SECTION CD

SCHEDULE OF CLEARANCES AND WEAR LIMITS

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| ITEM | DESCRIPTION OF PART | DESIGN DIMENSION | WORKING CLEARANCE | MAXIMUM |
| No |  | WHEN NEW | WHEN NEW | CLEARANCE |
|  |  | mm (in) | mm (in) | mm (in) |
| i | CRANKSHAFT AND MAIN BEARINGS |  |  |  |
|  | \* Bearing: Bore (fitted) | 228.80 - 228.85 (9.0080 - 9.0100) | 0.20 - 0.29 | 0.46 |
|  |  |  | (0.0080-0.0115) | (0.018) |
|  | Journal: Diameter | 228.56 - 228.60 (8.9985 - 9.000) |  |  |
|  | Thrust Bearing : Dim. over Thrust Faces | 82.18-82.38 (3.2355 - 3.2435) | End Float 0.14-0.39 | 0.56 |
|  |  |  | (0.0055 - 0.0155) | (0.022) |
|  | Thrust Journal: Dim. between | 82.52 - 82.57 |  |  |
|  | Thrust Faces | (3.2490 - 3.2510) |  |  |
| 2 | DOUBLE IDLER GEAR, CAMSHAFT DRIVE |  |  |  |
|  | Drive, Bush: Bore (fitted) | 38.11 -38.22 (1.5039 - 1.5046) | 0.063 - 0.090. | 0.20 |
|  |  |  | (0.0025 - 0.0037) | (0.0080) |
|  | Spindle: Diameter | 38.12-38.14 (1.5009 - 1.5014) |  |  |

\* See end of Section

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| ITEM  No | DESCRIPTION OF PART | | DESIGN DIMENSION WHEN NEW mm (in) | WORKING CLEARANCE WHEN NEW mm (in) | | MAXIMUM CLEARANCE mm (in) |
| 2 | DOUBLE IDLER GEAR, CAMSHAFT DRIVE (Contd) | |  |  |  |  |
|  | End Float |  |  | 0.18-0.48  (0.007-0.019) | |  |
|  | Backlash - Crankshaft Gearwheel | |  | 0.10-0.25 (0.0040 - 0.0100) | |  |
| 3 | CAMSHAFT AND BEARINGS  Base circle to cam nose: Dimension |  | 53.21 - 53.47 (2.095-2.105) |  |  | Minimum  Dimension  52.40  (2.0630) |
|  | Bearing: Bore  Journals: Diameter |  | 66.68 - 66.72 (2.6250 - 2.6268)  (66.54 - 66.57 (2.6198 - 2.6208) | 0.11-0.18 (0.0042 - 0.0070) | | 0.31  (0.0120) |
|  | Bearing, Free-end: Bore  Journal, Free-end: Diameter |  | 31.75-31.79 (1.2500- 1.2516)  31.68-31.73 (1.2474 -1.2490) | 0.025-0.11 (0.0010 - 0.0042) | | 0.20  (0.008) |
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| ITEM  No | DESCRIPTION OF PART | | DESIGN DIMENSION WHEN NEW mm (in) | WORKING CLEARANCE WHEN NEW mm (in) | | MAXIMUM CLEARANCE mm (in) |
| 3 | CAMSHAFT AND BEARINGS (Contd) | |  |  |  |  |
|  | Gearwheel: Backlash when meshing with Double idler gear | |  | 0.10-0.25 (0.0040 - 0.0100) | |  |
|  | Drive Gear: Depth of thrust recess  Thrust Collar Flange: Thickness | | 9.53 - 9.65 (0.3750 - 0.3800)  9.37 - 9.42 (0.3690-0.3710) | 0.10-0.28 (0.0040 - 0.0110) | | 0.46  (0.0180) |
| 4 | CAM FOLLOWER HOUSINGS |  |  |  |  |  |
|  | Housing: Bore  Cam Follower: Outer Diameter |  | 44.45 - 44.48 (1.7500- 1.7510)  46.36 - 44.40 (1.7464- 1.7480) | 0.05-0.12 (0.0020 - 0.0046) | | 0.20  (0.0080) |
|  | Roller: Bore  Roller Bush: Outer Diameter |  | 24.00 - 24.02 (0.9449 - 0,9458)  23.88 - 23.90 (0.9402 - 0.9409) | 0.10-0.14 (0.0040 - 0.0056) | | 0.20  (0.0080) |
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| ITEM | DESCRIPTION OF PART | DESIGN DIMENSION | WORKING CLEARANCE | MAXIMUM |
| No |  | WHEN NEW | WHEN NEW | CLEARANCE |
|  |  | mm (in) | mm (in) | mm (in) |
| 4 | CAM FOLLOWER HOUSINGS (Contd) |  |  |  |
|  | Roller Bush: Bore | 16.06 -16.10 (0.6323 - 0.6339) | 0.10-0.16 | 0.20 |
|  |  |  | (0.0038 - 0.0063) | (0.008) |
|  | Pin: Diameter | 15.94 -15.96 (0.6276 - 0.6285) |  |  |
| 5 | GOVERNOR DRIVE |  |  |  |
|  | Spur and Worm Gear Bush: Bore (fitted) | 31.75-31.79 (1.2500- 1.2516) | 0.03-0.11 | 0.18 |
|  |  |  | (0.0010 - 0.0042) | (0.007) |
|  | Fixed Spindle: Diameter | 31.68-31.73 (1.2474 -1.2490) |  |  |
|  | Spur Gear, Backlash - when meshing with |  | 0.10-0.25 |  |
|  | Main Idler Gear |  | (0.004 - 0.010) |  |
|  | Worm Gear, Backlash - when meshing with |  | 0.10-0.15 |  |
|  | Worm Wheel |  | (0.004 - 0.006) |  |

