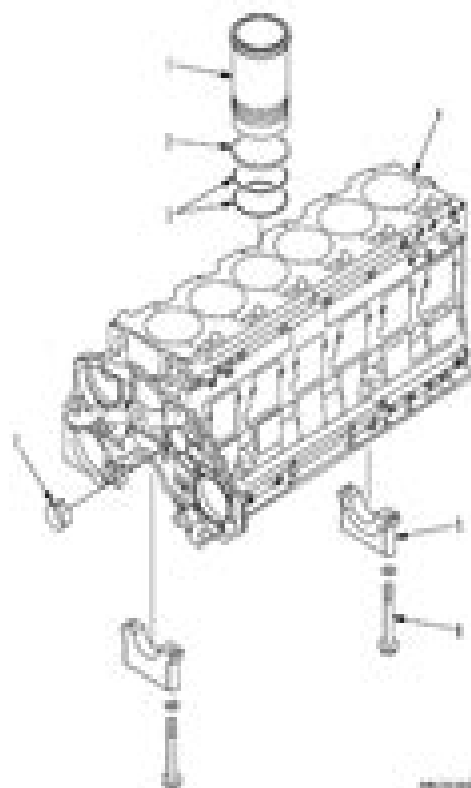


Cylinder block parts



1. Cylinder liner
2. Piston seal
3. Cylinder liner O-ring
4. Cylinder block
5. Main bearing cap
6. Main bearing cap bolt
7. Camshaft bearing

Testing and inspecting cylinder block

Unit: mm															
Type test	Inspection item	Judgement standards	Remedy												
A.	Crankshaft	Check for cracks (external color check) (cylinder head seal main piston, etc.)	Replace												
B.	Condition of contact of packing portion		Refine												
C.	Clearance from cylinder liner	 <table border="1"> <thead> <tr> <th colspan="4">Standard value</th> </tr> <tr> <th>Standard size</th> <th>Max. clearance of cylinder block</th> <th>Max. clearance of cylinder head</th> <th>Standard maximum</th> </tr> </thead> <tbody> <tr> <td>10.00</td> <td>10.00 ~ 10.04</td> <td>10.00 ~ 10.04</td> <td>0.04 ~ 0.06</td> </tr> </tbody> </table>	Standard value				Standard size	Max. clearance of cylinder block	Max. clearance of cylinder head	Standard maximum	10.00	10.00 ~ 10.04	10.00 ~ 10.04	0.04 ~ 0.06	Replace cylinder liner or cylinder head
Standard value															
Standard size	Max. clearance of cylinder block	Max. clearance of cylinder head	Standard maximum												
10.00	10.00 ~ 10.04	10.00 ~ 10.04	0.04 ~ 0.06												
D.	Inside diameter of camshaft bearing	• Inside diameter <table border="1"> <thead> <tr> <th>Standard size</th> <th>Standard value</th> <th>Standard limit</th> </tr> </thead> <tbody> <tr> <td>50</td> <td>49.998 ~ 49.999</td> <td>50.00</td> </tr> </tbody> </table> • Clearance from camshaft bearing <table border="1"> <thead> <tr> <th>Standard clearance</th> <th>Clearance limit</th> </tr> </thead> <tbody> <tr> <td>0.010 ~ 0.040</td> <td>0.15</td> </tr> </tbody> </table>	Standard size	Standard value	Standard limit	50	49.998 ~ 49.999	50.00	Standard clearance	Clearance limit	0.010 ~ 0.040	0.15	Replace bearing		
Standard size	Standard value	Standard limit													
50	49.998 ~ 49.999	50.00													
Standard clearance	Clearance limit														
0.010 ~ 0.040	0.15														
E.	Position of liner		Replace cylinder liner or correct cylinder block												
F.	Depth of notch/face and position of bottom surface	 <table border="1"> <thead> <tr> <th>Standard size</th> <th>Standard value</th> </tr> </thead> <tbody> <tr> <td>11</td> <td>11.00 ~ 11.02</td> </tr> </tbody> </table>	Standard size	Standard value	11	11.00 ~ 11.02	Repair by machining and etc.								
Standard size	Standard value														
11	11.00 ~ 11.02														
G.	Condition, wear of cylinder head mounting surface	• Check for corrosion <table border="1"> <thead> <tr> <th colspan="2">Maximum</th> <th>Repair limit</th> </tr> </thead> <tbody> <tr> <td>Overall top surface of block</td> <td>Max. 0.04</td> <td>0.10</td> </tr> <tr> <td>For one cylinder</td> <td>Max. 0.02</td> <td>0.08</td> </tr> </tbody> </table>	Maximum		Repair limit	Overall top surface of block	Max. 0.04	0.10	For one cylinder	Max. 0.02	0.08	Repair by machining			
Maximum		Repair limit													
Overall top surface of block	Max. 0.04	0.10													
For one cylinder	Max. 0.02	0.08													

