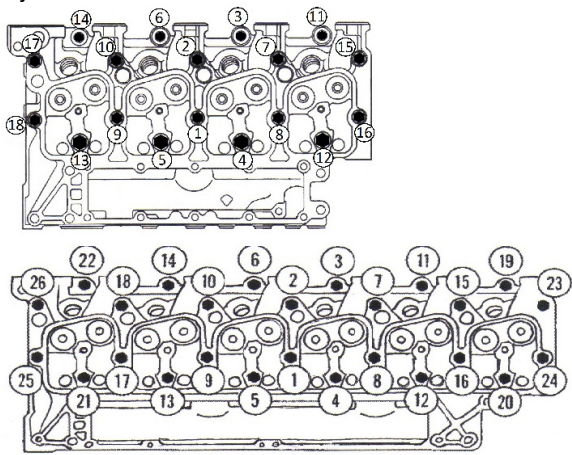


# Torque and Rebuild Specifications for Cummins Four and Six Cylinder B Series Engines in Industrial and Generator Applications with Front Gear Trains



Rocker Cover	18 ft. lbs.											
Cylinder Head Bolts	 <p>Tighten all to 66ft. lb. in sequence  Tighten Long Bolts(4,5,12,13 on 4B;  4,5,12,13,20,21 on 6B) to 89ft. lb.  Tighten Short Bolts  (All others not noted above) to 66 ft. lb.  Tighten All Long Bolts again to 89ft. lb.  Tighten all in sequence 90 Degrees</p>											
Main Bearing Cap Torque	37ft. lbs. 44ft. lbs. 66ft. lbs. +90° Starting at center main cap and work outwards.											
Piston Protrusion	0.024" – 0.028"											
Connecting Rod Bolt	22ft. lbs. 44ft. lbs. +60°											
Standard Cylinder Bore	4.0161" – 4.0177"											
Cylinder Bore Out-of-round	0.0015" Max											
Cylinder Bore Taper	0.003" Max											
Piston Skirt to Liner Clearance	0.0048" – 0.0089"											
Crankshaft End Play	0.004" – 0.017"											
Valve Adjust Sequence	Cyl 1		Cyl 2		Cyl 3		Cyl 4		Cyl 5		Cyl 6	
	I	E	I	E	I	E	I	E	I	E	I	E
	X	X	X			X	X			X		
				X	X			X	X			X
Valve Clearance (set cold)	0.010" Intake 0.020" Exhaust											