



JANUARY, 1966

SERVICE SHEET

No. 124

MODEL B44 VICTOR ENDURO
TECHNICAL DATA.

ENGINE

Capacity (cc)	441
Cylinder bore (mm)	79
Stroke (mm)	90
Compression ratio	9.4
<u>Valve timing</u> (at .015" tappet clearance)	
inlet opens B.T.D.C.	51°
" closes A.B.D.C.	68°
exhaust opens A.B.D.C.	78°
" closes A.T.D.C.	37°
<u>Tappet clearance</u> (running)	in. .008" ex. .010"
<u>Piston ring width</u>	
compression (in)	1/16
scraper (in)	1/8
<u>Piston ring gaps</u>	
maximum (in)	.014
minimum (in)	.009
<u>Spark plug</u>	Champion N64Y
<u>Plug points gap</u>	.020" min. .025" max.
<u>Ignition setting</u> (17/64")	28° B.T.D.C. FA.
<u>Contact breaker gap</u>	.015"

Continued.....

TORQUE WRENCH SETTINGS

Crankpin nuts	200 lb. ft.
Oil pump stud nuts	7 " "
Clutch centre nut	60/65 " "
K/S ratchet nut	60 " "
Rotor fixing nut	60 " "
Stator fixing nuts	10/15 " "
Crankshaft pinion nut	60 " "
Carburetter flange nuts	10 " "

TRANSMISSION

Gear ratios - top	5.36
third	6.70
second	8.84
first	14.20
Sprocket sizes - engine	28T
clutch	52T
gearbox	18T
rear wheel	52T
Chain sizes - front	$\frac{3}{8}$ " x 70 pitches, DUPLEX
rear	$\frac{1}{2}$ " x 127 pitches.

CAPACITIES

Fuel tank	2 $\frac{1}{2}$ US.GAL.
Oil tank	6 " PINTS
Gearbox	.6 " "
Front fork (each leg)	.4 " "
Primary chaincase	.3 " "

SERVICE SHEET NO.124 (CONT'D.3.)

CARBURETTER SETTINGS

Bore	1.5/32"
Main jet	330
Pilot jet	25
Throttle valve	3½
Needle position	3
" jet	.106

BEARING DIMENSIONS

Big-end roller	.250" dia. x .250"
Big-end bush (bore)	1.7701"/1.7706"
Small-end bush (bore)	.7503"/.7506"
Gudgeon pin (dia.)	.750"/.7502"
Gearside crankshaft bearing	25 x 62 x 17 mm. (Hoffman 325)
Driveside " "	25 x 62 x 17 mm. (Ransome & Marles MRTA 25)
Shaft dia. (G/S & D/S)	.9841"/.9844"
Clutch rollers (25)	.1875" x .1875"
Gearbox mainshaft diameters -	
gearside	.6245"/.625"
driveside	.7485"/.749"
Gearbox sleeve pinion	
internal dia.	.752"/.753"
external "	1.179"/1.180"
Gearbox mainshaft bearing (D/S)	30 x 62 x 16 mm (Hoffman 130)
" layshaft bearings (D/S & G/S)	needle roller (Torrington B108)
" mainshaft bearing (G/S)	5/8" x 1.9/16" x 7/16" (Hoffman LS7)
" layshaft diameters (D/S & G/S)	.6245"/.625"