OIL SCRAPER RINGS

Number on each piston	1
Height	4.74 mm (0.186″)
Scraper ring clearance in groove	0.040—0.072 mm (0.0016—0.0028″)

GUDGEON PINS

Floating fit. Circlips at both ends in piston.

Fit:	
In connecting rod	Close running fit
In piston	Push fit
Diameter, standard	22.00 mm (0.866″)

CYLINDER HEAD

	B 20 A	B 20 B	B 20 E	B 20 F
Height, measured from cylinder contact face to face for bolt heads	86.7 mm (3.41″)	86.2 mm (3.39″)	84.9 mm (3.34″)	87.0 mm (3.42″)
Cylinder head gasket, thickness, standard, unloaded	1.4 mm (0.055″)	0.8 mm (0.031″)	0.8 mm (0.031″)	1.2 mm (0.047″)
loaded	1.2 mm (0.047″)	0.7 mm (0.028″)	0.7 mm (0.028″)	1.0 mm (0.039″)
Distance from top side of head to overflow pipe upper end (pipe placed under thermostat)	35 mm (1.38″)			

CRANKSHAFT

Crankshaft, end float	0.047—0.137 mm (0.0018—0.0054″)
Main bearings, radial clearance	0.028—0.083 mm (0.0011—0.0033″)
Big-end bearings, radial clearance	0.029—0.071 mm (0.0012—0.0028″)

MAIN BEARINGS

MAIN BEARING JOURNALS

Diameter, standard	63.451—63.464 mm (2.4981—2.4986″)
Undersize 0.010″	63.197—63.210 mm (2.4881—2.4886″)
0.020″	62.943—62.956 mm (2.4781—2.4786″)
Width on crankshaft for pilot bearing shell	
Standard	38.960—39.000 mm (1.5338—1.5351″)
Oversize 1 (undersize bearing shell 0.010″)	39.061—39.101 mm (1.5438—1.5451″)
2 (undersize bearing shell 0.020″)	39.163—39.203 mm (1.5538—1.5551″)

BIG-END BEARINGS

BIG-END BEARING JOURNALS

Width of bearing recess	31.950—32.050 mm (1.2579—1.2618″)
Diameter, standard	54.099—54.112 mm (2.1299—2.1304″)
Undersize 0.010″	53.845—53.858 mm (2.1199—2.1204″)
0.020″	53.591—53.604 mm (2.1099—2.1104″)

CONNECTING RODS

End float on crankshaft	0.15—0.35 mm (0.006—0.014″)
Max. permissible weight deviation between connecting rods in same engine	6 grammes (0.21 oz.)

FLYWHEEL

Permissible axial throw, max.	0.05 mm (0.002″) at a diameter of 150 mm (5.9″)

FLYWHEEL HOUSING

Max. axial throw for rear face	0.05 mm (0.002″) at a diameter of 100 mm (3.9″)
Max. radial throw for rear guide	0.15 mm (0.006″)