

## ENGINE SPECIFICATIONS

### PISTON PIN

Type . . . . .	Full Floating
Pin length . . . . .	2.963" - 2.973"
Pin diameter . . . . .	.99955" - .99975"
Pin to piston clearance at room temperature . . . . .	.0001" - .0005" loose
Inside diameter of connecting rod bushing - installed . . . . .	1.0001" - 1.0006"
Piston pin to connecting rod bushing clearance . . . . .	.00035" - .00105"

### PISTON RINGS

Number of rings per piston . . . . .	5
Location of oil rings . . . . .	One above and one below piston pin
Ring end gaps - top compression . . . . .	.007" minimum
2nd and 3rd compression . . . . .	.014" minimum
4th oil control . . . . .	.014" minimum
5th oil control . . . . .	.007" minimum
Clearance of rings in grooves	
Top compression . . . . .	.003" - .0045"
Top compression wear limit . . . . .	.008"
2nd and 3rd compression . . . . .	.002" - .004"
4th oil control . . . . .	.001" - .0075"
5th oil control . . . . .	.0015" - .0035"

### CRANKSHAFT

Connecting rod journal diameter . . . . .	1.9975" - 1.9985"
Main bearing journal diameter . . . . .	2.497" - 2.498"
Connecting rod journal width . . . . .	1.500" - 1.504"
Main bearing journal width	
Front bearing . . . . .	1.557" - 1.567"
Intermediate bearings . . . . .	1.318" - 1.326"
Center bearing . . . . .	1.875" - 1.879"
Rear bearing . . . . .	2.000"
Crankshaft end clearance . . . . .	.003" - .009"
End clearance wear limit . . . . .	.015"
Crankshaft journals may be ground to the following undersize . . . . .	.010" - .020" - .040"
Fit of crankshaft gear on crankshaft . . . . .	.001" - .003" tight

### MAIN BEARINGS

Number used . . . . .	5
Type . . . . .	Replaceable precision
Inside diameter - with capscrews tightened to specified torque . . . . .	2.4993" - 2.501"
Crankshaft main bearing journal diameter . . . . .	2.497" - 2.498"
Bearing to journal clearance (with capscrews torqued to specifications) . . . . .	.0013" - .004
Replace parts when bearing clearance exceeds . . . . .	.007"
Main bearing length - front	
Intermediates . . . . .	1.245" - 1.255"
Center . . . . .	1.120" - 1.130"
Rear . . . . .	1.870" - 1.872"
Undersize bearing available . . . . .	1.745" - 1.755"
Bearing wall thickness - standard . . . . .	.002" - .010" - .020" - .040"
Bearing bore in cylinder block cap in place and capscrews tightened to specified torque . . . . .	.0995" - .1000"
Main bearing capscrew torque . . . . .	2.6993" - 2.7000"
	120 - 130 ft. lbs.

# Ford Tractor R134a Capacity Guide

**M Mark**



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