

# SERVICE TABLE OF LIMITS

## PART 1 DIRECT DRIVE ENGINES

### SECTION II CYLINDERS

| Ref.<br>New  | Ref.<br>Old | Chart                    | Nomenclature   | Dimensions                        |               | Clearances                |               |
|--|-------------|--------------------------|--|-----------------------------------|---------------|---------------------------|---------------|
|  |             |                          |  | Mfr.<br>Min.<br>&<br>Max.         | Serv.<br>Max. | Mfr.<br>Min.<br>&<br>Max. | Serv.<br>Max. |
| 600  | 510         | ALL                      | Connecting Rod and Connecting Rod Bushing                                    | Bushings To Be Burnished in Place |               |                           |               |
|  |             | ALL                      | Finished I.D. of Connecting Rod Bushing                                      | <u>1.1254</u><br>1.1262           |               |                           |               |
| 601  | 510         | A-B-D-G-J-BD             | Length Between Connecting Rod Bearing Centers                                | <u>6.4985</u><br>6.5015           |               |                           |               |
|  |             | S-T-Y-AF-BE              | Length Between Connecting Rod Bearing Centers                                | <u>6.7485</u><br>6.7515           |               |                           |               |
| 602  | 511         | ALL                      | Connecting Rod Bushing and Piston Pin  |                                   |               | <u>.0008L</u><br>.0021L   | .0025L        |
| 603  | 512         | ALL                      | Piston Pin and Piston  |                                   |               | <u>.0003L</u><br>.0014L   | .0018L        |
|  |             | ALL                      | Diameter of Piston Pin Hole in Piston  | <u>1.1249</u><br>1.1254           |               |                           |               |
|  |             | ALL                      | Diameter of Piston Pin   | <u>1.1241</u><br>1.1246           |               |                           |               |
| 604  | 513         | A-G-J-S-T-AF-BD-BE       | Piston and Piston Pin Plug   |                                   |               | <u>.0002L</u><br>.0010L   | .002L         |
|  |             | A-G-J-S-T-AF-BD-BE       | *Diameter of Piston Pin Plug   | <u>1.1242</u><br>1.1247           |               |                           |               |
| 605  | 513         | B-D-G-J-S-T-Y-AF         | Piston Pin and Piston Pin Plug (Optional)                                    |                                   |               | <u>.0005L</u><br>.0025L   | .005L         |
|  |             | G-J-S-T-Y-AF             | *Diameter of Piston Pin Plug   | <u>.5655</u><br>.5665             |               |                           |               |
|  |             | B-D                      | Diameter of Piston Pin Plug (Thin Wall Pin)                                  | <u>.8405</u><br>.8415             |               |                           |               |
| *See latest edition of Service Instruction No. 1267. |             |                          |  |                                   |               |                           |               |
| 606  | 514         | A-B                      | Piston Ring and Piston - Side Clearance (Top Ring Comp.) (Plain) Full Wedge  |                                   |               | <u>.000</u><br>.004L      | .006L(B)      |
|  |             | B-D                      | Piston Ring and Piston - Side Clearance (Top Ring Comp.) (Chrome) Full Wedge |                                   |               | <u>.0025L</u><br>.0065L   | .008L(B)      |
|  |             | G-J-S-T-Y-AF-BD-BE       | Piston Ring and Piston - Side Clearance (Top Ring Comp.) Half Wedge          |                                   |               | <u>.0025L</u><br>.0055L   | .008L(B)      |
| 606  | 515         | B                        | Piston Ring and Piston - Side Clearance (2nd Ring Comp.) (Chrome) Full Wedge |                                   |               | <u>.0025L</u><br>.0065L   | .008L(B)      |
|  |             | A-B-D-G-J-S-T-Y-AF-BD-BE | Piston Ring and Piston - Side Clearance (2nd Ring Comp.) Full or Half Wedge  |                                   |               | <u>.000</u><br>.004L      | .006L(B)      |
|  |             | J                        | Piston Ring and Piston - Side Clearance (3rd Ring Comp.) Half Wedge          |                                   |               | <u>.000</u><br>.004L      | .006L(B)      |
| 606  | 516         | ALL                      | Piston Ring and Piston - Side Clearance (Oil Regulating)                     |                                   |               | <u>.002L</u><br>.004L     | .006L(B)      |