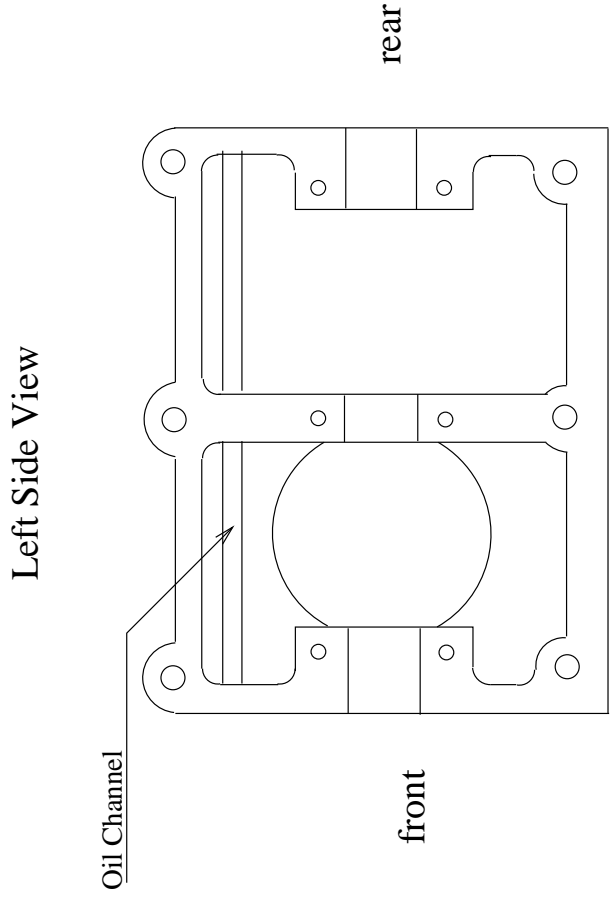
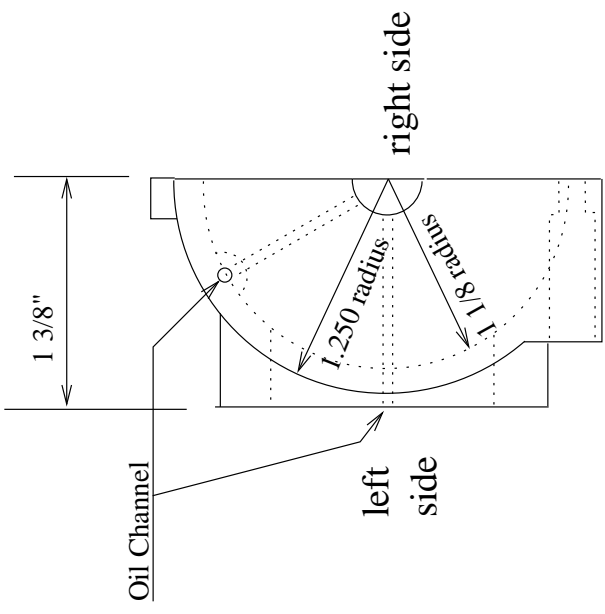
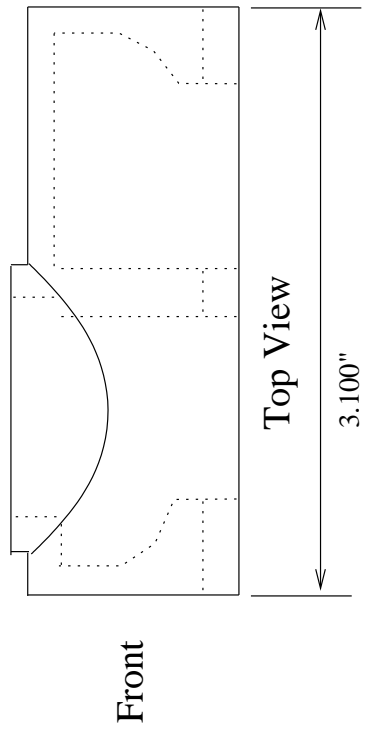
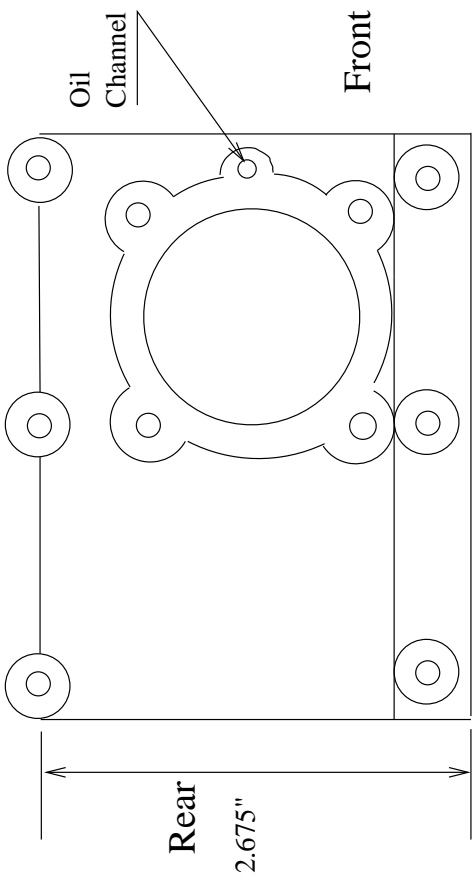


