4	303-1013510	VALVE SPRING RETAINER	× 2
Aa5	303-1133010	VALVE SPRING NEW STD	(× 2)
Aa6	303-1122507	VALVE STEM SEAL	× 2

※Cylinder head valve surrounding parts are assembled.
Please use valve spring compresser when installing / removing.



※Basically, reuse genuine parts if it is unattached.
If there is a hard degradation like a blem, fatigue and wear etc on the reuse parts, please change to new ones.

▼PACKING LIST 01

FIGURE	CODE	NAME	214-1083105	214-1083115	215-1133121	215-1133122
A1	313-1133110	STD CYLINDER HEAD ASSY (VALVE ASSEMBLED)	× 1	× 1	× 1	× 1
A2	300-1083100	SPL HIGH CAMSHAFT (For application C)	OP	× 1	OP	× 1
A3	311-1123200	Φ52.0 CYLINDER T2 (88/108cc)	× 1	× 1	-	-
	311-1083701	Φ52.0 CHROME CYLINDER (88/108cc)	-	-	× 1	× 1
A4	351-1133101	Φ52.0 PISTON (88cc) 3R (0.8-0.8-1.5)	× 1	× 1	× 1	× 1
A5	353-0001336	PISTON PIN 13x36	× 1	× 1	× 1	× 1
A6	352-0006520	Φ52.0 PISTON RING (88/108cc) 3R (0.8-0.8-1.5)	× 1SET	× 1SET	× 1SET	× 1SET
A7	70-989-08120	DOWEL PIN 8x12L	× 2+1	× 2+1	× 2+1	× 2+1
A8	70-989-08140	DOWEL PIN 8x14L	× 2	× 2	× 2	× 2
B ↓	960-1016088	RUBBER SEAL SET-A (88/108cc) MONKEY BC SUS RUBBER SEAL	× 1SET	× 1SET	-	-
	960-1123088	RUBBER SEAL SET-A (88/108cc) ROUND HOLE SUS RUBBER SEAL	-	-	× 1SET	× 1SET
B1	961-1123200	HEAD GASKET (88/108cc) LONG ROUND HOLE STANLESS STEEL	(× 1)	(× 1)	-	-
	961-1123088	HEAD GASKET (88/108cc) ROUND HOLE STANLESS STEEL	-	-	(× 1)	(× 1)
B2	966-1015022	CYLINDER HEAD COVER GASKET	(× 1)	(× 1)	(× 1)	(× 1)
B3	966-1015110	R HEAD SIDE COVER GASKET (12v)	(× 1)	(× 1)	(× 1)	(× 1)
B4	966-1015021	L HEAD SIDE COVER GASKET	(× 1)	(× 1)	(× 1)	(× 1)
B5	966-1015010	RUBBER SEAL 16mm	(× 1)	(× 1)	(× 1)	(× 1)
B6	950-1015010	MANIFOLD RUBBER SEAL	(× 1)	(× 1)	(× 1)	(× 1)
B7	70-963-11001	EX GASKET (H-1)	(× 1)	(× 1)	(× 1)	(× 1)
B8	967-1015000	O RING 30.8mm	(× 2)	(× 2)	(× 2)	(× 2)
B9	962-1083600	BASE RUBBER SEAL	(× 1)	(× 1)	(× 1)	(× 1)
B10	354-0000130	PISTON PIN CLIP 13mm	(× 2)	(× 2)	(× 2)	(× 2)
		OPTION PARTS (CYLINDER HEAD PARTS)				
C1	303-1013711	TAPPET ADJUST TITANUM NUT (1pc)	OP	OP	OP	OP

