

Carburetor 230, AQ131

Type	Down draught
Designation	Model 44 PAI-5
Venturi	34
Main jet	165
Idling jet	65
Air jet	185
Needle valve	1.7
Float, weight in grams (oz's)	7.3 (0.26)
Acceleration jet	70
Econostat jet	110

AQ131A, 131B

Type	Down draught
Designation	Model 44 PAI-5
Venturi	34
Main jet	165
Idling jet	65
Air jet	185
Needle valve	1.7
Float, weight in grams (oz's)	7.3 (0.26)
Acceleration jet	70
Econostat jet	110

AQ131C,131D, 230

Type	Down draught
Designation	Model 44 PAI-7
Venturi	34
Main jet	165
Idling jet	65
Air jet	185
Needle valve	2.0
Float, weight in grams (oz's)	7.3 (0.26)
Acceleration jet	70
Econostat jet	110

Carburetor 250, AQ151

Type	Down draught
Designation	Model 44 PAI-4
Venturi	31
Main jet	145
Idling jet	62
Air jet	185
Needle valve	1.5
Float, weight in grams (oz's)	7.3 (0.26)
Acceleration jet	60
Econostat jet	—

AQ151A, AQ151B

Type	Down draught
Designation	Model 44 PAI-4
Venturi	31
Main jet	145
Idling jet	62
Air jet	185
Needle valve	1.5
Float, weight in grams (oz's)	7.3 (0.26)
Acceleration jet	60
Econostat jet	—

AQ151C, AQ151D, 250

Type	Down draught
Designation	Model 44 PAI-7
Venturi	31
Main jet	145
Idling jet	62
Air jet	180
Needle valve	1.7
Float, weight in grams (oz's)	7.3 (0.26)
Acceleration jet	60
Econostat jet	—

Carburetor 251DOHC, AQ171

Type	Down draught
Designation	Model 44 PAI-5-6
Venturi	32
Main jet	147
Idling jet	65
Air jet	190
Needle valve	1.7
Float, weight in grams (oz's)	7.3 (0.26)
Acceleration jet	70
Econostat jet	—

AQ171A, AQ171B

Type	Down draught
Designation	Model 44 PAI-5-6
Venturi	32
Main jet	147
Idling jet	65
Air jet	190
Needle valve	1.7
Float, weight in grams (oz's)	7.3 (0.26)
Acceleration jet	70
Econostat jet	—

AQ171C, AQ171D, 251DOHC

Type	Down draught
Designation	Model 44 PAI-7
Venturi	32
Main jet	147
Idling jet	60
Air jet	200
Needle valve	1.7
Float, weight in grams (oz's)	7.3 (0.26)
Acceleration jet	70
Econostat jet	—

Electrical system**Battery**

Grounding	Negative
Voltage	12 Volts
Capacity	60 Ah
Specific weight of the electrolyte	
Fully charged battery	1.275–1.285 grams/cm ³ (0.0460–0.0464 lb/cu.in.)
Discharged battery	1.230 grams/cm ³ (0.0444 lb/cu.in.)

Starter motor

Output	0.8 kW (1.1 hk)
--------------	-----------------

Alternator

Output, maximum Amp (W)	50 (14x50)
-------------------------------	------------

Ignition system

Cylinder marking	No 4 closest to the flywheel
Spark plugs 230, 250, AQ131, AQ151	Part no 875820-3, Bosch W6DC or its equivalent
Spark plugs, 251DOHC, AQ171	Part no 876077-9, Bosch WR6DC or its equivalent
Spark plug gap	0.7 mm (0.0276")

Distributor 230, 250, AQ131, AQ151

Type Breaker point system
Type Bosch JF4 0231 178 019

Setting for regular gasoline, min 91 octane ROT:

USA: Ignition setting for regular petrol (RON+MON)/2 = min 87 octane
Basic setting 6° BTDC (0–14.17 r/s = 0–850 rpm)
Stroboscope setting 32–36° BTDC (70 r/s = 4200 rpm)
Contact gap 0.40 mm (0.01575")
Dwell angle 62±3°

Distributor, 251DOHC, AQ171

Type Bosch TVX4, Breakerless system A 237 540 079

Setting for regular gasoline, min 91 octane ROT:

USA: Ignition setting for regular petrol (RON+MON)/2 = min 87 octane
Basic setting 10° BTDC (0–15 r/s = 0–900 rpm)
Stroboscope setting (not adjustable) 23–25° BTDC (73.33 r/s=4400 rpm)

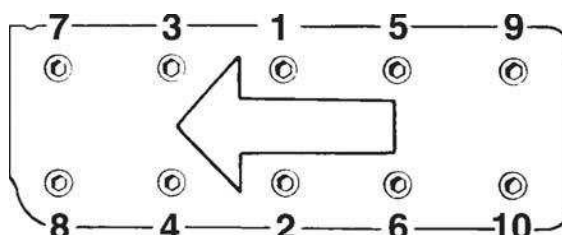
Cooling system

Thermostat

Type Wax thermostat
Starts opening at 82°C (179.6°F)
Fully open at 92°C (197.6°F)

Tightening torques

NOTE! Always tighten the cylinder head bolts when the engine is cold. The torque values are valid for bolts and nuts being well oiled prior to installation. Parts having been washed should be oiled prior to the assembly.



Tightening torque for cylinder head bolts:

The cylinder head: To be tightened in stages 1 = 20 Nm (2.0 kpm) (15 ft.lbs.)
..... 2 = 40 Nm (4.0 kpm) (29 ft.lbs.)
..... 3 = Angle tighten through 120° in one operation!

- Replace the cylinder head bolts if they show signs of being stretched. If a bolt is “stretched” can clearly be seen on the “waist” of the bolt, which is then elongated.
 - The cylinder head bolts can be “re-used” max 5 times.
- Replace the bolts if you feel uncertain on any of these points.



	Nm	Kpm	Ft.lbs.
Main bearings	110	11.0	79.5
Crank bearings, 1st stage ¹⁾	20	2.0	15
2nd stage ¹⁾	through 90°		
Flywheel (use new bolts)	70	7.0	51
Spark plugs (do not oil them!)	25±5	2.5±0.5	18
Camshaft gear	50	5.0	36
Intermediate gear	50	5.0	36
Camshaft bearing cap	20	2.0	15
Crankshaft, center bolt pulley, stage 1	60	6.0	43
stage 2	Angle tighten through 60°		

¹⁾ Old bolts can be used provided the length does not exceed 55.5 mm (2.185”).