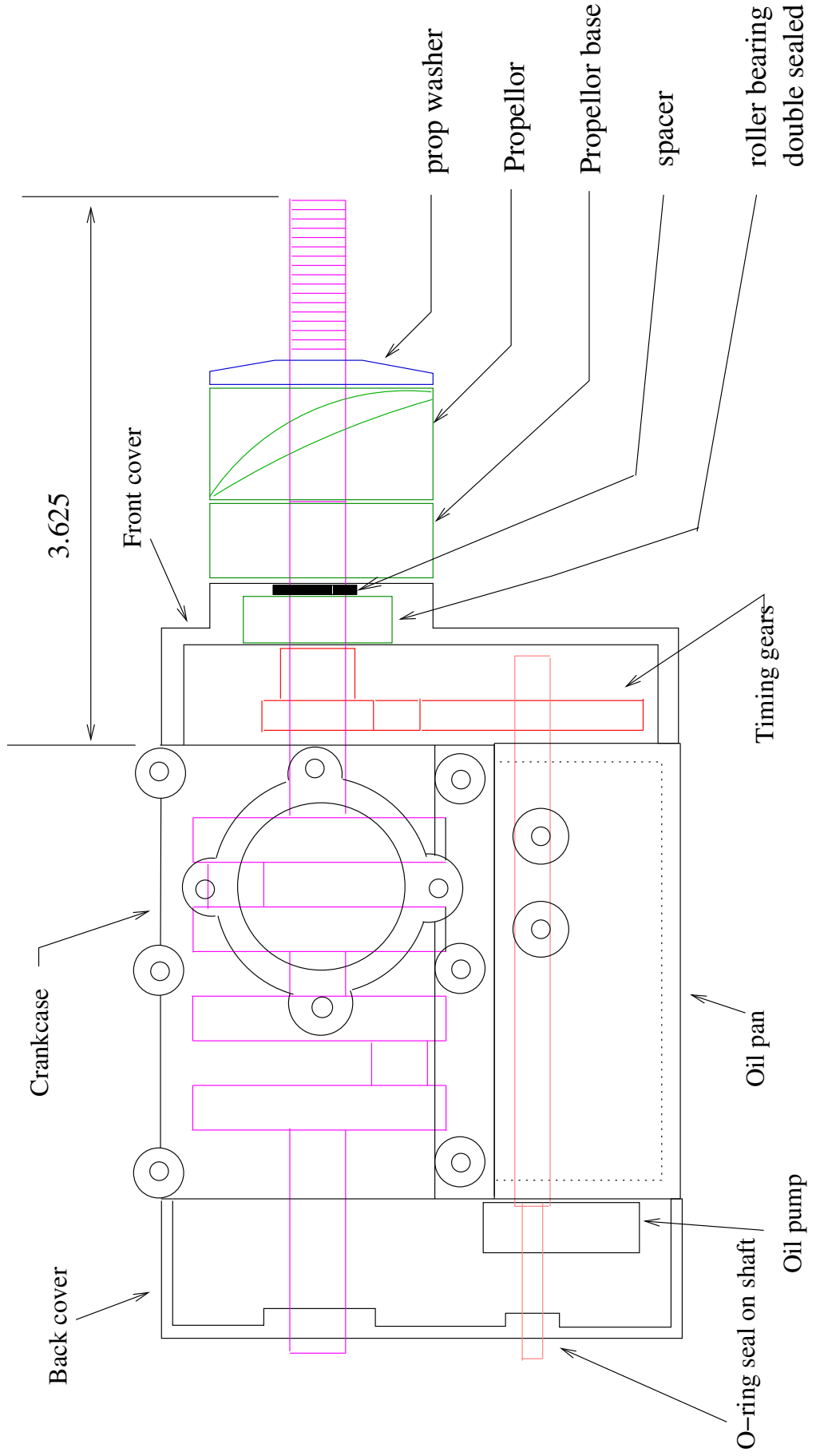
This is the Saito timing  
 Saito FA200Ti cam timing:  
 opens closes  
 intake : 40 btdc 60 abdc  
 exhaust : 75 btdc 25 atdc  
 65 deg. overlap

