

## Engine Building Data sheet – SBD 2.0L Duratec (RACE/RALLY)

This Data sheet is designed to give information that would be needed during an engine build or rebuild using SBD parts

	Metric	Imperial	Notes
Bore preparation			See relevant piston doc.
Bore Size	+0.01/-0.00mm	+ .0004/ -.0000"	i.e. 87.50mm = 87.51/87.50mm
Skirt clearance	N/A	N/A	Correct when bore size achieved*
Squish Clearance	0.85mm	.033"	Gasket minus average piston edge protrusion
Top Ring Gap	0.25mm	.010"	Min. **
2 <sup>nd</sup> Ring Gap	0.20mm	.008"	Min. **
Oil Ring Gap 2pc	0.20mm	.008"	Min. **
Oil Ring Gap 3pc	0.35mm	.015"	Min. **
Big End Clearance	0.045/0.064mm	.0018/.0025"	
Main Clearance	0.025/0.038mm	.001/.0015"	
Rod side clearance	0.15/0.25mm	.006/.010"	
Crank Float	0.127/0.25mm	.005/.010"	
Valve to Piston Clearance	1.52mm	.060"	Minimum on rotation
Tappet Clearance	0.20/0.25mm	.008/.010"	SBD Mechanical ONLY

### Squish Clearance –

Please take time to measure and set the squish clearance correctly, this is an important part of building an engine that performs well, and an aspect that becomes more critical as the engine specification rises.

*\*The complex shape of SBD/Omega Pistons means that it is virtually impossible to accurately measure the piston to determine bore clearance by the end user, the machining standards which are achieved and checked by Omega before despatch mean that the end user should only be concerned by the actual bore size, if the specified limits are met the bore clearance will be correct.*

*\*\* N.B – Over recent years ring manufacturers have increased end gaps without any detriment to the engine performance or ring sealing abilities, therefore use our clearance as a minimum value.*

# Data Sheet Duratec M

**Clemens Wendtner**



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