NOTE Governor vertical spindle is fitted with PTFE impregnated bushes. No clearances are quoted as these bushes cannot be

scraped.

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| ITEM | DESCRIPTION OF PART | DESIGN DIMENSION | WORKING CLEARANCE | MAXIMUM |
| No |  | WHEN NEW | WHEN NEW | CLEARANCE |
|  |  | mm (in) | mm (In) | mm (in) |
| 6 | WATER CIRCULATING PUMP DRIVE |  |  |  |
|  | Bush: Bore (fitted) | 31.83 - 31.87 (1.2530 - 1.2546) | 0.05-0.10 | 0.18 |
|  |  |  | (0.0018 - 0.0040) | (0.007) |
|  | Spindle: Diameter | 31.77-31.78 (1.2506- 1.2512) |  |  |
|  | End Float: (Designed |  | 0.30 - 0.53 | 0.79 |
|  |  |  | (0.0120-0.0210) | (0.0310) |
|  | Backlash - when meshing with Camshaft |  | 0.10-0.25 |  |
|  | gearwheel |  | (0.004 - 0.010) |  |
|  | PUMP DRIVE - CENTRE BEARING |  |  |  |
|  | Bush: Bore (fitted) | 31.83-31.87 (1.2530- 1.2546) | 0.05-0.10 | 0.18 |
|  |  |  | (0.0018-0.0040) | (0.007) |
|  | Spindle: Diameter | 31.77-31.78 (1.2506- 1.2512) |  |  |
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| ITEM | DESCRIPTION OF PART |  | DESIGN DIMENSION | WORKING CLEARANCE | | MAXIMUM |
| No |  |  | WHEN NEW |  | WHEN NEW | CLEARANCE |
|  |  |  | mm (in) |  | mm (in) | mm (in) |
| 7 | WATER CIRCULATING PUMP | |  |  |  |  |
|  | Bush: Bore (fitted) |  | 31.83-31.87 (1.2530- 1.2546) |  | 0.05 -0.10 | 0.007 |
|  |  |  |  | (0.0018 - 0.0040) | | (0.18) |
|  | Spindle: Diameter |  | 31.77-31.78 (1.2506- 1.2512) |  |  | Minimum |
|  | Thrust Washer: Thickness |  | 2.31-2.36 |  |  | thickness |
|  |  |  | (0.091 - 0.093) |  |  | 2.19  (0.086) |
|  | End Float |  |  |  | 0.06 - 0.019 | 0.36 |
|  |  |  |  | (0.0025 - 0.0077) | | (0.014) |
| 8 | TWIN IDLER GEAR - FUEL PUMP DRIVE | |  |  |  |  |
|  | Bush: Bore (fitted) |  | 38.20 - 38.22 (1.5039- 1.5046) |  | 0.06 - 0.09 | 0.20 |
|  |  |  |  | (0.0025 - 0.0037) | | (0.008) |
|  | Spindle: Diameter |  | 38.12-38.14 (1.5009- 1.5014) |  |  |  |
|  | End Float of Idler Gear |  |  |  | 0.18-0.48 | 0.53 |
|  |  |  |  | (0.0070 -0.0190) | | (0.021) |
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| ITEM | DESCRIPTION OF PART | DESIGN DIMENSION | WORKING CLEARANCE | MAXIMUM |
| No |  | WHEN NEW | WHEN NEW | CLEARANCE |
|  |  | mm (in) | mm (in) | mm (in) |
| 8 | TWIN IDLER GEAR - FUEL PUMP DRIVE (Contd) |  |  |  |
|  | Backlash - when meshing with camshaft gearwheel |  | 0.15-0.20 (0.006 - 0.008) |  |
| 9 | FUEL INJECTION PUMP CAMSHAFT AND BEARINGS |  |  |  |
|  | Bearing bore | 107.95 - 108.01 (4.2500 - 4.2522) | 0.09-0.17 | 0.25 |
|  |  |  | (0.0036 - 0.0068) | (0.010) |
|  | Journal: Diameter | 107.83 - 107.86 (4.2454 - 4.2464) |  |  |
|  | Bearing Drive-end: Bore | 66.67 - 66.72 (2.6250 - 2.6268) | 0.076-0.15 | 0.19 |
|  |  |  | (0.0030 - 0.0058) | (0.0073) |
|  | Journal, Drive-end: Diameter | 66.57 - 66.60 (2.6210 - 2.6220) |  |  |

