

<b>TECHNICAL DATA</b>	
<b>ENGINE</b>	<b>250 SXF</b>
Design	Liquid-cooled single cylinder 4-stroke engine
Displacement	249.51 ccm
Bore/Stroke	76 / 55 mm
Ratio	12.8 : 1
Fuel	unleaded fuel with at least RON 95
Valve timing	4 valves controlled by finger levers and 2 camshafts, driven by a pair of spur gears and a tooth-type chain
Camshaft	05
Valve diameter Intake	30.9 mm
Valve diameter Exhaust	26.5 mm
Valve clearance cold Intake	0.10 - 0.15 mm
Valve clearance cold Exhaust	0.15 - 0.20 mm
Crank shaft bearing	2 cylinder roller bearings
Connecting rod bearing	needle bearing
Top end bearing	bronze bushing
Piston	aluminium alloy forged
Piston rings	1 compression ring, 1 oil scraper ring
Engine lubrication	pressure circulation lubrication with 2 rotor pumps
Engine oil	full synthetic oil (Motorex Power Synt 4T 10W/50)
Quantity of engine oil	1.1 liters
Primary drive	22:68
Transmission claw shifted	6-speed
1st gear	13:32
2nd gear	15:30
3rd gear	17:28
4th gear	19:26
5th gear	21:25
6th gear	22:24
Ignition system	contactless DC-CDI ignition with digital advanced system by KOKUSAN
Generator	no generator
Spark plug	NGK CR 9 EBK
Cooling system	liquid cooled, permanent rotation of cooling liquid through mechanically driven water pump
Cooling liquid	1.2 liters, 50% antifreeze, 50% water, at least -25° (-13° F)

<b>BASIC CARBURATOR SETTING</b>	
	<b>250 SXF</b>
Type	Keihin FCR-MX 3925D
Main jet	168
Jet needle	OBETP
Idling jet	40
Main air jet	200
Idling air jet	100
Needle position	5 <sup>th</sup> from top
Starting jet	85
Mixture control screw open	1.25
Slide	15
Performance restrictor	–
Stop pump membrane	858 / 2.15 mm
Hot start device	2.5 mm

**TIGHTENING TORQUES – ENGINE 250 SXF**

Hexagon collar screw, engine case, clutch cover, ignition cover, water pump cover	M6	10 Nm
Oil drain plug	M12x1.5	20 Nm
Allen head plug, oil screen short	M16x1.5	Oil + 10 Nm
Hexagon plug, oil screen long	M20x1.5	15 Nm
Collar screw for oil filter cover	M5	6 Nm
Plug pressure valve	M12x1.5	20 Nm
Screws, oil pump cover	M5	Loctite 222 + 6 Nm
Hexagon collar screw, cylinder / cylinder head	M6	10 Nm
Cylinder head screw	M10	Oil + 40/50 Nm
Hexagon collar screw, exhaust flange	M6	Loctite 243 + 10 Nm
Hex.collar screw, cylinder head top section	M6	10 Nm
Camshaft screw	M12x1	Loctite 243 + 80 Nm
Collar screw/nut camshaft bearing support	M7	Oil + 18 Nm
Hexagon nut, primary gear	M18x1.5	Loctite 243 + 150 Nm
Nut for inner clutch hub	M18x1.5	Loctite 243 + 120 Nm
Hexagon collar screw, clutch spring	M6	10 Nm
Allan head screw, shift roller locking piece	M6	Loctite 243 + 10 Nm
Hexagon collar screw, locking lever	M5	Loctite 243 + 6 Nm
Locking screw for shift roller bearing	M6	Loctite 243 + 8 Nm
Locking screw for main shaft bearing	M6	Loctite 243 + 8 Nm
HH collar screw clip/tensioning rail	M6	Loctite 243 + 10 Nm
Plug for chain tensioner	M24x1.5	25 Nm
Hexagon collar screw, stator SX	M5	Loctite 243 + 6 Nm
Hexagon collar screw, pulser coil	M5	Loctite 243 + 6 Nm
Hexagon collar nut, flywheel	M12x1	60 Nm
Hexagon collar screw, bump part kickstarter	M6	Loctite 243 + 10 Nm
Cable retaining bracket (ignition)	M6	Loctite 243 + 6 Nm
Allan head screw, kickstarter	M8	Loctite 243 + 25 Nm
Hexagon collar screw, shift lever	M6	Loctite 243 + 10 Nm
Hexagon screw, engine sprocket	M10	Loctite 243 + 60 Nm
Spark plug	M10	10-12 Nm