

GENERAL DATA

ENGINEERING & DESIGN

Type	Unit	mm	In.
Number of cylinders	4		
Bore	76.2	(3.00)	
Stroke	89.0	(3.50)	
Capacity	5.489	(0.336)	
Compression ratio	13.1		
Firing order	1-3-4-2		
Idle speed	600 to 650	(rev/min)	
Maximum governed light running speed	Refer to pump nameplate		
Crankshaft			
Journal diameter	2.0005 to 2.001	(in.) (50.813 to 50.825 mm)	
Clearance in main bearings	0.001 to 0.0027	(in.) (0.0254 to 0.0688 mm)	
Crankpin diameter	2.0005 to 2.001	(in.) (50.813 to 50.825 mm)	
Clearance in big end bearings	0.001 to 0.0027	(in.) (0.0254 to 0.0688 mm)	
Unbalance (Journals and crankpins)			
First	0.010	(in.) (0.254 mm)	
Second (maximum)	0.020	(in.) (0.508 mm)	
Endfloat	0.002 to 0.003	(in.) (0.051 to 0.076 mm)	
Endfloat adjustment	Selective thrust washer assembly		
Cylinder bore			
Standard	2.8745 to 2.876	(in.) (73.012 to 73.05 mm)	
Oversizes			
First	0.010	(in.) (0.254 mm)	
Second (maximum if lined)	0.020	(in.) (0.508 mm)	
Third	0.030	(in.) (0.762 mm)	
Fourth (maximum)	0.040	(in.) (1.016 mm)	
Pistons and rings			
Piston type	Aluminum alloy with solid skirt		
Piston to bore clearance at bottom of skirt	0.0035 to 0.0043	(in.) (0.089 to 0.109 mm)	
Ring/groove clearance			
Top compression	0.0035 to 0.0055	(in.) (0.089 to 0.140 mm)	
2nd and 3rd compression	0.0025 to 0.0045	(in.) (0.063 to 0.114 mm)	
Oil control	0.002 to 0.004	(in.) (0.051 to 0.102 mm)	
Ring gap			
Top compression	0.012 to 0.017	(in.) (0.305 to 0.432 mm)	
Remainder	0.008 to 0.013	(in.) (0.203 to 0.330 mm)	
Camshaft			
Journal diameter			
Front	1.78875 to 1.78925	(in.) (45.434 to 45.447 mm)	
Centre	1.72875 to 1.72925	(in.) (43.910 to 43.922 mm)	
Rear	1.62275 to 1.62325	(in.) (41.218 to 41.231 mm)	
Clearance in bearings	0.001 to 0.002	(in.) (0.0254 to 0.0508 mm)	
End float	0.003 to 0.007	(in.) (0.0762 to 0.1778 mm)	
End float adjustment	Renew locating plate		
Gudgeon pins			
Type	Fully floating		
Diameter	0.8988 to 1.0	(in.) (22.38 to 25.4 mm)	
Fit in piston	0.0002 in. (0.005 mm) clearance to 0.0002 in. (0.005 mm) interference		
Chain wheel alignment	0.0002 in. to 0.0009 in. (0.005 to 0.023 mm) clearance Crankshaft chain wheel face 0.005 in. (0.127 mm) rearwards of camshaft chain wheel face		
Method of adjustment	Shims behind crankshaft chain wheel		
Cylinder head			
Valve seat angle	45°		
Valve seat face width	0.089	(in.) (2.261 mm)	
Valves			
Stand-down	0.018 to 0.038	(in.) (0.457 to 0.965 mm)	
Lift	0.317	(in.) (8.05 mm)	
Head diameter			
Inlet	1.370 to 1.375	(in.) (34.8 to 34.9 mm)	
Exhaust	1.151 to 1.156	(in.) (29.2 to 29.4 mm)	
Stem diameter			
Inlet	0.3422 to 0.3427	(in.) (8.69 to 8.70 mm)	
Exhaust	0.002 to 0.003	(in.) (0.051 to 0.076 mm)	
Stem to guide clearance			
Inlet	0.0015 to 0.0025	(in.) (0.038 to 0.064 mm)	
Exhaust	0.002 to 0.003	(in.) (0.051 to 0.076 mm)	
Seat angle	44°		
Seat face width	0.000 ± 0.010 in. (2.386 — 0.254 mm)		
Valve springs			
Free length	Inlet 1.875 in. (47.63 mm) Exhaust 1.4375 in. (36.512 mm) 20 ± 1 lb. (9.07 ± 0.454 kg)	Outer 2.243 in. (56.75 mm) 1.5625 in. (39.687 mm) 50 ± 2 lb. (22.907 ± 0.907 kg)	
Fitted length			
Pressure (valve closed)			

Bmc Vintage Diesel Manuals For Mechanics

ML Morrison



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web the joining of simple words is a great help to accuracy and speed in writing shorthand and its acquirement should not be deferred until the habit of writing common words separately has been formed 5 punctuation etc in shorthand the following marks are used 6 sentence drill 7