View from front of camshaft  
 BECO 2.0 Cam. lobe timing

Intake Lobe on Cam  
 Exhaust Lobe on Cam



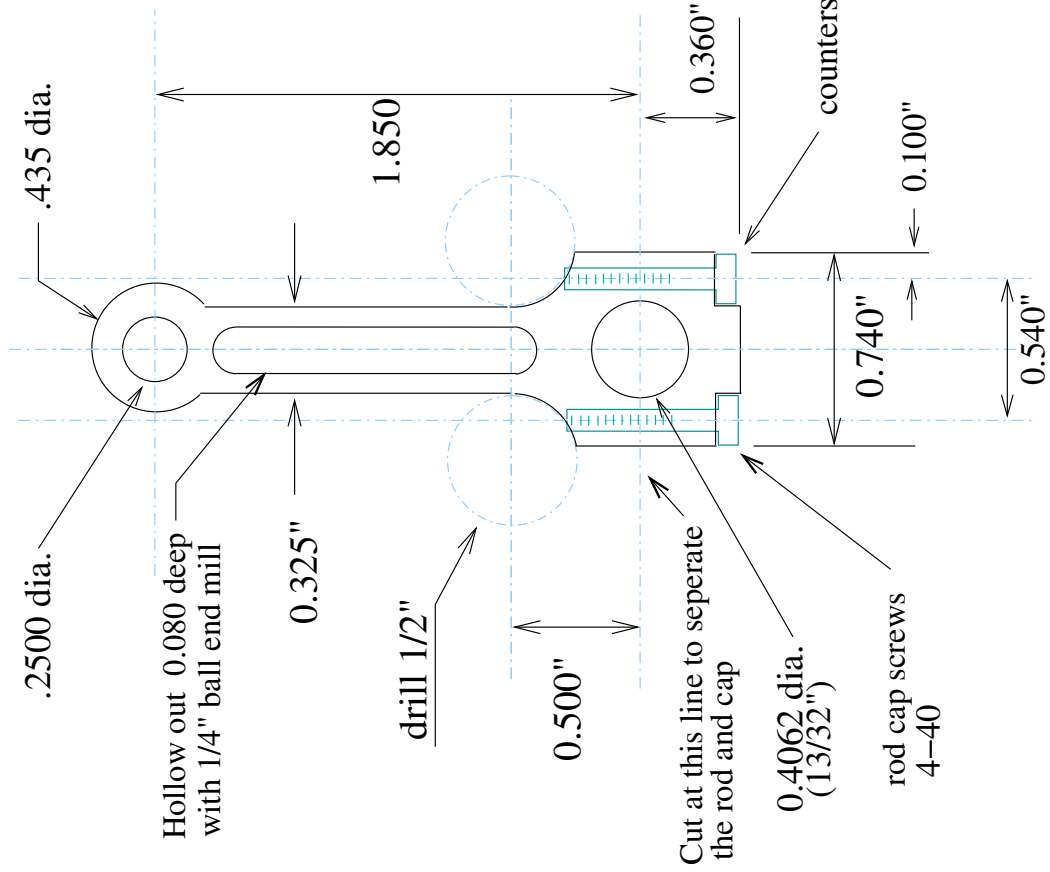




## Step by step directions for making a rod

Material: 6061 aluminum, 1/4" thick

- 1 – Cut a blank 0.75 wide by 3 inches long from 0.250 thick plate.
- Mount the blank in the mill vise – vertical.
- 2 – drill 2 holes for the rod cap screws 3/4 inch deep.
  - Countersink .100" with a 3/16 endmill.
- 3 – cut the cap off from the rod.
- 4 – mill the ends of the rod and cap flat and **SQUARE!** (this step is not necessary if the cap is cut accurately.)
- 5 – size cap to 0.360" and tap threads (4–40) in the rod.
- 6 – drill out the rod cap for screw clearance (7/64).
- 7 – attach rod cap to rod blank and mount flat in the mill.
- 8 – drill and ream the hole for the big end.
- 9 – drill and ream the hole for the small end.
- 10 – drill the holes for the sholder radius', use a 1/2" endmill.
- 11 – cut (using an end mill) the straight sides.
- 12 – put the rod on the rotary table and round the small end.

