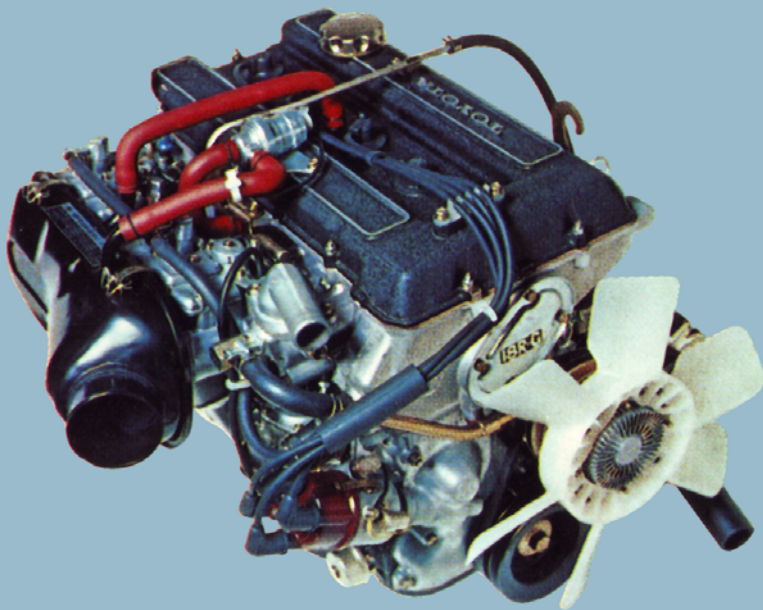




TOYOTA

18R-G CHEAT SHEET



DOHC 1968cc 145ps

VARIANTS

18R-G

POWER	145 PS @ 6,400 RPM
TORQUE	130 FT-LB @ 5,200 RPM
HEAD	11111-88210 SMALLEST VALVES
CAMS	1351-88210 MOST AGGRESSIVE / 3-BOLT
PISTONS	9.7:1 88210, 88233 & 88252
CARBURETOR	DUAL SOLEX 40 MM

18R-GR

POWER	140 PS @ 6,400 RPM
TORQUE	124 FT-LB @ 4,800 RPM
HEAD	11111-88230 SMALLEST VALVES
CAMS	1351-88231 SLIGHTLY LESS AGGRESSIVE / 3-BOLT
PISTONS	8.5:1 88232
CARBURETOR	DUAL SOLEX 40 MM

18R-GU

POWER	130 PS @ 5,800 RPM
TORQUE	123 FT-LB @ 4,400 RPM
HEAD	11111-88253 LARGE VALVES / DOUBLE VALVE SPRINGS
CAMS	1351-88251 LESS AGGRESSIVE / 1-BOLT (ADJUSTABLE)
PISTONS	8.3:1 88251
CARBURETOR	DUAL SOLEX 40 MM

18R-GEU "DOHC" CAM COVER

POWER	135 PS @ 5,800 RPM
TORQUE	127 FT-LB @ 4,800 RPM
HEAD	11111-88270 LRG. VALVES / DBL. SPRINGS / STRONGEST HEAD
CAMS	1351-88270 LEAST AGGRESSIVE / 1-BOLT (ADJUSTABLE)
PISTONS	8.3:1 88270
EFI	FUEL ONLY

OVERVIEW

CYLINDERS	4
CAPACITY	1968 CC 88.5 MM BORE 80 MM STROKE
BLOCK	STEEL SAME AS 18R BLOCK EXCEPT: • OIL DIPSTICK ON LHS • ENGINE NO. IS UPSIDE-DOWN
HEAD	ALUMINIUM HEMISPHERICAL COMBUSTION CHAMBER ALL 18R-G HEADS ARE YAMAHA DESIGNED
VALVETRAIN	DOHC
VALVES	8 BUCKET OVER SHIM 13.8 MM FLAT SHIMS
TIMING	CHAIN DOUBLE-ROW

NOTES

THE 18R-G IS A NON-INTERFERENCE MOTOR (PISTONS HAVE VALVE-RELIEFS CUT OUT).
BE CAREFUL NOT TO TURN CAMS INDEPENDENTLY, AS VALVES CAN COLLIDE.
18R "FLAT-TOP" PISTONS ARE 8.5:1 WHEN USED WITH THE SOHC HEAD, BUT WOULD BE LOWER IF USED WITH A DOHC 18R-G HEAD.

TUNE-UP

SPARK PLUGS	BPR-6EZ 0.9 - 1.0 MM GAP - CAN ALSO USE "BPR-5EY-11"
LEADS	NGK RC-TE94
DWELL ANGLE	50 - 54°
POINT GAP	0.45 MM
IGN. TIMING	15° BTDC @ 1000 RPM
FIRING ORDER	1-3-4-2
VALVE CLEARANCE	(COLD)
INTAKE	0.26 - 0.32 MM
EXHAUST	0.31 - 0.36 MM
COMP. PRESSURE	
STANDARD	184.6 PSI
LIMIT	142.0 PSI
MAX. DIFFERENCE	14.2 PSI
PISTON RINGS	
18R-G, 18R-GR, 18R-GU, (18R-GEU)	
TOP COMP. RING	2.0 MM (1.5 MM)
2ND COMP. RING	2.5 MM (1.5 MM)
OIL RING	4.0 MM
OIL	20W-60 EG: PENRITE HPR30
OIL FILTER	90915-YZZD2 USE GENUINE TOYOTA FILTER