

Engine & Cooling	Fuel	Ignition	Electrical	Running gear	Torque settings	Capacities	Notes & Illustrations
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Automotive Technical DATA BOOK

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Engine and cooling system 323, 1.6i Estate CAT 1991 to 1994

Type	B6E. SOHC 8V 42kW	
Capacity (cm ³) / number of cylinders	1598 / 4	
Compression ratio / pressure	bar	9.3 / ≥7.8
Oil pressure	bar	[3.0 to 4.0]
Oil temperature	°C	–
Valve clearance - inlet	mm	0: Hyd.
Valve clearance - exhaust	mm	0: Hyd.
Firing order	1-3-4-2	
No 1 cylinder position	TBE	
Thermostat opening temperature	°C	82 to 85
Radiator cap pressure	bar	0.76 to 1.04

Fuel system 323, 1.6i Estate CAT 1991 to 1994

Idle speed - manual [auto]	rpm	850±50
Fast idle speed - manual [auto]	rpm	–
CO @ idle speed [3000 rpm] - see page VI	%	≤0.3
HC @ idle speed [3000 rpm] - see page VI	ppm	≤200
CO ₂ @ idle speed [3000 rpm] - see page VI	%	–
O ₂ @ idle speed [3000 rpm] - see page VI	%	–
Carburettor / fuel injection	Mazda	
Type / ref	EGI EFI	
Main jet / needle	–	
Injection pressure	bar	2.7 to 3.2
Pump pressure	bar	3.5
Octane rating	RON	95[U]

Ignition system 323, 1.6i Estate CAT 1991 to 1994

Type	Electronic	
Ignition coil	–	
Primary resistance	ohms	1.04 to 1.27
Ballast resistor	ohms	–
Voltage - Tmnl 15(+) to earth	V	–
Distributor	–	
Points gap (air gap)	mm	–
Dwell angle	° (%)	–
Condenser capacity	µF	–
Rotation	–	
Ignition timing - basic [static	° Crankshaft @ rpm	2±1 BTDC @ idle
V = Vacuum NV = No Vacuum	NV	
Total ignition advance	° Crankshaft @ rpm	–
	° Crankshaft @ rpm	–
	° Crankshaft @ rpm	–
Centrifugal check.	° Crankshaft @ rpm	-2 to +2 @ 1300
	° Crankshaft @ rpm	–
	° Crankshaft @ rpm	17 to 21 @ 3500
Vacuum range check	mbar	102 to 599
Maximum vacuum advance	° Crankshaft	26 to 30
Spark plugs	NGK	
Type	BKR5ES-11	
Electrode gap	mm	1.00 to 1.10

Electrical system 323, 1.6i Estate CAT 1991 to 1994

Battery	V / CC / RC	12 / 50 or 60Ah
Alternator voltage / full load current / engine rpm	14.1 to 14.7 / 65 / 2500	
Starter motor current / voltage - cranking	A / V	–
- locked	A / V	–

Running gear 323, 1.6i Estate CAT 1991 to 1994

Brakes -		
Front (min. friction material thickness)	mm	2.0
Rear (min. friction material thickness)	mm	1.0
Tyres		
Saloon	Size	–
Estate / Van	Size	155x13: 175/70x13
Pressure - front / rear - Saloon	bar	–
- Estate / Van	bar	1.9 / 1.8
Front suspension / wheel alignment		
Toe-in (+) / Toe-out (-)	mm [°]	+2.0±3.0
Camber	+49'±30'	
Castor	+1°35'±45'	
King pin inclination	+12°22'	
Rear suspension / wheel alignment		
Toe-in (+) / Toe-out (-)	mm [°]	+2.0±3.0
Camber	-5'±45'	

Torque wrench settings 323, 1.6i Estate CAT 1991 to 1994

Cylinder head - stage 1	Nm	40
- stage 2	Nm	76 to 81
Cylinder head - stage 3	Nm	–
- stage 4	Nm	–
Big-end bearings	Nm	29 to 34
Main bearings	Nm	54 to 59
Clutch cover	Nm	18 to 26
Flywheel [driveplate]	Nm	96 to 103
Front hubs	Nm	235 to 319 N
Rear hubs	Nm	177 to 235
Wheel nuts / bolts	Nm	118
Spark plugs	Nm	15 to 23

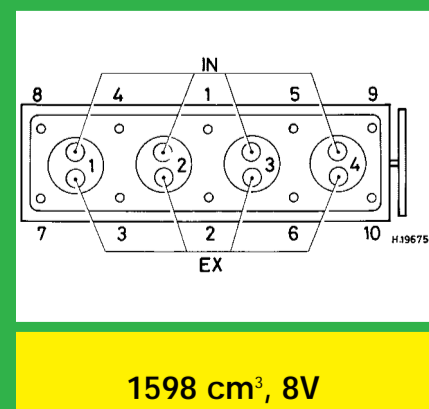
Capacities 323, 1.6i Estate CAT 1991 to 1994

Engine oil & filter	litres	3.4
Gearbox - 4-speed [5-speed]	litres	2.7
Automatic transmission - refill	litres	5.8
Final drive	litres	WT
Cooling system	litres	5.0 [AT: 6.0]
Fuel tank	litres	50

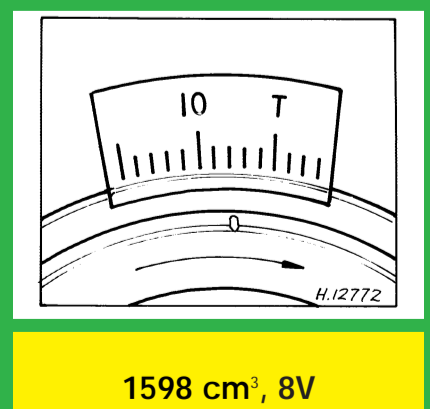
Notes and Illustrations



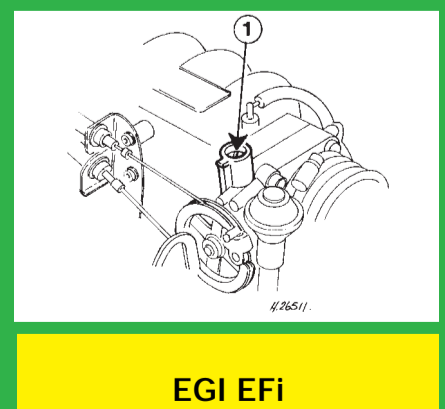
1: Idle speed 2: CO / Mixture



1598 cm³, 8V



1598 cm³, 8V



EGI EFI