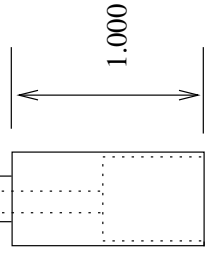


This drawing not drawn to scale





0.125 drill through for valve stem  
raised 0.050" to fit inside valve spring



outside dia. same as  
valve dia + 0.015

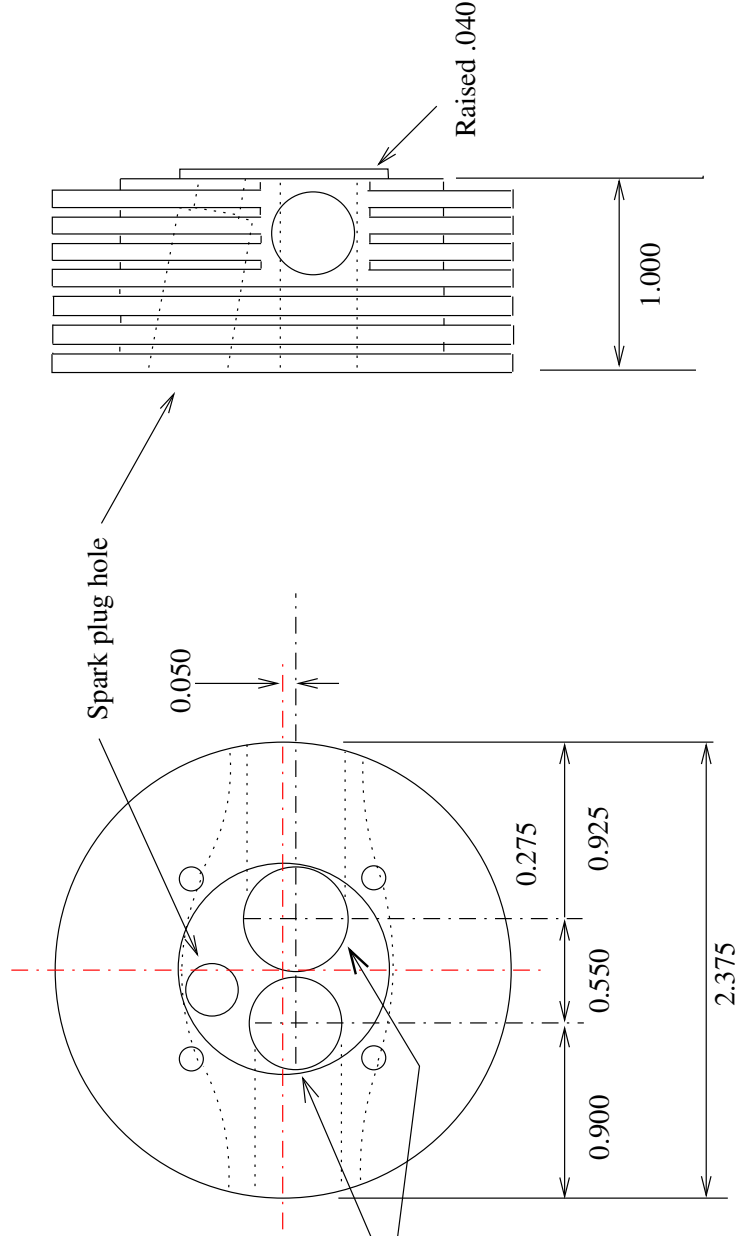
Bore to same as port bore

