



# YOSHIMURA

## SPECIAL PARTS TECHNICAL SERVICE MANUAL

### SUZUKI 2001-03 GSX-R1000K1/K2/K3

### ST-1 CAMSHAFT (PART NO.SUXR-481)

This product is designed for racetrack use only. Do not use on the public road.

- Be sure to carefully read the instruction manual before starting installation.
- During installation, keep these instructions at hand and proceed with the work in accordance with the instructions.
- These instructions should be retained until the product is scrapped.

**⚠ Danger** : Indicates a potential hazard that could result in death or injury.

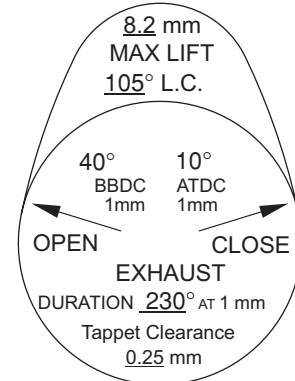
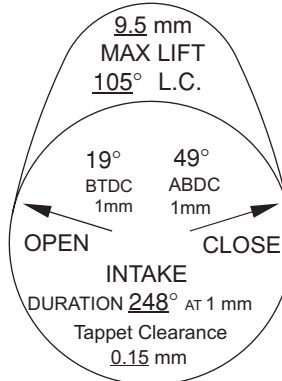
**⚠ Caution** : Indicates a potential hazard that could result in motorcycle damage.

(Reference) : Indicates special information for smooth work.

#### ● KIT contents

- Intake camshaft X 1
  - Exhaust camshaft X 1
- (Including Cam Sprockets, Flanges, Bolts)

#### ● Cam Profile



✘ This product is only intended for use with the model & year listed below.

#### ● Applicable model

SUZUKI GSX-R1000K1/K2/K3 (01-03)

✘ To remove, install and adjust valve lash for camshafts use the SUZUKI genuine service manual procedures.

#### ⚠ Caution

During the disassembling procedure do not drop any parts into the crankcase. All removed parts should be thoroughly cleaned and dried.

#### Inspections

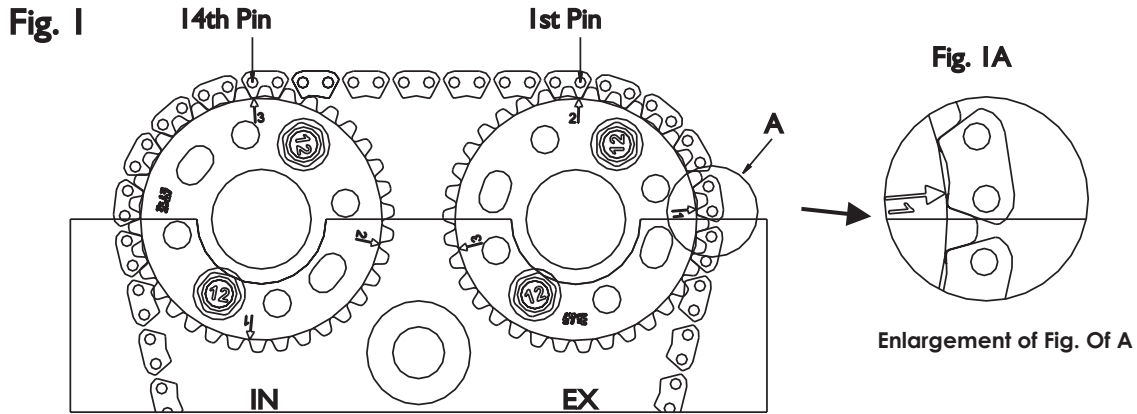
##### Check Items:

- Wear and damage to valve retainers, valve cotter pins, valve springs, spring seats and lifter buckets.
- Wear, damage and looseness of valves and valve guides.
- Surface contact positions and contact width of valve seats.
- Wear and damage to cylinder head camshaft journals.

#### ⚠ Danger

Parts inspection and replacement of consumable parts must be done correctly, otherwise it may cause serious damage to the engine.

✘ Other than mentioned, please inspect each part in accordance with the SUZUKI genuine service manual



**Danger** An arrow marked "1" on the exhaust cam sprocket and the cam chain pin should point flush with cylinder head gasket surface (See Fig.1 and Enlarged Fig. of A)

**Caution** Tappet clearances must be adjusted to the specifications supplied below.

#### Tappet Clearances with Engine Cold

INTAKE: 0.13 ~ 0.17mm

EXHAUST: 0.23 ~ 0.27mm

#### Break-in

1. Put in a specified amount of new engine oil.  
(Reference) Use engine oil higher than API-SF grade and SAE 10W-40~15W-50.
2. With the spark plugs removed spin the crankshaft to lubricate the engine by using the electric starter.

**Caution** The starter motor must be used intermittently to prevent starter motor damage.

3. Leave the machine for several minutes and check the oil level. If the level is low add suitable amount of oil.
4. Install the spark plugs.
5. Start the engine. Inspect work for oil leakage. Once the engine has reached operating temperature adjust idle.
6. Up to 100km, engine RPM should not exceed 4000RPM
7. Until 200km, engine should not exceed 5000RPM, and up to 300km engine RPM should not exceed 6000RPM.

**Caution** During the break-in procedure, heavy loading action such as sudden starts and rapid acceleration should be avoided.

8. Once the break-in procedure has been completed, check tappet clearances and adjust as necessary. Check that there are not irregular noises from the engine. If an irregular sound is heard disassemble the engine and inspect.

**Caution** During normal start-up after camshaft break-in has been completed engine oil must reach normal operating temperature before applying load to the engine.

#### ○ After the installation

Quality control is implemented in all products. If, however, any defects or failure should be found please notify Yoshimura Japan (Yoshimura-RD in the US) through the selling dealer. Necessary technical service or replacement will be made. Prices and Specifications are subject to change without notice.

YOSHIMURA JAPAN Co., LTD  
6748 Nakatu, Aikawa, Aiko, Kanagawa 243-0303 Japan  
Phone +81-46-286-0321 FAX +81-46-286-1919  
Email: yj-world@netmove.co.jp

YOSHIMURA-RD of America Inc.  
5420 Daniels Street Suite A, Chino, CA 91786  
Phone 1-800-634-9166 FAX 909/591-2198  
Email: sales@yoshimura-rd.com