▼OPTION PARTS

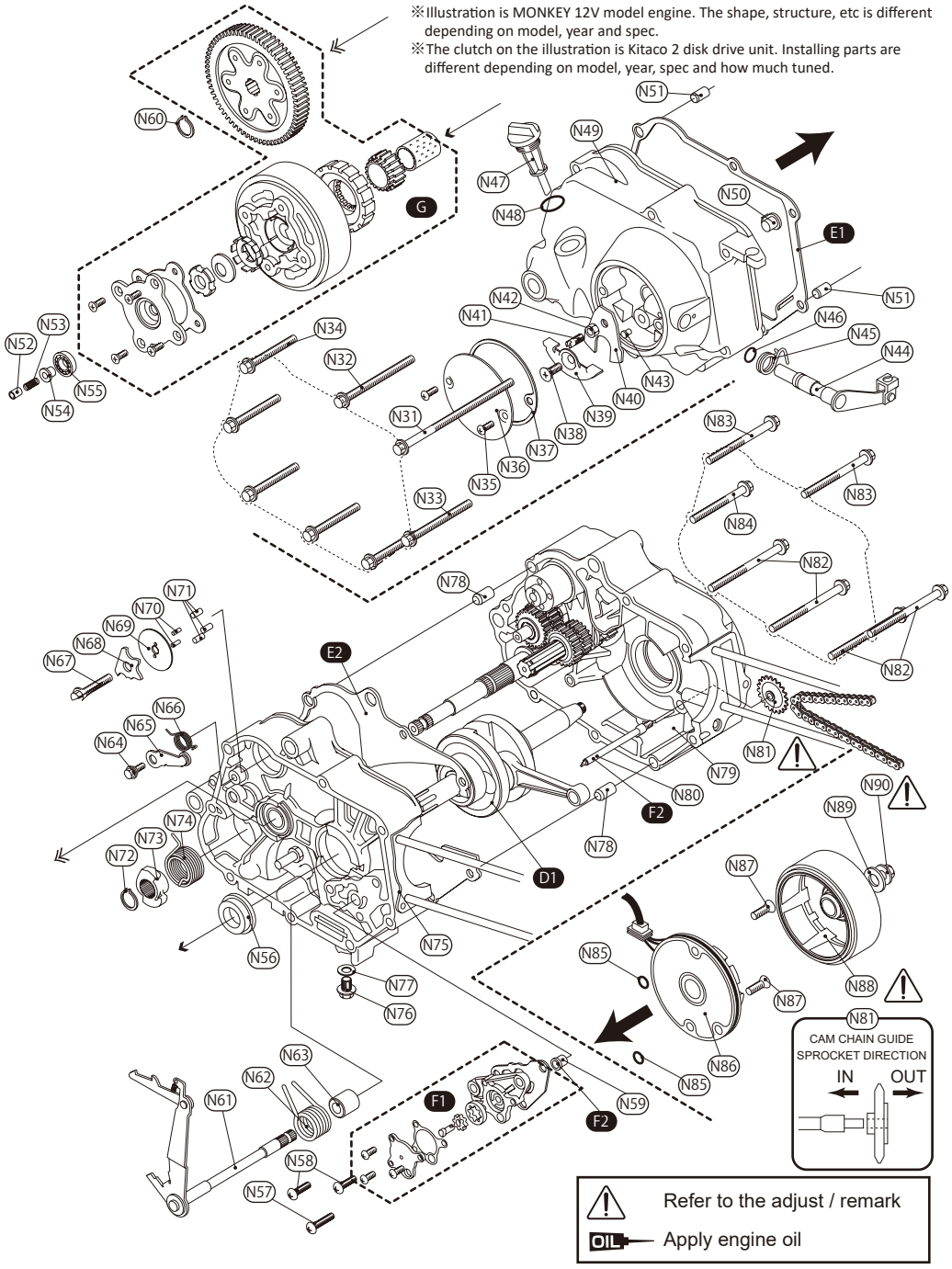
FIGURE	CODE	NAME	QTY
C2	303-1133900	LIGHTWEIGHT CAM SPROCKET 28T (12v MONKEY)	OP

▲() is 1set QTY.
▲OP is option parts. Please purchase separately depending on setting.

