

1. Maintenance Standards Table

Unit: mm [in.]

Group	Inspection point		Nominal value	Standard	Limit	Remark	
General	Maximum speed (no-load)		According to engine specification			Adjust governor setting.	
	Minimum speed (no-load)						
	Compression pressure	Swirl chamber	3.23 MPa (33 kgf/cm ²) [469 psi] (at 300 min ⁻¹)		2.84 MPa (29 kgf/cm ²) [412 psi]	Oil and water temperature at 20 to 30°C [68 to 86°F]	
		Direct injection	2.94 MPa (30 kgf/cm ²) [426 psi] (at 300 min ⁻¹)		2.64 MPa (27 kgf/cm ²) [384 psi]		
	Lubricating oil pressure	at 1500 min ⁻¹	0.29 to 0.49 MPa (3 to 5 kgf/cm ²) [42 to 71 psi]		0.15 MPa (1.5 kgf/cm ²) [21 psi]	Oil temperature at 70 to 90°C [158 to 194°F]	
		Idling	0.1 MPa (1 kgf/cm ²) [14.2 psi] or more		0.05 MPa (0.5 kgf/cm ²) [7.1 psi]		
	Valve timing	Inlet valve open Inlet valve closed Exhaust valve open Exhaust valve closed	BTDC 30° ABDC 50° BBDC 74° ATDC 30° ±3° (crank angle)	(Swirl chamber)	BTDC 18° ABDC 54° BBDC 60° ATDC 22° ±3° (crank angle)	(Direct injection)	
	Valve clearance (Cold)			0.25 [0.009]		Both Inlet and Exhaust	
	Fuel injection start timing					The timing for each model of engine varies according to its specification. Be sure to verify the timing by referring to the specifications of each model.	
	V belt deflection			10 to 12 [0.39 to 0.47]		Deflection when pressed with thumb 98 N (10 kgf) [22 lbf].	
Engine main parts	Rocker arm	Rocker bushing inside diameter		φ 19 [0.7480]	19.010 to 19.030 [0.7484 to 0.7492]		
		Rocker shaft diameter		φ 19 [0.7480]	18.980 to 19.000 [0.7472 to 0.7480]		
		Clearance between bushing and shaft			0.010 to 0.050 [0.0003 to 0.0020]	0.070 [0.0028]	
	Valve	Valve stem diameter	Inlet	φ 8 [0.3150]	7.940 to 7.955 [0.3126 to 0.3132]	7.900 [0.3110]	
			Exhaust	φ 8 [0.3150]	7.920 to 7.940 [0.3118 to 0.3126]	7.850 [0.3091]	
		Valve stem - to - guide clearance		Inlet		0.065 to 0.095 [0.0026 to 0.0037]	0.150 [0.0059]
		Exhaust		0.080 to 0.115 [0.0031 to 0.0045]	0.200 [0.0079]		
Height to top of valve guide		14 [0.5511]	13.9 to 14.1 [0.5472 to 0.5551]				

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Roman Wölfel



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web may 9 2019 the need to upskill the competencies of leaders across both early childhood and early intervention sectors the lack of structured and supported transition from preschool to primary school lynn ang co principal investigator and professor of early childhood at the ioe said i believe every child deserves the very best quality care and education

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