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| ITEM | DESCRIPTION OF PART |  | DESIGN DIMENSION | WORKING CLEARANCE | | MAXIMUM |
| No |  |  | WHEN NEW |  | WHEN NEW | CLEARANCE |
|  |  |  | mm (in) |  | mm (in) | mm (in) |
| 9 | FUEL INJECTION PUMP CAMSHAFT | |  |  |  |  |
|  | AND BEARINGS (Contd) |  |  |  |  |  |
|  | Thrust Bearing: Dimension |  | 82.42 - 82.55 |  |  |  |
|  | over thrust faces |  | (3.2450 - 3.2500) |  | End Float 0.13-0.51 | 0.64 |
|  |  |  |  | (0.0050 - 0.0200) | | (0.025) |
|  | Thrust Journal: Dimension between thrust | | 82.68 - 82.93 |  |  |  |
|  | faces (fitted) |  | (3.2550 - 3.2650) |  |  |  |
|  | Gearwheel: Backlash when meshing with | |  |  | 0.10-0.15 |  |
|  | Double Idler Gear |  |  | (0.004 - 0.006) | |  |
|  | Bearing: Free-end Cover: Bore |  | 25.40 - 25.43 (1.0000 -1.0012) |  | 0.04-0.10 | 0.15 |
|  |  |  |  | (0.0016 - 0.0040) | | (0.0060) |
|  | Journal, Bevel Gear: Diameter |  | 25.33 - 25.36 (0.9972 - 0.9984) |  |  |  |
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| ITEM  No | DESCRIPTION OF PART | DESIGN DIMENSION WHEN NEW mm (in) | WORKING CLEARANCE WHEN NEW mm (in) | MAXIMUM CLEARANCE mm (in) |
| 10 | CYLINDER LINER |  |  |  |
|  | Bore | 196.85 - 196.92 (7.7500 - 7.7528) |  | Max step in bore  0.10  (0.004) |
| 11 | PISTON RINGS |  |  |  |
|  | Compression - Top groove Gap in standard bore | 0.53 - 0.79 (0.021 -0.031) |  | 1.52  (0.0600) |
|  | Vertical clearance in groove | 0.08-0.124 (0.0035 - 0.0049) |  | 0.0080  (0.20) |
|  | Compression - 2nd and 3rd grooves Gap in standard bore | 0.53 - 0.78 (0.021 -0.031) |  | 1.52  (0.0600) |
|  | Vertical clearances in groove | 0.061 - 0.099 (0.0024 - 0.0039) |  | 0.18  (0.007) |
|  | Oil control - 4th groove Gap in standard bore | 0.61 - 0.86 (0.024 - 0.034) |  | 1.52  (0.0600) |
|  | Vertical clearance in groove | 0.063 - 0.114 (0.0025 - 0.0045) |  | 0.18  (0.007) |