STOCK PARTS (TORQUE / REMARK)

FIGURE	NAME	QTY	TORQUE	FIGURE	NAME	QTY	TORQUE
N1	M6 NUT	× 1	12N・m (1.2kgf・m)	N13	CAM CHAIN	× 1	
N2	6mm FLAT WASHER	× 3		N14	CAMSHAFT	× 1	
N3	M6 CAP NUT	× 3	12N・m (1.2kgf・m)	N15	CAM SPROCKET	× 1	
N4	6mm COPPER FLAT WASHER	× 1		N16	M5 BOLT	× 2	8N・m (0.8kgf・m)
N5	CYLINDER HEAD COVER	× 1		N17	L CYLINDER HEAD SIDE COVER	× 1	
N6	M6 FLANGE NUT	× 2	12N・m (1.2kgf・m)	N18	TAPPET CAP	× 2	12N・m (1.2kgf・m)
N7	M6 x 110 BOLT	× 1	10N・m (1.0kgf・m)	N19	LOCKER ARM	× 2	
N8	6mm SEALING WASHER	× 1		N20	TAPPET ADJUST NUT	× 2	10N・m (1.0kgf・m)
N9	M6 x 20 BOLT	× 2	10N・m (1.0kgf・m)	N21	TAPPET ADJUST SCREW	× 2	
N10	R CYLINDER HEAD SIDE COVER	× 1		N22	CAM CHAIN GUIDE ROLLER	× 1	
N11	LOCKER ARM SHAFT	× 2		N23	ROLLER PIN	× 1	10N・m (1.0kgf・m)
N12	M6 BOLT	× 2	10N・m (1.0kgf・m)	N24	8mm SEALING WASHER	× 1	

■CRANK CASE PARTS
※Illustration is MONKEY 12V model engine. The shape, structure, etc is different depending on model, year and spec.
※The clutch on the illustration is Kitaco 2 disk drive unit. Installing parts are different depending on model, year, spec and how much tuned.



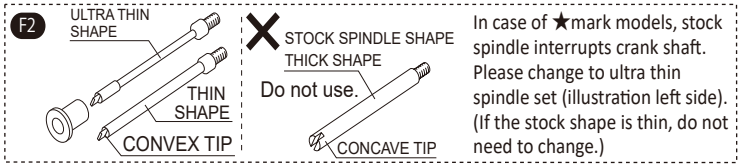
▲BIG BORE KIT PACKING LIST is on (No,2) too.

▼PACKING LIST 02

FIGURE	CODE	NAME	214-1133121	214-1133122	215-1133121	215-1133122
D1	309-1083500	STROKE UP CRANK SHAFT COMP (12V CRANK)	× 1	× 1	× 1	× 1
E1	966-1015004	R CRANK CASE COVER GASKET	× 1	× 1	× 1	× 1
E2	966-1015023	CRANK CASE GASKET	× 1	× 1	× 1	× 1
		OPTION PARTS (OIL PUMP)				
F1	331-1083400	ULTRA OIL PUMP KIT (For application C)	OP	OP	OP	OP
F2	331-1083003	OIL PUMP SPINDLE SET	OP ※	OP ※	OP ※	OP ※
		OPTION PARTS (CLUTCH)				
G	307-1016500	2 DISK DRIVE UNIT	OP	OP	OP	OP
	307-1016000	MANUAL CLUTCH KIT	OP	OP	OP	OP
	317-1083010	ULTRA CLUTCH KIT TYPE X (For MONKEY 4 speed)	OP	OP	OP	OP
	317-1123710	ULTRA CLUTCH KIT TYPE X (For MONKEY 5 speed type II / III)	OP	OP	OP	OP
		OPTION PARTS (FOR AUTO CLUTCH)				
-	966-1015011	CLUTCH OUTER COVER GASKET (For auto clutch)	OP	OP	OP	OP
-		OPTION PARTS (FOR STARTER MOTOR MODEL)				
-	966-1085023	L CRANK CASE COVER GASKET (For starter motor model)	OP	OP	OP	OP

▲OP ※ is option. Please purchase in case of (★) models.

