

**Valve springs - vehicle, M50 and M50T engines**

Fitted length	34.7 mm (1.37 in)
Load at fitted length	150 N (34.5 lbf) to 20.2 kgf
Number of active coils	4.5
Number of damper coils	0
Direction of coils	Left hand
Identification colour	Orange

**Valve springs - 500 and M50 engines**

Fitted length	34.7 mm (1.37 in)
Load at fitted length	142/137 N (32/30 lbf) 14.5/13.0 kgf
Number of active coils	5.2
Number of damper coils	0
Direction of coils	Left hand
Identification colour	White

**Pistons and skirts****Materials:**

- Vehicle, M50 and M50T engines
- 500 and M50 engines

Steel  
Cast iron

Outside diameter of skirt	71.725/71.745 mm (2.822/2.848 in)
Clearance of skirt in cylinder head	0.050/0.055 mm (0.002/0.002 in)
Thickness of skirt head	0.55/0.58 mm (0.022/0.023 in)
Skirt length:	
- Vehicle, M50 and M50T engines	25.7/26.3 mm (1.01/1.04 in)
- 500 and M50 engines	25.7/26.3 mm (1.01/1.04 in)
Skirt thickness	Range of 48 gms: from 2.085 mm (0.081 in) to 2.405 mm (0.094 in) in grades of 0.025 mm (0.001 in)

**Camshaft**

Diameter of front and rear journals	47.860/47.875 mm (1.885/1.888 in)
Diameter of centre journal	47.865/47.875 mm (1.886/1.888 in)
Clearance of journals in bores:	
- Front and rear	0.040/0.044 mm (0.0017/0.0017 in)
- Centre	0.040/0.045 mm (0.0017/0.0018 in)
Diameter for pulley hub	36.58/36.61 mm (1.440/1.441 in)
Cam lift - vehicle, M50 and M50T engines:	
- Intake and exhaust	9.344/9.724 mm (0.372/0.382 in)
Cam lift - 500 and M50 engines:	
- Intake camshaft part number L 141DP 111	9.344/9.004 mm (0.368/0.355 in)
- Intake camshaft part number L 141 DP02	9.344/9.324 mm (0.368/0.363 in)
- Exhaust	9.344/9.524 mm (0.367/0.375 in)
End float	0.11/0.27 mm (0.004/0.011 in)
Maximum permissible end float in service	0.50 mm (0.020 in)
Width of recess for thrust washer	6.05/6.12 mm (0.238/0.241 in)
<b>Camshaft thrust washer</b>	
Type	1.807 washer fitted in camshaft cover
Thickness	0.80/0.85 mm (0.031/0.034 in)
Transition fit of thrust washer in camshaft cover recess	± 0.05 mm (± 0.002 in)

# Perkins M80t Manual

**Jin-Ying Zhang**



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