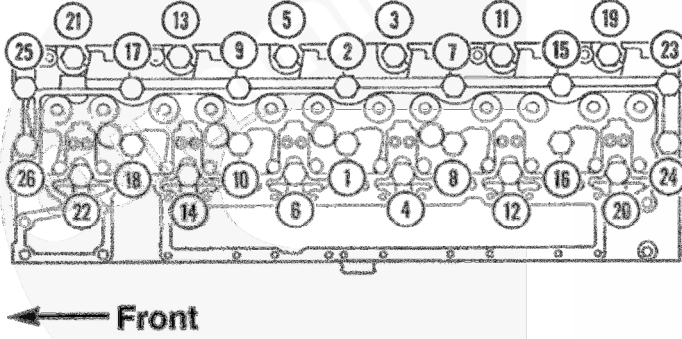


### Cummins 8.3l C Series Engines

Cylinder Bore	4.488 – 4.450"    114.00 – 114.04mm																																																					
Cylinder Bore Out-of-round	0.002" Max																																																					
Cylinder Bore Taper	0.002" Max																																																					
Main Bearing Cap Torque	37ft. lbs. 70ft. lbs. +60° Starting at center main cap and work outwards.																																																					
Connecting Rod Bolt	22ft. lbs. 44ft. lbs. +60°																																																					
Crankshaft End Play	0.005 – 0.013"																																																					
Cylinder Head Bolts	 <p>Pre 1991 30ft. lbs. 111ft. lbs. 162ft. lbs.</p> <p>Post 1991 – Used block and Capscrews</p> <ol style="list-style-type: none"> <li>1. Torque all in sequence to 52ft. lbs.</li> <li>2. Torque 14 Long (1,2,7,8,9,10,15,16,17,18, 23,24,25,26) to 107ft. lbs.</li> <li>3. Torque Short (3,4,5,6,11,12,13,14,19,20,21,22) to 52ft. lb. (70Nm)</li> <li>4. Repeat step 2.</li> <li>5. Tighten all in sequence an additional 90°.</li> </ol>																																																					
Valve Adjust Sequence	<table border="1"> <thead> <tr> <th></th> <th colspan="2">Cyl 1</th> <th colspan="2">Cyl 2</th> <th colspan="2">Cyl 3</th> <th colspan="2">Cyl 4</th> <th colspan="2">Cyl 5</th> <th colspan="2">Cyl 6</th> </tr> <tr> <th></th> <th>I</th> <th>E</th> <th>I</th> <th>E</th> <th>I</th> <th>E</th> <th>I</th> <th>E</th> <th>I</th> <th>E</th> <th>I</th> <th>E</th> </tr> </thead> <tbody> <tr> <td>TDC #1</td> <td>X</td> <td>X</td> <td>X</td> <td></td> <td></td> <td>X</td> <td>X</td> <td></td> <td></td> <td>X</td> <td></td> <td></td> </tr> <tr> <td>TDC #6</td> <td></td> <td></td> <td></td> <td>X</td> <td>X</td> <td></td> <td></td> <td>X</td> <td>X</td> <td></td> <td>X</td> <td>X</td> </tr> </tbody> </table>			Cyl 1		Cyl 2		Cyl 3		Cyl 4		Cyl 5		Cyl 6			I	E	I	E	I	E	I	E	I	E	I	E	TDC #1	X	X	X			X	X			X			TDC #6				X	X			X	X		X	X
	Cyl 1		Cyl 2		Cyl 3		Cyl 4		Cyl 5		Cyl 6																																											
	I	E	I	E	I	E	I	E	I	E	I	E																																										
TDC #1	X	X	X			X	X			X																																												
TDC #6				X	X			X	X		X	X																																										
Valve Clearance (set cold)	0.012" Intake 0.024" Exhaust																																																					
Rocker Cover	18 Ft. Lbs.																																																					