

Displacement 1.13 L. (69.0 in³) Compression Ratio: 23:1

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Standard	Standard Value	Value Observed	Allowable	Remarks
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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)							Valve seat angle 45°
					0.85 - 1.15	1.8			
		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		Ø77	Ø77.99 - 77.005	Ø77.2		Over size (0.5)	
		Distortion of upper face of cylinder block			Less than 0.05	0.12			
	PISTON	Skirt diameter (longer diameter)		Ø77	Ø77.9225 - 77.9375			Over size 0.50 MM	
		Clearance to cylinder			0.0525 - 0.0865		0.25	At 20°C	
		Inside diameter of piston pin hole		Ø21	Ø20.998 - 21.000		21.016		
		Piston pin hole-to-pin clearance			-0.004 - +0.004		0.02		
	PISTON PIN	Outer diameter of pin		Ø21	Ø20.998 - 21.000		Ø20.98		
		Small end bush-to-pin clearance			0.005 - 0.023		0.05	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			Over size Piston Rings 0.50 MM		
		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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Perkins 403d 11 Workshop Manual

Yan Bai



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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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