

Indirect Injection

Unit	Part	Inspection Item	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 - 53 (5.0 - 5.3)			Coat threads with molybdenum disulfide based grease.
MAIN MOVING SYSTEM	CYLINDER BLOCK	Block	∅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 Piston 0.50 MM
		Clearance to cylinder		∅0.0525 - 0.0865		0.25	At 20°C
		Inside diameter of piston pin hole	∅21	∅20.996 - 21.002		21.016	
		Piston pin hole-to-pin clearance		-0.004 - +0.004		0.02	
	PISTON PIN	Outer diameter of pin	∅21	∅20.996 - 21.002		∅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			
		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		

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SJ Ball



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