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| ITEM | DESCRIPTION OF PART |  | DESIGN DIMENSION | WORKING CLEARANCE | | MAXIMUM |
| No |  |  | WHEN NEW |  | WHEN NEW | CLEARANCE |
|  |  |  | mm (in) |  | mm (in) | mm (in) |
| 12 | CONNECTING RODS AND BEARINGS | |  |  |  |  |
|  | Large End |  |  |  |  |  |
|  | \* Bearing Block Shell: Bore (fitted) | | 139.79 - 139.84 |  |  |  |
|  |  |  | (5.5035 - 5.5055) |  | 0.09-0.18 | 0.33 |
|  |  |  |  | (0.0035 - 0.0070) | | (0.013) |
|  | Crankshaft Pin Diameter |  | 139.66 - 139.70 (5.4985 - 5.5000) |  |  |  |
|  | End float - Bearing Block to Crankshaft | |  |  | 0.25 - 0.46 |  |
|  |  |  |  | (0.010 - 0.018) | |  |
|  | Centre Connecting Rod Shell: |  | 177.89 -177.94 |  |  |  |
|  | Bore if (fitted) |  | (7.0035 - 7.0055) |  | 0.09-0.17 | 0.30 |
|  |  |  |  | (0.0035 - 0.0065) | | (0.012) |
|  | Bearing Block (with shell fitted): | | 6.9990 - 7.0000 |  |  |  |
|  | Outer Diameter |  | (177.78 - 177.80) |  |  |  |
|  | End Float - Centre Rod to Bearing Block | |  |  | 0.25 - 0.46 |  |
|  |  |  |  | (0.010-0.018) | |  |
|  | Small End Bush: Bore (Fitted) |  | 79.43 - 79.49 (3.1271 -3.1295) |  | 0.68-0.141 | 0.17 |
|  |  |  |  | (0.0027 - 0.0055) | | (0.0065) |
|  | Gudgeon Pin: Diameter |  | 79.351 -79.361 (3.12405 - 3.12445) |  |  |  |
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| ITEM | DESCRIPTION OF PART | DESIGN DIMENSION | WORKING CLEARANCE | MAXIMUM |
| No |  | WHEN NEW | WHEN NEW | CLEARANCE |
|  |  | mm (in) | mm (in) | mm (in) |
| 12 | CONNECTING RODS AND BEARINGS (Contd) |  |  |  |
|  | Piston Gudgeon Pin Boss: Bore | 79.364 - 79.374 (3.12455 - 3.12495) | 0.00254 - 0.02286 | 0.0762 |
|  |  |  | (0.0001 - 0.0009) | (0.003) |
|  | Gudgeon Pin: Diameter | 79.351 - 79.361 (3.12405 - 3.12445) |  |  |
|  | Centre Connecting Rod - Bore for bearing | 184.12- 184.15 |  |  |
|  | shells | (7.249 - 7.250) |  |  |
|  | Bore max. ovality |  |  | 0.0762  (0.003) |
|  | End Float |  | 0.254 - 0.457 (0.010-0.018) |  |
|  | Forked Conn. Rod: Bore for bearing shells | 146.02 - 146.05 (5.7490 - 5.7500) |  |  |
|  | Bore max. ovality |  |  | 0.0762  (0.003) |
|  | End Float |  | 0.254 - 0.457 (0.010-0.018) |  |
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| ITEM | DESCRIPTION OF PART | DESIGN DIMENSION | WORKING CLEARANCE | MAXIMUM |
| No |  | WHEN NEW | WHEN NEW | CLEARANCE |
|  |  | mm (in) | mm (in) | mm (in) |
| 13 | CYLINDER HEADS AND VALVE GEAR |  |  |  |
|  | Bumping clearance |  | 2.79 - 3.30 (0.110 -0.130) |  |
|  | Depth of Valve Face below Cylinder | 0.13-0.76 |  | 1.78 |
|  | Head Face | (0.0050 - 0.0300) |  | (0.070) |
|  | Rocker Lever Bush: Bore (fitted) | 25.44 - 25.48 (1.0015- 1.0033) | 0.02 - 0.79 | 0.178 |
|  |  |  | (0.0008 - 0.0031) | (0.007) |
|  | Fulcrum: Diameter | 25.40 - 25.42 (1.0002- 1.0007) |  |  |
|  | Valve Guide: Bore | 14.27 - 14.30 (0.5620 - 0.5630) | 0.076-0.11 | 0.20 |
|  |  |  | (0.003 - 0.0045) | (0.008) |
|  | Inlet Valve Stem: Diameter | 14.19-14.20 (0.5585 - 0.5590) |  |  |
|  | Valve Guide: Bore | 14.27 - 14.30 (0.5620 - 0.5630) | 0.09-0.11 | 0.20 |
|  |  |  | (0.0035 - 0.0045) | (0.008) |
|  | Exhaust Valve Stem: Diameter | 14.19-14.20 (0.5585 - 0.5590) |  |  |