▲( ) is 1SET QTY.
▲OP is option.
Please purchase to match setting.



In case of ★mark models, stock spindle interrupts crank shaft. Please change to ultra thin spindle set (illustration left side). (If the stock shape is thin, do not need to change.)

STOCK PARTS (TORQUE / REMARK)

FIGURE	NAME	QTY	TORQUE	FIGURE	NAME	QTY	TORQUE
N31	M6 x 100 BOLT	× 1	10N・m (1.0kgf・m)	N61	GEAR SHIFT ARM COMP	× 1	
N32	M6 x 65 BOLT	× 1	10N・m (1.0kgf・m)	N62	GEAR SHIFT ARM RETURN SPRING	× 1	
N33	M6 x 55 BOLT	× 1	10N・m (1.0kgf・m)	N63	12.2mm COLLAR	× 1	
N34	M6 x 40 BOLT	× 5	10N・m (1.0kgf・m)	N64	DRUM STOPPER ARM PIVOT BOLT	× 1	12N・m (1.2kgf・m)
N35	M5 x 12 SCREW	× 2		N65	DRUM STOPPER ARM	× 1	
N36	CLUTCH COVER	× 1		N66	DRUM STOPPER ARM SPRING	× 1	
N37	CLUTCH COVER GK	× 1		N67	M6 BOLT	× 1	12N・m (1.2kgf・m)
N38	M6 x 16 SCREW	× 1	10N・m (1.0kgf・m)	N68	DRUM STOPPER PLATE	× 1	
N39	LIFTER SETTING PLATE	× 1		N69	SHIFT DRUM SIDE PLATE	× 1	
N40	CLUTCH LIFTER PLATE	× 1		N70	ROLLER 3 x 8.5	× 2	
N41	CLUTCH ADJUST SCREW	× 1		N71	SHIFT DRUM PIN	× 3	
N42	M6 NUT	× 1	10N・m (1.0kgf・m)	N72	16mm CIRCLIP	× 1	
N43	CLUTCH ARM STOPPER PIN	× 1		N73	KICK SPRING RETAINER	× 1	
N44	CLUTCH LIFTER ARM	× 1		N74	KICK STARTER SPRING	× 1	
N45	CLUTCH ARM SPRING	× 1		N75	R CRANK CASE	× 1	
N46	O RING 14 x 1.5	× 1		N76	DRAIN BOLT	× 1	
N47	FILER CAP	× 1		N77	DRAIN COCK RUBBER SEAL	× 1	
N48	O RING 18 x 3	× 1		N78	DOWEL PIN 10 x 14	× 2	
N49	R CRANK CASE COVER	× 1		N79	L CRANK CASE	× 1	
N50	CLUTCH PUSH ROD	× 1		N80	OIL PUMP SPINDLE	× 1	
N51	DOWEL PIN 8 x 12	× 2		N81	CAM CHAIN GUIDE SPROCKET 25T	× 1	
N52	OIL THROUGH	× 1		N82	M6 x 65 BOLT	× 4	
N53	OIL THROUGH SPRING	× 1		N83	M6 x 60 BOLT	× 2	
N54	OIL THROUGH GUIDE	× 1		N84	M6 x 50 BOLT	× 1	
N55	OIL THROUGH BEARING	× 1		N85	O RING 7 x 2	× 2	
N56	17mm COLLAR	× 1		N86	STARTER COIL ASSY	× 1	
N57	M6 x 22 SCREW	× 1	10N・m (1.0kgf・m)	N87	M6 x 16 PLATE SCREW	× 2	10N・m (1.0kgf・m)
N58	M6 x 16 SCREW	× 2	10N・m (1.0kgf・m)	N88	FLYWHEEL	× 1	
N59	OIL PUMP SPINDLE COLLAR	× 1		N89	10mm WASHER	× 1	
N60	17mm CIRCLIP	× 1		N90	M10 NUT	× 1	42N・m (4.2kgf・m)

