

Engine Clearances

Camshaft Bearings.0015	-	.0025
Connecting Rod Bearings.0015	-	.0025
Connecting Rod Bearing Side Clearance.005	-	.010
Main Bearings.002	-	.003
Crankshaft End Play.003	-	.005
Piston Clearance005	-	.0055
Piston Pin Clearance in Piston (Hand push fit)0001	-	.0002
Piston Ring Gap.020		
(Top002	-	.0025
Piston Ring Land Clearance (Second.003	-	.0035
(Oil Ring.002	-	.0025
Intake.010		
Valve Tappet Clearance (Hot) Exhaust016		
Valve Stem Clearance in Guide.001	-	.0015
Tappet Clearance in Cluster.00075	-	.001
Exhaust Valve Seat	1-5/8 diameter	-	Seat 1/16 inch wide
Intake Valve Seat.	1-13/16 diameter	-	Seat 1/16 inch wide
Governor Gear to Camshaft Gear Lash.005	-	.010
Camshaft Gear to Crankshaft Gear Lash.000	-	.001
Idler Gear to Camshaft Gear Lash001	-	.002
Water Pump Drive Gear to Idler Gear Lash002	-	.004
Oil Pump Gear to Camshaft Lash008	-	.010
Bellhousing Clearance to Crankshaft Flange012	-	.025
Water Pump Drive Bearing Clearance0015	-	.0025
Water Pump Drive Shaft End Thrust.001	-	.003
Housing Clearance Around Water Pump Shaft.006	-	.015
Gear Cover Clearance Around Crankshaft008	-	.015
Oil Pan Clearance Around Crankshaft.008	-	.015
Oil Pump Body Bushing Clearance.001	-	.0015

Valve Timing

INTAKE		EXHAUST	
Opens	Closes	Opens	Closes
5° B.T.D.C.	55° P.L.D.C.	45° B.L.D.C.	15° P.T.D.C.

NOTE - Letters designate B - Before L - Lower D.C. - Dead Center
P - Past T - Top

Wrench Tension

(For Tightening Nuts and Cap Screws.)

	Foot Pounds	Inch Pounds
Cylinder Head (With Copper Asbestos Gasket)	60	720
(With Steel Asbestos Gasket)	75	900
Connecting Rod	53	636
Main Bearings - Front and Intermediate	105	1260
Main Bearings - Center and Rear	70	840

Crankshaft Journal Dimensions

	Main Bearing Journal	Con Rod Journal
Standard	2.623 - 2.622	2.248 - 2.247
.020 Undersize	2.603 - 2.602	2.228 - 2.227
.030 Undersize	2.593 - 2.592	2.218 - 2.217
.060 Undersize	2.563 - 2.562	2.188 - 2.187