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| ITEM | DESCRIPTION OF PART |  | DESIGN DIMENSION | WORKING CLEARANCE | | MAXIMUM |
| No |  |  | WHEN NEW |  | WHEN NEW | CLEARANCE |
|  |  |  | mm (in) |  | mm (in) | mm (in) |
| 14 | LUBRICATING OIL PUMPS |  |  |  |  |  |
|  | Drive Gear: Bush bore (fitted) |  | 63.50 - 63.55 (2.5000 - 2.5018) |  | 0.041 - 0.09 | 0.20 |
|  |  |  |  | (0.0016 - 0.0036) | | (0.008) |
|  | Stub shaft: Diameter |  | 63.43 - 63.46 (2.4972 - 2.4984) |  |  |  |
|  | End Float |  |  |  | 0.13-2.03 |  |
|  |  |  |  | (0.0050 - 0.080) | |  |
|  | Backlash - when meshing with |  |  |  | 0.10-0.15 |  |
|  | Crankshaft Gearwheel |  |  | (0.0040 - 0.006) | |  |
|  | Driving Rotor Bushes: Bore |  | 33.37 - 33.39 |  |  |  |
|  | (fitted and reamed) |  | (1.3139- 1.3145) |  | 0.086-0.11 | 0.20 |
|  |  |  |  | (0.0034 - 0.0045) | | (0.008) |
|  | Driving Spindle: Diameter |  | 33.27 - 33.29 (1.3100- 1.3105) |  |  |  |
|  | Driven Rotor Bushes: Bore (fitted) | | 28.69 - 28.74 |  |  |  |
|  |  |  | (1.1295- 1.1315) |  | 0.084-0.15 | 0.25 |
|  |  |  |  | (0.0033 - 0.0059) | | (0.010) |
|  | Driven Rotor Spindle: Diameter |  | 28.59 - 28.61 (1.1256- 1.1262) |  |  |  |
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| ITEM  No | DESCRIPTION OF PART | | DESIGN DIMENSION WHEN NEW mm (in) | WORKING CLEARANCE WHEN NEW mm (in) | | MAXIMUM CLEARANCE mm (in) |
| 14 | LUBRICATING OIL PUMPS (Contd) | |  |  |  |  |
|  | Backlash - between rotors |  |  | 0.10-0.20 (0.0040 - 0.0080) | |  |
|  | End Float |  |  | 0.10-0.15 (0.0040 - 0.0060) | |  |
| 15 | FUEL FEED PUMP AND DRIVE | |  |  |  |  |
|  | Bush, Fuel Feed Pump: Bore (fitted and reamed)  Rotor Spindles: Diameter |  | 15.88 -15.90 (0.6250 - 0.6260)  15.81 -15.84 (0.6225 - 0.6235) | 0.038 - 0.089 (0.0015 - 0.0035) | | 0.15  (0.006) |
|  | Backlash - between rotors |  |  | 0.015-0.20 (0.006 - 0.0080) | |  |
|  | End Float - Rotors |  |  | 0.03 - 0.08 (0.0010 - 0.0030) | |  |
|  | Drive Housing: Bore |  | 15.88 -15.90 (0.6250 - 0.6260) | 0.015-0.07 (0.0006 - 0.0026) | | 0.15  (0.006) |
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| ITEM  No | DESCRIPTION OF PART | | DESIGN DIMENSION WHEN NEW mm (in) | WORKING CLEARANCE WHEN NEW mm (in) | | MAXIMUM CLEARANCE mm (in) |
| 15 | FUEL FEED PUMP AND DRIVE (Contd) | |  |  |  |  |
|  | Bevel Pinion Spindle: Diameter  Bevel Pinion: Backlash when meshing with bevel gear | | 15.83 -15.86 (0.6234 - 0.6244) | 0.10-0.15s (0.0040 - 0.0060) | |  |
| 16 | TACHOMETER GENERATOR DRIVE | |  |  |  |  |
|  | Housing: Bore  Drive Shaft: Diameter  Bevel Gearwheel: Backlash - when meshing with Bevel Pinion on 'B' bank fuel pump drive single idler gear | | 15.88 -15.90 (0.6250 - 0.6260)  15.85 -15.86 (0.6240 - 0.6244) | 0.015 - 0.05 (0.0006 - 0.0020)  0.10-0.15 (0.004 - 0.006) | | 0.15  (0.006) |
| 17 | OVERSPEED TRIP GOVERNOR DRIVE | |  |  |  |  |
|  | Housing: Bore |  | 15.88 -15.90 (0.6250 - 0.6260) | 0.015 - 0.05 (0.0006 - 0.0020) | | 0.15  (0.006) |
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