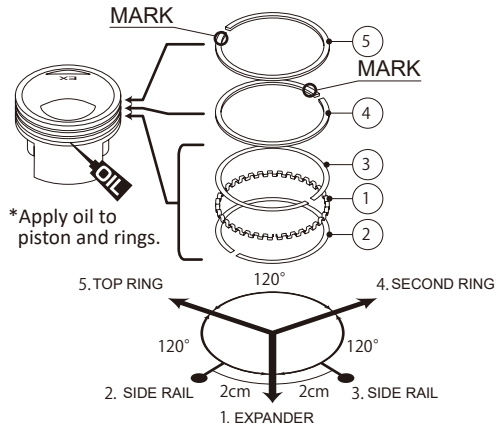
INSTALLING PISTON RING

Install piston ring as illustration.

"POINT"

- ●Divide ring as following illustration.
- ●Top and second ring marked face to upward (head direction).
- ●There is no specified direction for expander and side rail.

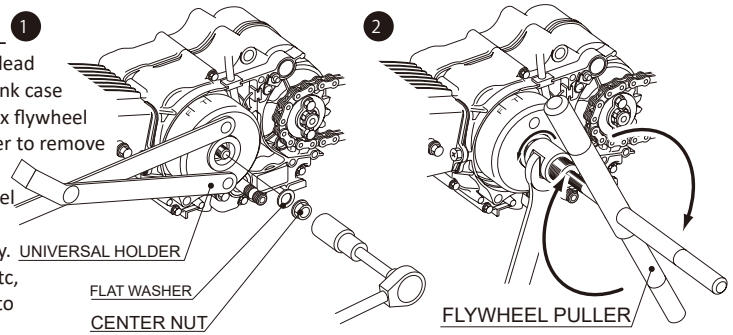
PARTS DATA (Install in numecrial order)		
FIGURE	NAME	QTY
1	EXPANDER	× 1
2/3	SIDE RAIL (BOTH SAME)	× 2
4	SECOND RING (BLACK)	× 1
5	TOP RING (WHITE)	× 1



*Install piston with EX mark to exhaust side.

INSTALLING / REMOVING FLYWHEEL

1) Firstly, set to compression top dead center (flywheel T mark and crank case matching mark are matched.) Fix flywheel by specified tool universal holder to remove flywheel center nut.
2) Install flywheel puller to flywheel with rotating left (counter clockwise) to install firmly deeply. Fix flywheel puller by spanner, etc, then rotate handle to right side to pull out flywheel.



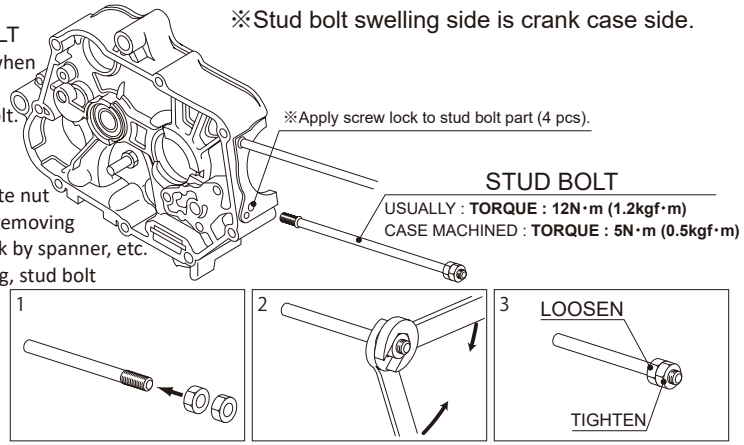
REMOVING / INSTALLING STUD BOLT

(Orifice enlargement machining when installing oil pump.)

