

GENERAL DATA—continued

Camshaft end float	-.003 to -.007 in. (-.07 to -.17 mm.)
Camshaft drive type	Single roller chain $\frac{3}{8}$ in. (9.52 mm.) pitch, 52 pitches, endless with synthetic rubber tensioner rings on camshaft gear
Valve timing marking	Adjoining gear teeth are marked
Seat angle	45°
Seat width:							
Inlet	-.066 in. (1.68 mm.)
Exhaust	-.088 in. (2.23 mm.)
Valve lift	-.285 in. (7.24 mm.)
Valve guide length:							
Inlet and exhaust	1.687 in. (42.86 mm.)
Stem clearance:							
Inlet	-.0015 to -.0025 in. (-.038 to -.063 mm.)
Exhaust	-.002 to -.003 in. (-.051 to -.076 mm.)
Valve springs:							
Free length	1½ in. (41.275 mm.)
Fitted length and load	1½ in. at 37½ ± 2 lb. (32.9 mm. at 17.01 ± .907 kg.)
Rocker bore	-.686 to -.687 in. (17.42 to 17.44 mm.)
Rocker bush inside diameter (reamed in position)	-.5630 to -.5635 in. (14.30 to 14.31 mm.)
Running clearance (cold)	-.012 in. (-.30 mm.)
Clearance for timing	-.019 in. (-.48 mm.)
Timing:							
Inlet valve opens	5° before T.D.C.
Inlet valve closes	45° after B.D.C.
Exhaust valve opens	40° before B.D.C.
Exhaust valve closes	10° after T.D.C.

} with 0.019 in. (-.48 mm.)
valve rocker clearance
(for checking purposes only)

IGNITION

Type	Lucas 12 volt coil
Distributor type (Mk. I)	Lucas DM2
Distributor type (Mk. II)	Lucas 25D4
Direction of rotation	Anti-clockwise at rotor arm
Contact breaker gap	-.014 to -.016 in. (-.35 to -.40 mm.)
Static setting:							
High compression engines	5° B.T.D.C. (premium fuel)
Low compression engines	2° B.T.D.C. (commercial fuel)
Coil type	Lucas LA12
Spark plug type	Champion N5
Spark plug gap	-.024 to -.026 in. (-.61 to -.66 mm.)

COOLING SYSTEM

Capacity	8 pints (4.5 litres, 9.6 U.S. pints)
Capacity (including heater)	8½ pints (5 litres, 10½ U.S. pints)
Circulation	Pump and thermostat

FUEL SYSTEM (Mk. I)

Fuel pump	A.C. Sphinx, 'Y' Type, Mechanical
Carburettor type	Down draught Zenith type 26 VME
Standard settings:							
Choke tube	22
Main jet	80
Compensating jet	57
Slow run jet	50

Mki Mkii Assembly Manual Marine

Brendan G. Carr



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Table of Contents Mki Mkii Assembly Manual Marine

1. Understanding the eBook Mki Mkii Assembly Manual Marine
 - The Rise of Digital Reading Mki Mkii Assembly Manual Marine
 - Advantages of eBooks Over Traditional Books
2. Identifying Mki Mkii Assembly Manual Marine
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Mki Mkii Assembly Manual Marine
 - User-Friendly Interface
4. Exploring eBook Recommendations from Mki Mkii Assembly Manual Marine

- Personalized Recommendations
- Mki Mkii Assembly Manual Marine User Reviews and Ratings
- Mki Mkii Assembly Manual Marine and Bestseller Lists
- 5. Accessing Mki Mkii Assembly Manual Marine Free and Paid eBooks
 - Mki Mkii Assembly Manual Marine Public Domain eBooks
 - Mki Mkii Assembly Manual Marine eBook Subscription Services
 - Mki Mkii Assembly Manual Marine Budget-Friendly Options
- 6. Navigating Mki Mkii Assembly Manual Marine eBook Formats
 - ePub, PDF, MOBI, and More
 - Mki Mkii Assembly Manual Marine Compatibility with Devices
 - Mki Mkii Assembly Manual Marine Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Mki Mkii Assembly Manual Marine
 - Highlighting and Note-Taking Mki Mkii Assembly Manual Marine
 - Interactive Elements Mki Mkii Assembly Manual Marine
- 8. Staying Engaged with Mki Mkii Assembly Manual Marine
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Mki Mkii Assembly Manual Marine
- 9. Balancing eBooks and Physical Books Mki Mkii Assembly Manual Marine
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Mki Mkii Assembly Manual Marine
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Mki Mkii Assembly Manual Marine
 - Setting Reading Goals Mki Mkii Assembly Manual Marine
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Mki Mkii Assembly Manual Marine

- Fact-Checking eBook Content of Mki Mkii Assembly Manual Marine
- Distinguishing Credible Sources

13. Promoting Lifelong Learning

- Utilizing eBooks for Skill Development
- Exploring Educational eBooks

14. Embracing eBook Trends

- Integration of Multimedia Elements
- Interactive and Gamified eBooks

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