

# Haflinger Technik Ltd

Service Information

October 2017

## Haflinger Engine Settings

### Torque Settings

- 4 x M12 Bolts on Crankcase – 29 ft/lb
- Conrod Bolts – 22 ft/lb
- Cylinder Head Bolts – 20 ft/lb
- Flywheel Nut – 230 ft/lb
- Vee Pulley Nut – 87 ft/lb

### Pistons

- Fit rings with lettering facing crown of piston.
- Groove clearance of new rings = 0.15mm for 1<sup>st</sup> & 2<sup>nd</sup> rings, 0.1mm for Oil scraper.
- Ring Gap 20mm into bore = 0.3 – 0.45mm when new. Wear limit 1.0mm
- Narrow side of piston to thrust, ie, RHS UP & LHS DOWN.

### Cylinder Head

- Tappet Clearance = 0.15mm cold
- Fit valve springs with closer coil to head
- Rockershaft springs have washer each end
- Spark Plug Gap = 0.6 – 0.7 mm

### Conrods

- Do not interchange
- Line up oil hole on conrod & shell
- Weigh conrods – must be within 5 grammes
- Small end wear max 0.05mm
- Oil holes must point to thrust side of piston, ie, RHS UP & LHS DOWN
- Use 2 feeler guages set at 0.15mm – 0.25mm to align caps

### **Camshaft**

- Check number stamped on shaft between lobes.

### **Crankshaft**

- "N" stamped on web denotes Nitrated crank
- Check crank end float. If insufficient, add paper gaskets between flywheel & crank.

### **Distributor**

- To install, RHS valves in overlap position & TDC marks aligned. Line up dist finger with mark on housing and install.
- Lube pad with HMP grease.
- Points gap 0.4 mm
- Timing 6 – 7mm before TDC