Torque and Rebuild Specifications for International Harvester D414 Engines

Cylinder Liner Protrusion	.002” - .005”
Main Bearing Cap	115 ft. lbs.
Connecting Rod Bolt	60 ft. lbs., 130 ft. lbs.
Piston Protrusion	.008” - .025”
Crankshaft End Play	.006” - .012”
Cylinder Head Bolts **SEQUENCE “A”** 20 12 4 5 13 21 24 16 8 1 9 17 25 23 15 7 2 10 18 26 19 11 3 6 14 22 ←FRONT INTAKE SIDE **SEQUENCE “B”** 21 22 23 24 25 26 14 15 16 17 18 19 20 7 8 9 10 11 12 13 1 2 3 4 5 6 ←FRONT INTAKE SIDE	110 ft. lbs. Sequence A 155 ft. lbs. Sequence A 165 ft. lbs. Sequence B Re-torque and check valve lash after one hour of operation.
Valve Clearance (set cold) ESN ->126953 ESN 123954->	I .020” E .025” I .025” E .025”
w/ #1 @ TDC Comp Adjust	#1IE, #2I, #3E, #4I, #5E
w/ #1 @ TDC Exhaust Adjust	#2E, #3I, #4E, #5E, #6IE