### Valve Guide detail

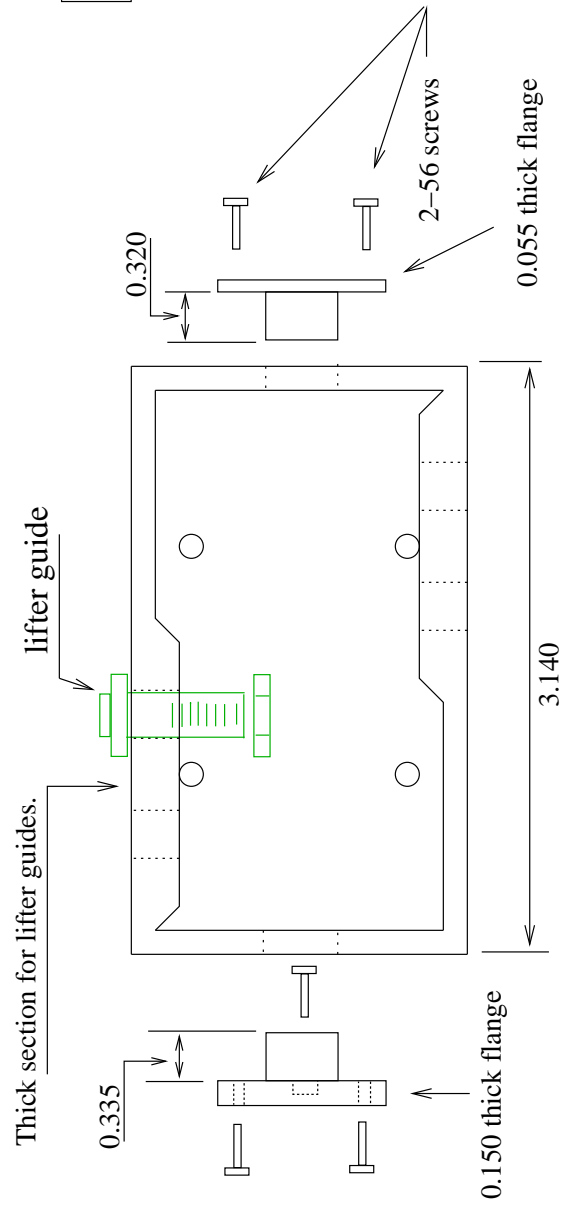
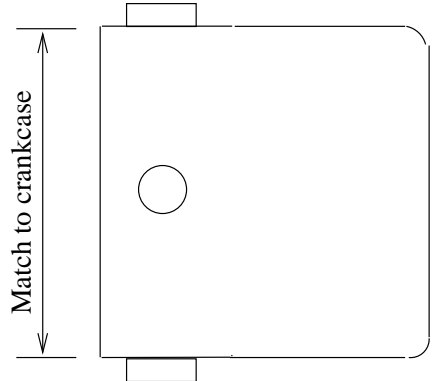
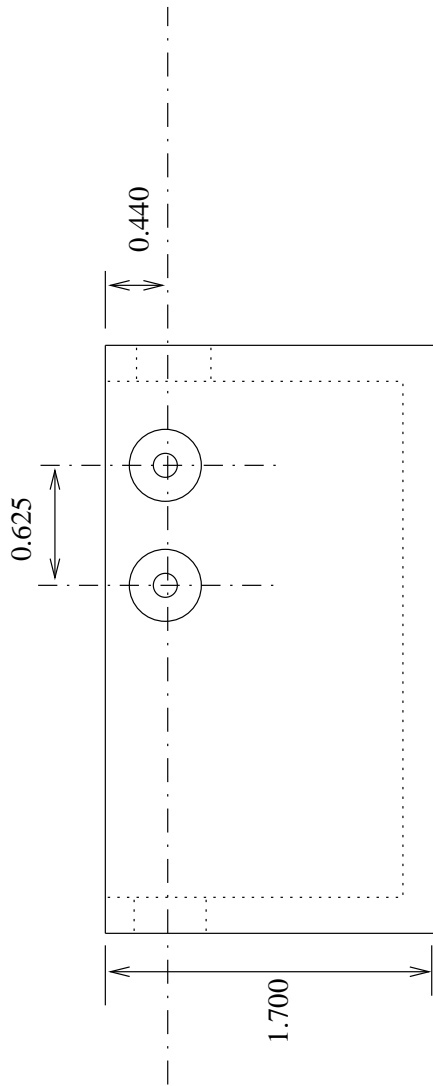
Cylinder head is made from 2.5" 6061 aluminum bar stock  
Cooling fins are evenly spaced. Cut with 1/16" wide cutter.  
Spark plug threads are 1/4-32

