

aligned as indicated on pulley (Example: 1 and 6 cylinders for A or 1-6 "VS"). On one cylinder of the pair, both rocker levers will be free and valves closed, this is cylinder to be adjusted.

5. Adjust injector plunger first, then crossheads and valves to clearances indicated in the following paragraphs.

Injector Plunger Adjustment — Torque Method

The injector plungers are adjusted with a torque wrench and a screwdriver adapter to a definite torque setting. See Fig. 14-101.

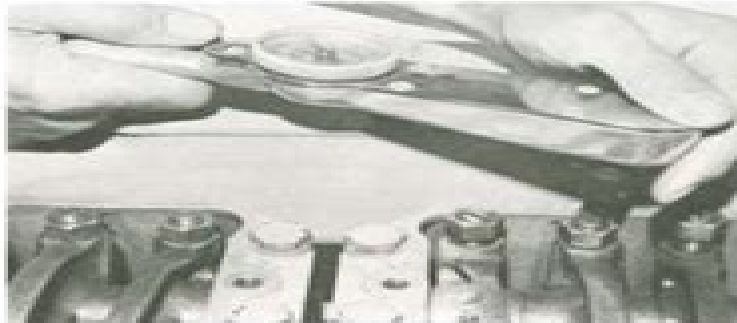


Fig. 14-101, DN114063. Adjusting injector plunger

1. Turn adjusting screw down until plunger contacts cup and advance an additional 15 degrees to squeeze oil from cup.

2. Loosen adjusting screw one turn; then, tighten adjusting screw making two or three passes with torque wrench, to values shown in Table 14-14.

Table 14-14: Injector Adjustment (Oil Temperature)

Cold Set	Hot Set
Cast Iron Rocker Housing	
48 inch-lb [5.4 N•m]	72 inch-lb [8.1 N•m]
Aluminum Rocker Housing	
72 inch-lb [8.1 N•m]	72 inch-lb [8.1 N•m]

Note: Set torque wrench on value required and pull to "0".

Break adjusting screw loose and pull torque to value shown on each tightening pass.

3. Tighten locknut to 30 to 40 ft-lbs [41 to 54 N•m] torque. If ST-669 Torque Wrench Adapter is used, torque to 25 to 35 ft-lbs [34 to 47 N•m].

Crosshead Adjustment

See Crosshead Adjustment (Dial Indicator Method).

Valve Adjustment — Torque Method

The same engine position used in adjusting injectors is used for setting intake and exhaust valves.

1. While adjusting valves, make sure that the compression release, on those engines so equipped, is in running position.

Table 14-15: Valve Clearance — Inch [mm]

Intake Valves		Exhaust Valves	
Cold Set	Hot Set	Cold Set	Hot Set
Aluminum Rocker Housing			
0.014 [0.36]	0.014 [0.36]	0.027 [0.69]	0.027 [0.69]
Cast Iron Rocker Housing			
0.016 [0.41]	0.014 [0.36]	0.029 [0.74]	0.027 [0.69]

2. Loosen locknut and back off adjusting screw. Insert feeler gauge between rocker lever and crosshead. Valve clearances are shown in Table 14-15. Turn screw down until lever just touches gauge and lock in this position. Tighten locknut to 30 to 40 ft-lbs [41 to 54 N•m] torque. When using ST-669 torque to 25 to 35 ft-lbs [34 to 47 N•m].

3. Continue to bar engine to next "VS" mark and adjust each cylinder in firing order. See Table 14-12.

After injector and valve adjustment is completed, bar or crank (in chassis overhaul) engine several revolutions to properly seat adjusting screws, plunger links, push tubes, etc. to mating surfaces. Take break-away torque reading on injector plunger adjusting screws. Break-away torque must be the same as adjustment torque. See Table 14-14. Re-adjust as necessary.

Jacobs Brake

Install Jacobs Brake, if used. See Group 20.

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