

Individuals Impacted

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

Unit		Part	Inspection Item	Standard Dimension	Standard Value	To be Repaired	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			Over size Porton 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
Phone: 269 673 1638
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Perkins 403d 11 Workshop Manual

ML Morrison



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