**Note: Make left and right side heads**  
intake to rear, exhaust to front.

ex. valve dia: 0.488    Port bore: 0.438  
in. valve dia: 0.550    Port bore 0.500



Bore through for valve guide

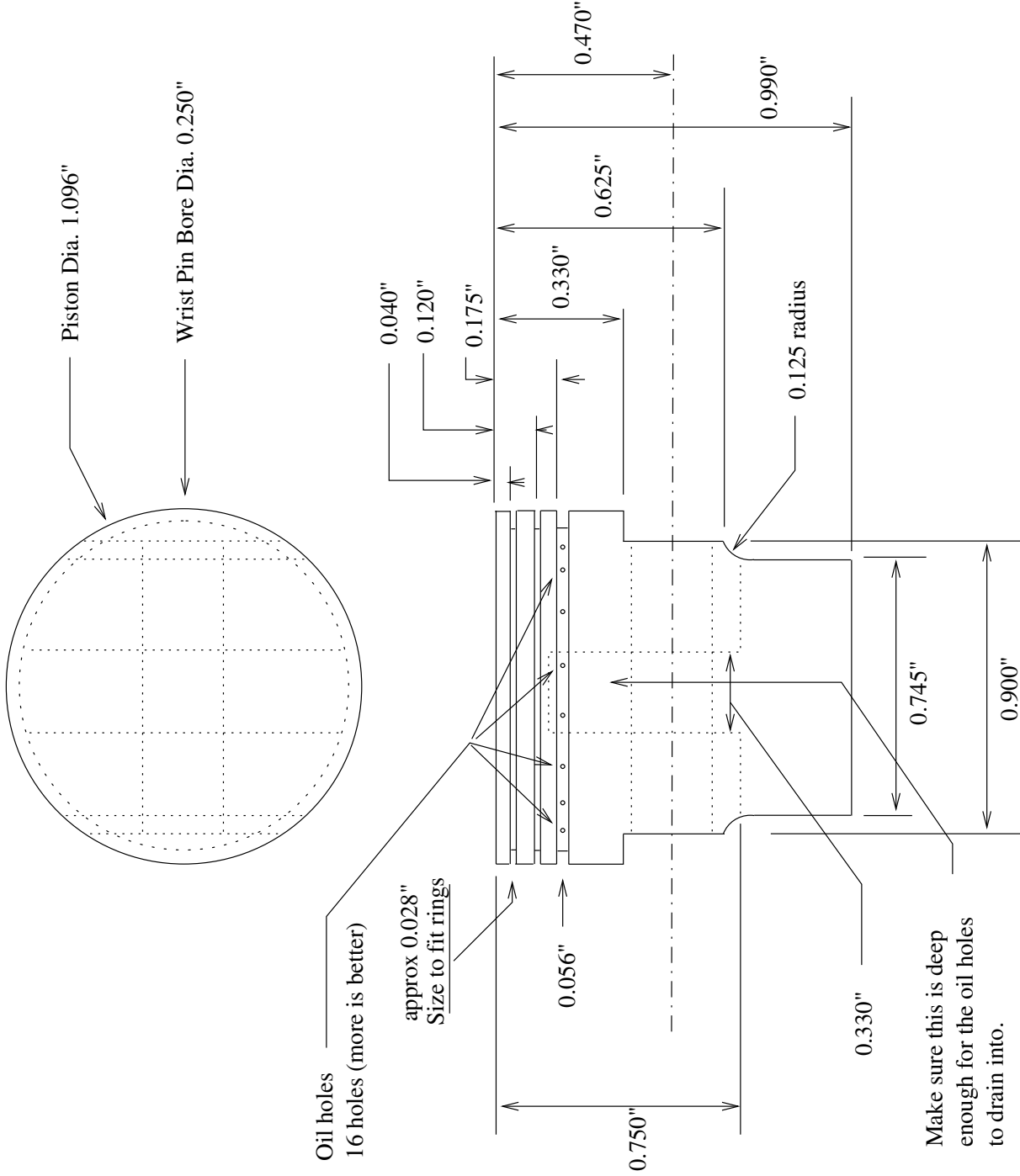


