

Indirect: Injected

* Unit for values without unit in the column of inspection item is mm.

Unit	Part	Inspection Items	Standard Dimension	Standard Value	To be Replaced	Allowable Limit	Remarks	
ENGINE	CYLINDER HEAD	Compression pressure of cylinder MPa (kgf/cm ²)		More than 2.94 (More than 30)	Less than 2.45 (Less than 25)		Engine 200 rpm	
		Distortion of face of cylinder head		Less than 0.05	More than 0.12			
		Valve seat (Intake/exhaust)			0.85 ~ 1.15	1.8		Valve seat angle 45°
		Width of valve seat (intake/exhaust)		1.7 ~ 2.1	More than 2.5			
		Tightening torque of cylinder head N·m (kgf·m)		49 ~ 52 (5.0 ~ 5.3)			Coat threads with molybdenum disulfide based grease.	
	CYLINDER BLOCK	Bore	∅77	∅77.99 ~ 77.005	∅77.2		Over size (0.5)	
		Distortion of upper face of cylinder block		Less than 0.05	0.12			
	PISTON	Skirt diameter (longer diameter)	∅77	∅77.9225 ~ 77.9375			Over size: Porton 0.50 MM	
		Clearance to cylinder		0.0525 ~ 0.0865		0.25	At 20°C	
		Inside diameter of piston pin hole	∅21	∅20.996 ~ 21.000		21.016		
		Piston pin hole-to-pin clearance		-0.004 ~ +0.004		0.02		
	PISTON PIN	Outer diameter of pin	∅21	∅20.996 ~ 21.000		∅20.98		
		Small end bush-to-pin clearance		0.006 ~ 0.023		0.06	Oil clearance	
	PISTON RING	Piston ring gap	No. 1 ring		0.15 ~ 0.27		1.0	
			No. 2 ring		0.12 ~ 0.24			
			Oil ring		0.2 ~ 0.35			
		Piston ring groove-to-ring clearance	No. 1 ring		0.06 ~ 0.1		0.25	
			No. 2 ring		0.05 ~ 0.09			
			Oil ring		0.02 ~ 0.06			0.15
		Ring width	No. 1 ring	2	1.97 ~ 1.99			
No. 2 ring			1.5	1.47 ~ 1.49				
Oil ring	4		3.97 ~ 3.99					

Heavy Equipment Restoration Parts LLC
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LL Leslie



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Table of Contents Perkins 403d 11 Workshop Manual

1. Understanding the eBook Perkins 403d 11 Workshop Manual
 - The Rise of Digital Reading Perkins 403d 11 Workshop Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying Perkins 403d 11 Workshop Manual
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Perkins 403d 11 Workshop Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from Perkins 403d 11 Workshop Manual
 - Personalized Recommendations

- Perkins 403d 11 Workshop Manual User Reviews and Ratings
- Perkins 403d 11 Workshop Manual and Bestseller Lists
- 5. Accessing Perkins 403d 11 Workshop Manual Free and Paid eBooks
 - Perkins 403d 11 Workshop Manual Public Domain eBooks
 - Perkins 403d 11 Workshop Manual eBook Subscription Services
 - Perkins 403d 11 Workshop Manual Budget-Friendly Options
- 6. Navigating Perkins 403d 11 Workshop Manual eBook Formats
 - ePub, PDF, MOBI, and More
 - Perkins 403d 11 Workshop Manual Compatibility with Devices
 - Perkins 403d 11 Workshop Manual Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Perkins 403d 11 Workshop Manual
 - Highlighting and Note-Taking Perkins 403d 11 Workshop Manual
 - Interactive Elements Perkins 403d 11 Workshop Manual
- 8. Staying Engaged with Perkins 403d 11 Workshop Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Perkins 403d 11 Workshop Manual
- 9. Balancing eBooks and Physical Books Perkins 403d 11 Workshop Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Perkins 403d 11 Workshop Manual
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Perkins 403d 11 Workshop Manual
 - Setting Reading Goals Perkins 403d 11 Workshop Manual
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Perkins 403d 11 Workshop Manual
 - Fact-Checking eBook Content of Perkins 403d 11 Workshop Manual

- Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
- 14. Embracing eBook Trends
 - Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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