1) Install 2pcs M6 nuts to stud bolt.
2) Hang spanner to each nut, tighten both to fix.
3) When installing stud bolt, rotate nut in the front by wrench. When removing stud bolt, rotate nut in the back by spanner, etc.

※In case of processed case boring, stud bolt surrounding is thin, therefore use screw lock and tighten a half of specified torque. (Install muffler stud bolt as same.)

※Stud bolt swelling side is crank case side.



ADJUSTMENT AND INSTALLING EACH PARTS / CHECK POINT

HOW TO ADJUST VALVE TIMING AND CHECK VALVE CLEARANCE

INSTALLING CAMSHAFT

1) Rotate crank shaft to counterclockwise to match fly wheel "T" mark and crank case matching mark.
2) Apply clean oil to camshaft and camshaft bearing. Face cam lobe to piston side, install camshaft to inside cylinder head while pushing locker arm.
3) Install dowel pin to cam sprocket, match cam sprocket O mark and cylinder head nod. Then install cam chain to sprocket. (Align crank shaft center, cam shaft center and O mark in a straight line.)

*Refer to the compression top dead center illustration.

4) Install cam sprocket to camshaft, tighten cam sprocket bolt. **(TORQUE : 0.8kgf·m)**

VALVE CLEARANCE SETTING

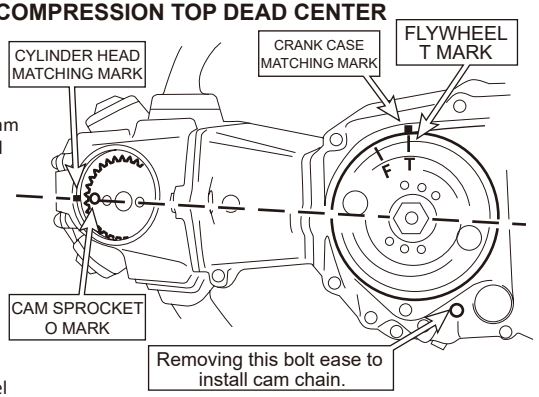
5) Rotate crank shaft to counterclockwise to match fly wheel "T" mark and L crank case matching mark. Move locker arm to check piston position is at compression top dead center.
6) Insert thickness gauge between adjust screw and valve stem to adjust intake and exhaust valve clearance.

○VALVE CLEARANCE
IN : 0.05~0.07mm
EX : 0.07~0.09mm

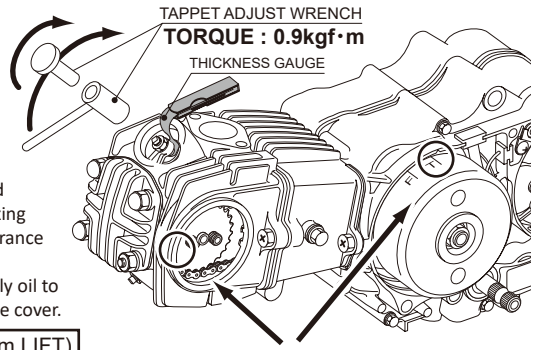
ADJUSTMENT

7) Loosen lock nut and rotate adjust screw to adjust specified valve clearance. After adjustment, tighten lock nut while fixing adjust screw. After tightening lock nut, check the valve clearance again. **(TORQUE : 0.9kgf·m)**
8) Check the tappet cap O ring, please change it in need, apply oil to tappet cap O ring, install tappet cap and cylinder head L side cover.

COMPRESSION TOP DEAD CENTER



VALVE CLEARANCE ADJUSTMENT



Adjust clearance while each matching mark are matched (compression top dead center).