Oil Pan 11-9-00 All dimensions are inches unless noted.

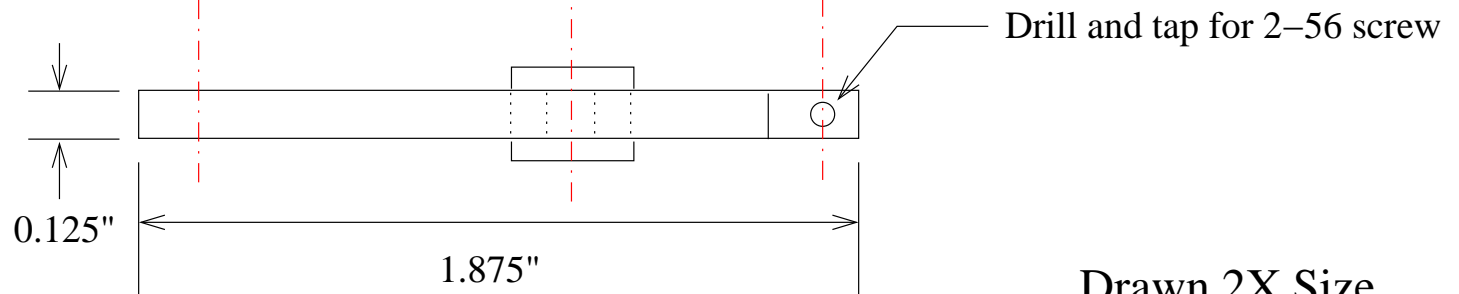
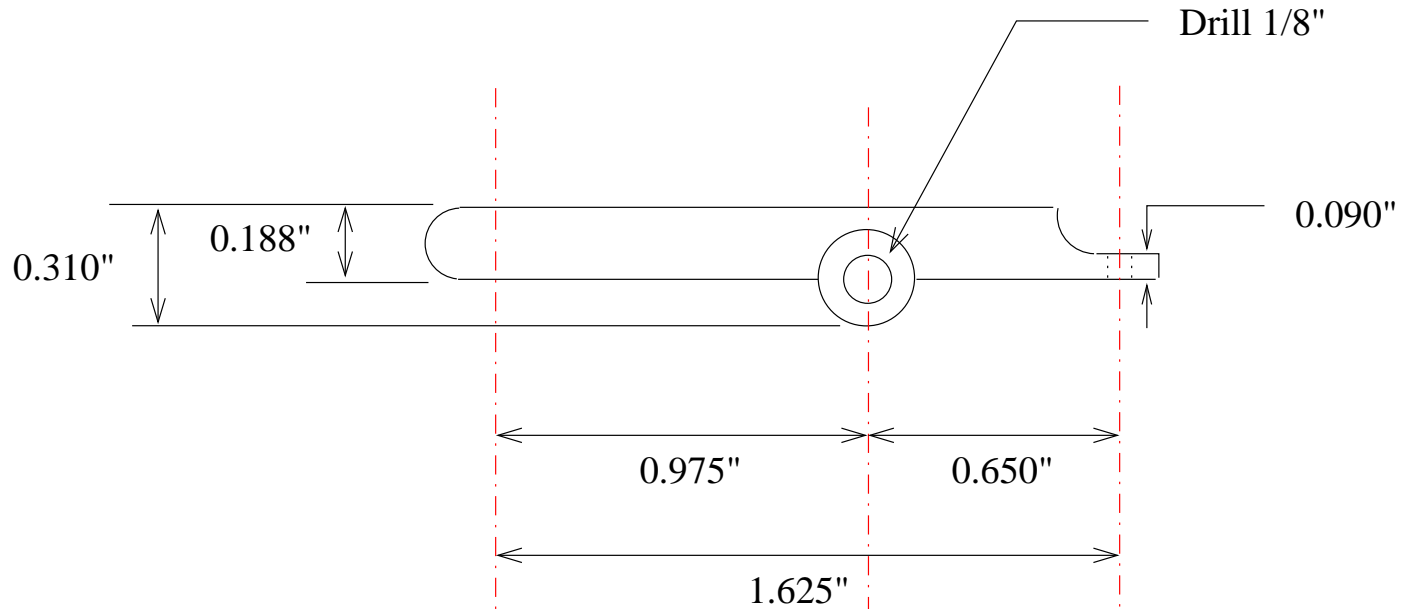
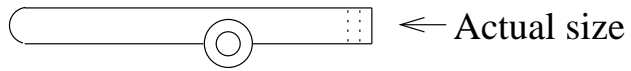
Drawn by Glen Bond

