

### Piston Clearance Chart

350	Pioneer	0.0025
350	M.A.R	0.002
250	Pioneer	0.002
250	Stiletto MX	0.0025
250	Stiletto TT-DMR	0.003
250	Pioneer Mar	0.0015
250	Phantom	0.0025
175	Pioneer	0.002
175	Stiletto MX	0.003
175	Phantom	0.0025
125	MX & Phantom	0.003

Ring End Gap      Stock OSSA Piston .075-.085

Clearances:	OSSA Engineering Setting	Factory Setting
Crank	.006-.010	.004-.008
Mainshaft	.028-.032	.020-.035
Layshaft	.006-.010	.010-.015
Shift Drum	.006-.010	.008-.012
Kickstart Shaft	.060-.080	
Shift Fork to Drum	.015-.025 AT FINGERS	

### Torque Specs:

Head	180 INCH LBS in 3 steps 60/120/180
Mag	60 FT LBS
Clutch Hub	65-70 FT LBS
Primary Drive	65-70 FT LBS
Front Cases Bolt	150 INCH LBS

## PRIMARY CHAIN ADJUSTEMENT

AS-77 GP-3

8-9 mm NEW  
ASSEMBLY  
12-13 mm AFTER  
RUN-IN IS OK