SPECIFICATIONS

Model Numbers	2R72
*Horsepower (B.I.A.-certified)	2 HP at 4500 rpm
Full throttle operating range	4200 to 4800 RPM
Test tank with test wheel	4000 RPM
Test wheel	Part Number 316021
Engine type	Single cylinder, 2 cycle
Bore and stroke	1-9/16" bore x 1-3/8" stroke
Piston displacement	2.64 cubic inches
Piston ring sets (2 per set)	
Standard	Part Number 383920
.030" oversize	Part Number 384312
Diameter of ring	1.563 in. (standard)
Width of ring	.0625 - .0615 in.
Lbs. compression recommended when compressed	1.3 to 2.8 lbs.
Piston and rings - standard	Part Number 384651
.030" oversize piston less rings	Part Number 384666
Crankshaft size	
Top journal	.7502 - .7497 in.
Bottom journal	.7502 - .7497 in.
Connecting rod crank pin	.6690 - .6685 in.
Carburetion	Single barrel float feed, with high and low-speed adjustments
Float level setting	Flush with casting
Inlet needle seat	.050 - .053 Use a #55 drill as gage
Cooling system	Vari-volume pump
Propeller gear ratio	12:25
Propeller drive pin	Part Number 203230
Propeller	7-1/4 x 4-1/2
Speed control	Single lever, synchronized throttle and spark
Weight	24 lbs.
Fuel capacity	Gravity feed integral tank 1 qt.
Starter	Manual self rewinding
Ignition	Flywheel magneto
Spark plug	AC-M44C, Champion J6J - 14mm
Spark plug gap	.030 inch
Spark plug torque	17-1/2 - 20-1/2 foot-pounds
Breaker point gap	.020 inch
Condenser	Part Number 580321
Capacity	.18 to .22 Mfd.

Part No. 580416 Coil Test Specifications
Old Stevens Tester

Switch	Index Reading
A	2. to 2.5

New Stevens Tester Model No. M.A. -75

Switch	Index Adjustment
A	22

Merc-O-Tronic

Operating Amperage	Primary Resistance		Secondary Continuity	
	Min.	Max.	Min.	Max.
1.4	.45	.55	35	45

Graham Tester Model 51

Maximum Secondary	Maximum Primary	Coil Index	Minimum Coil Test	Gap Index
5500	1.2	75	33	70

* Horsepower established at sea level. Allow 2% reduction per 1000' above sea level.

CLEARANCE CHART

Power head	
Piston ring gap	.015 max. - .005 min.
Piston ring - groove	.0040 max. - .0020 min.
Cylinder and piston	.0055 max. - .0043 min.
Crankshaft	
Upper	Needle bearing
Lower	Needle bearing
Connecting rod	
Piston end	.0011 max. - .0004 min.
Crankshaft end	Needle bearing
Lower unit	
Driveshaft and bushing in gear case	.0028 max. - .0010 min.
Gearcase head and propeller shaft	.0022 max. - .0007 min.
Propeller on shaft	.0057 max. - .0022 min.
Gearcase bushing to propeller shaft	.0022 max. - .0007 min.

TORQUE CHART

Power head	
Flywheel nut	22 - 25 foot-pounds
Connecting rod screws	60 - 66 inch-pounds
Cylinder head screws	60 - 80 inch-pounds
Manifold to crankcase screws	60 - 80 inch-pounds
Bearing housing to cylinder screws	60 - 80 inch-pounds
Spark plug	17-1/2 - 20-1/2 foot-pounds
Lower unit	
Pull at propeller shaft to tilt up lower unit	11 - 14 lbs.

SCREW TORQUE

Torque should be used on the following sizes unless otherwise specified.

Standard screws

	Inch-Pounds	Foot-Pounds
No. 6	7-10	
No. 8	15-22	
No. 10	25-35	2-3
No. 12	35-40	3-4
1/4"	60-80	5-7
5-16"	120-140	10-12
3/8"	220-240	18-20

NOTE

When tightening two or more screws on the same part, DO NOT tighten screws completely, one at a time. To avoid distortion of the part, first tighten all screws together to one-third of specified torque, then to two-thirds of specified torque, then torque down completely.

Re-torque cylinder head screws and spark plugs after motor has been run and has reached operating temperature, and has cooled comfortable to touch.