Drawn with XFig 3.2 protocol: 3.2 on a Linux 2.2.13 system



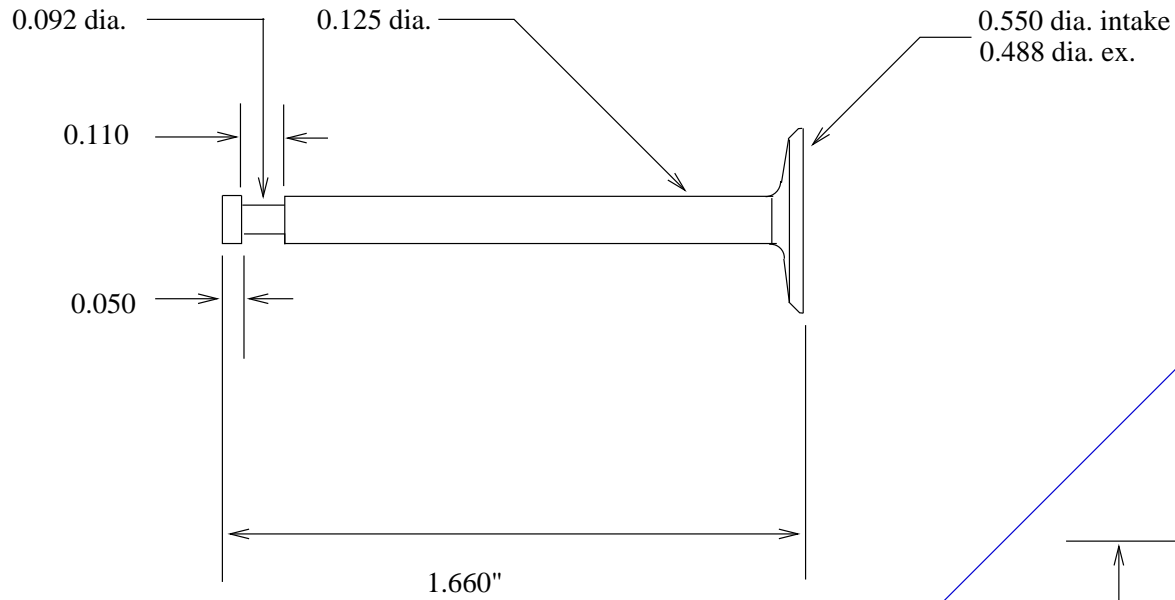


This drawing is 2X size



Drawn 2X Size





Intake valve Drawn 2X Size