SERVICE GUIDE VALVE TIMING DEGREE (AT1mm LIFT) *Compared to sock head, valve train layout and timing is different.			
SPL CAMSHAFT		OPEN	CLOSE
USING NEW STD CYLINDER HEAD	INTAKE	BTDC 7°	ABDC 41°
	EXHAUST	BBDC 46°	ATDC 11°
USING STOCK HEAD	INTAKE	BTDC 4°	ABDC 37°
	EXHAUST	BBDC 46°	ATDC 9°

START ENGINE AFTER INSTALLATION

A time lag of circulation engine oil around engine inside may cause of burning. In case of the engine with oil check bolt, remove check bolt and spark plug, then kick to the (cranking) oil comes out from check bolt. After check it, put check bolt and spark plug back and start engine.

BREAK IN (HEAT TREATMENT)

Please do break in with low (short) gear (in case of 5speed model, please use 4speed) and total 2 hours without applying force to engine.

ADDITIONAL TIGHTENING

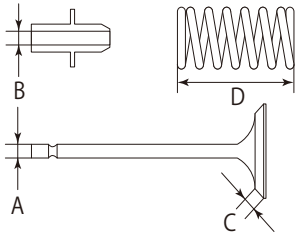
After break in, cylinder, cylinder head stud bolts might get distortion and elongation because of cooling and heating. Additional tightening to even the power. The bolts of cylinder head for most of the models are 4pcs + hexagon bolts 1 or 2 pcs. After the engine becomes room temperature, loosen a nut of 4pcs stud bolt, then apply oil to nut, washer and stud bolt screw part and tighten with specified torque.

Secondly, loosen diagonally stud bolt nut, then as same as previous, apply oil to nut, washer and stud bolt screw part and tighten with specified torque. (continue)

(ATTENTION! Do not loosen all 4pcs nut at once. Please operate one by one.)

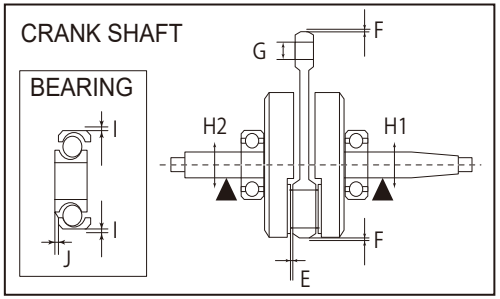
Finally, apply oil to bolts and tighten with specified torque as same to finish.

VALVE / VALVE GUIDE / VALVE SPRING



SERVICE GUIDE CYLINDER HEAD		BASIC VALUE (mm)	USAGE (mm)
A	IN VALVE STEM DIAMETER	φ 5,445 ～φ 5,465	～ φ 5.400
	EX VALVE STEM DIAMETER	φ 5.430 ～φ 5.445	～ φ 5.400
B	IN VALVE GUIDE I.D.	φ 5.475 ～φ 5.485	φ 5.500 ～
	EX VALVE GUIDE I.D.	φ 5.475 ～φ 5.485	φ 5.500 ～
C	IN VALVE SEAT CONTACT WIDTH	0.8 ± 0.1mm	1.3mm ～
	EX VALVE SEAT CONTACT WIDTH	0.8 ± 0.1mm	1.5mm ～
D	OUTER VALVE SPRING	30 ± 0.3mm	～29mm

CRANK SHAFT



SERVICE GUIDE (CRANK SHAFT)			
		BASIC VALUE (mm)	USAGE (mm)
E	CONROD BIG END SIDE GAP	0.1 ～ 0.35	0.5 ～
F	CONROD BIG END VERTICAL GAP	0 ～ 0.01	0.05 ～
G	CONROD SMALL END I.D.	13.013 ～ 13.043	13.05 ～
H	LEFT SIDE CRANK SHAFT SHAKE	0 ～ 0.05	0.08 ～
I	INSIDE BEARING, OUTER RING VERTICAL GAP	0.05 ～ 0.09	0.10 ～
J	INSIDE BEARING, OUTER RING SIDE GAP	0.005 ～ 0.040	0.050 ～

230606

KITACO 株式会社キタコ
3-8-13 NAGATA,
HIGASHI-OSAKA,
OSAKA,JAPAN
https://www.kitaco.co.jp/