

See the topic, SPECIFICATIONS, in the GENERAL INSTRUCTIONS.

Number of cylinders	6
Bore and stroke	4.5 x 5.5
Firing order	1-5-3-6-2-4

Accessory Drive

Backlash between accessory drive gear and accessory drive idler gear	.002 - .011 in.
Gear retaining nut torque	150 lb. ft.
Idler gear:	
Backlash between accessory drive idler gear and camshaft gear	.002 - .011 in.
End clearance	.002 - .009 in.
Permissible end clearance	.018 in.
Bearing bore	1.000 - 1.001 in.
Bearing clearance	.001 - .003 in.
Permissible bearing clearance	.007 in.

Camshaft

Backlash between camshaft gear and crankshaft gear	.001 - .009 in.
Bearing journal diameter	2.3105 - 2.3115 in.
Bearing clearance	.001 - .005 in.
Permissible bearing clearance	.010 in.
End clearance	.004 - .009 in.
Permissible end clearance	.025 in.
Retaining nut torque	165 - 185 lb. ft.

Connecting Rod

Bearing clearance	.0032 - .0060 in.
Permissible bearing clearance	.012 in.
Bolt nut torque	85 lb. ft.
Center-to-center distance	8.999 - 9.001 in.
Piston pin bearing bore	1.5014 - 1.5020 in.

Crankshaft

Main journal diameter	3.499 - 3.500 in.
Permissible main journal wear	.008 in.
Main bearing clearance (Earlier)	.0053 - .0082 in.
Permissible bearing clearance (Earlier)	.013 in.
Main bearing clearance (Later — with lead-tin overlay)	.0030 - .0059 in.
Permissible bearing clearance (Later)	.010 in.
End clearance	.0110 - .0180 in.
Permissible end clearance	.035 in.
Main bearing nut torque	155 lb. ft.
Connecting rod journal diameter	2.999 - 3.000 in.
Permissible journal wear	.007 in.
Permissible out-of-round	.004 in.
Pulley retaining bolt torque	210 - 250 lb. ft.

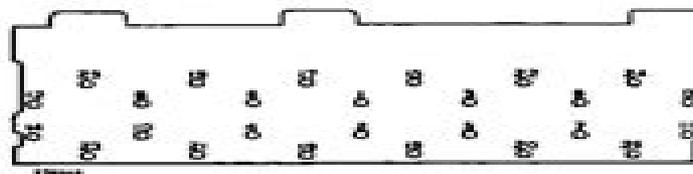
Cylinder Block

Main bearing original bore dimension	3.8155 - 3.8165 in.
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Cylinder Head

Tighten bolts in sequence shown in illustration:	
Initial	85 lb. ft.

Final	120 - 130 lb. ft.
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CYLINDER HEAD BOLT TIGHTENING SEQUENCE

Cylinder Liner (Use 5F7362 Adapter Plate for Removal)

Inside diameter	4.500 - 4.501 in.
Permissible liner wear (increase in diameter at top of ring travel)	.015 in.
Counterbore dimension in block	.400 - .402 in.
Flange thickness	.403 - .405 in.

Fan Belt Tension

Slack at point midway between pulleys	9/16 - 13/16 in.
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Flywheel

Retaining bolt torque	118 - 142 lb. ft.
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Flywheel Housing

Retaining bolt torque	60 - 70 lb. ft.
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Fuel Injection Equipment

Fuel injection pump timing	11° BTC
Fuel injection pump timing dimension setting (off engine) with 2M5215 Gauge	4.2655 - 4.2695 in.

LIFTER SETTINGS IN DEGREES (OFF ENGINE)	
LIFTER NO. (Numbered consecutively front to rear)	TIMING PLATE DEGREES
1	180°
2	60°
3	300°
4	120°
5	240°
6	0°

Fuel injection pump timing dimension setting (on engine with pistons at top center) with 2M5215 Gauge

4.2264 - 4.2304 in.	
Fuel pump plunger length	2.5935 - 2.5937 in.
Permissible wear (decrease in length of plunger)	.005 in.
Injection nozzle orifice (Use 5B2178 Drill for clearing)	.025 in.
Nozzle retaining nut torque	100 - 110 lb. ft.

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Yi-Tong Ma



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