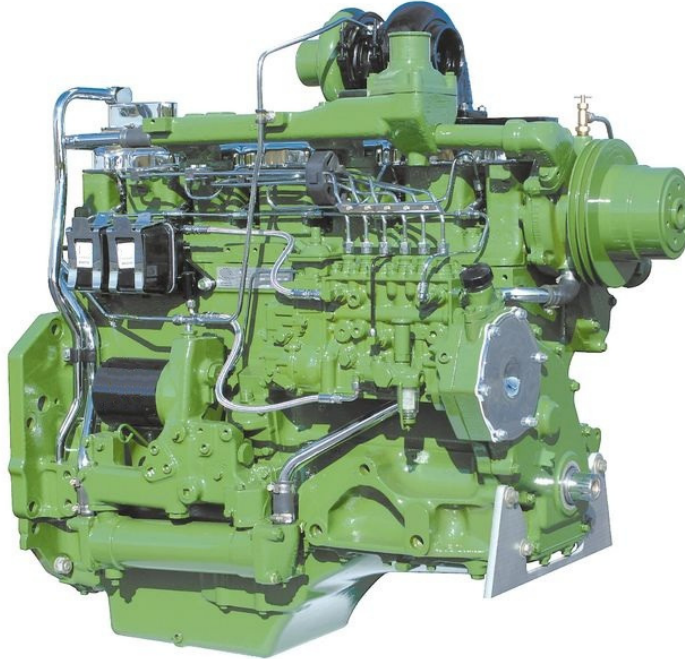


Torque and Rebuild Specifications for John Deere 6-619 Engines



| | |
|---|--|
| Cylinder Liner Protrusion | .001" - .004" |
| Main Bearing Cap Screws | 210 ft. lbs. |
| Connecting Rod Cap Screws | Blind Hole First 20 ft. lbs. 55 ft. lbs. +90° |
| Piston Protrusion | .003" - .010" |
| Crankshaft End Play | .004" - .011" |
| Cylinder Head Cap Screws | Grade 8/10.9 150 ft. lbs. 180 ft. lbs. Re-torque* Grade 180/12.9 200 ft. lbs. 240 ft. lbs. Re-torque* |
| <p style="text-align: center;">FRONT </p> | |
| *Wait at least two hours after final torque and loosen each cap screw in sequence 1/2 to 1/4 turn and re-tighten to final torque. | |
| Rocker Arm Shaft Clams | 65 ft. lbs. |
| Valve Clearance (set cold) (2 Valve Head) | 1 .015" E .025" |
| w/ #1 @ TDC Comp Adjust | #11&E, #2I, #3E, #4I, #5E |
| w/ #1 @ TDC Exhaust Adjust | #2E, #3I, #4E, #5I, #6I&E |
| Rocker Cover Bolts | Grade 2 - 20 in. lbs. Grade 5 - 96 in. lbs. |