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Two-cycle Diesel Engines, Model 71 General Motors Sales Corporation. Diesel Engine Division, 1938 Repair Manual for the Engine Types 1 VD 8/8-2 SL, 2 VD 8/8-2 SVL, 4 VD 8/8-2 SVL , 1983 **Maintenance Manual, Series 71 (2-cycle) Diesel Engine** General Motors Corporation. GMC Truck & Coach Division, 1957 *Chilton's Truck and Van Repair Manual* , 1971

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Table of Contents Komatsu S6d140 2 Sa6d140 2 Saa6d140 2 Engine Service Manual

1. Understanding the eBook Komatsu S6d140 2 Sa6d140 2 Saa6d140 2 Engine Service Manual
 - The Rise of Digital Reading Komatsu S6d140 2 Sa6d140 2 Saa6d140 2 Engine Service Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying Komatsu S6d140 2 Sa6d140 2 Saa6d140 2 Engine Service Manual
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Komatsu S6d140 2 Sa6d140 2 Saa6d140 2 Engine Service Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from Komatsu S6d140 2 Sa6d140 2 Saa6d140 2 Engine Service Manual

- Personalized Recommendations
- Komatsu S6d140 2 Sa6d140 2 Saa6d140 2 Engine Service Manual User Reviews and Ratings
- Komatsu S6d140 2 Sa6d140 2 Saa6d140 2 Engine Service Manual and Bestseller Lists
- 5. Accessing Komatsu S6d140 2 Sa6d140 2 Saa6d140 2 Engine Service Manual Free and Paid eBooks
 - Komatsu S6d140 2 Sa6d140 2 Saa6d140 2 Engine Service Manual Public Domain eBooks
 - Komatsu S6d140 2 Sa6d140 2 Saa6d140 2 Engine Service Manual eBook Subscription Services
 - Komatsu S6d140 2 Sa6d140 2 Saa6d140 2 Engine Service Manual Budget-Friendly Options
- 6. Navigating Komatsu S6d140 2 Sa6d140 2 Saa6d140 2 Engine Service Manual eBook Formats
 - ePub, PDF, MOBI, and More
 - Komatsu S6d140 2 Sa6d140 2 Saa6d140 2 Engine Service Manual Compatibility with Devices
 - Komatsu S6d140 2 Sa6d140 2 Saa6d140 2 Engine Service Manual Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Komatsu S6d140 2 Sa6d140 2 Saa6d140 2 Engine Service Manual
 - Highlighting and Note-Taking Komatsu S6d140 2 Sa6d140 2 Saa6d140 2 Engine Service Manual
 - Interactive Elements Komatsu S6d140 2 Sa6d140 2 Saa6d140 2 Engine Service Manual
- 8. Staying Engaged with Komatsu S6d140 2 Sa6d140 2 Saa6d140 2 Engine Service Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Komatsu S6d140 2 Sa6d140 2 Saa6d140 2 Engine Service Manual
- 9. Balancing eBooks and Physical Books Komatsu S6d140 2 Sa6d140 2 Saa6d140 2 Engine Service Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Komatsu S6d140 2 Sa6d140 2 Saa6d140 2 Engine Service Manual
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Komatsu S6d140 2 Sa6d140 2 Saa6d140 2 Engine Service Manual
 - Setting Reading Goals Komatsu S6d140 2 Sa6d140 2 Saa6d140 2 Engine Service Manual
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Komatsu S6d140 2 Sa6d140 2 Saa6d140 2 Engine Service Manual

- Fact-Checking eBook Content of Komatsu S6d140 2 Sa6d140 2 Saa6d140 2 Engine Service Manual
- Distinguishing Credible Sources

13. Promoting Lifelong Learning

- Utilizing eBooks for Skill Development
- Exploring Educational eBooks

14. Embracing eBook Trends

- Integration of Multimedia Elements
- Interactive and Gamified eBooks

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