

TOLERANCES TABLE

825, GTL & GTLA

SUPERIOR MODEL 40 PTD, DIESEL, DUAL FUEL

Free standing height of inner spring	5-3/8" ± 1/64"	5-21/32" ± 1/64"
Free standing height of outer spring	6-17/32" ± 1/64"	5-7/35" ± 1/64"
Minimum thickness of cylinder head	7.406"	7.391"
Depth between the combustion chamber surface and the cylinder head surface	0.226" - 0.228"	0.255" - 0.217"
Depth between the surface of the combustion chamber and low surfaces of seats (Intake)	1.025" - 1.030"	N/A
Depth between the surface of the combustion chamber and low surfaces of seats (Exhaust)	1.025" - 1.030"	N/A
Internal diameter of the hole for the intake valve	4.623" - 4.624"	N/A
Internal diameter of the hole for the exhaust valve	3.934" - 3.935"	N/A
Concentricity of the internal diameters of the seats of the valves	0.0005"	0.001"
Internal diameter of the guide holes	1.375" - 1.376"	1.251" - 1.250"
Interference values for the guides to head	0.001" - 0.0015"	0.001" - 0.0015"
Interference values for the seats to head	0.0045" - 0.0065"	0.0045" - 0.0065"
Internal diameter of the guides	0.873" - 0.875"	0.6875" - 0.6885"
External diameter of the stem of the valve	0.870" - 0.871"	0.682" - 0.683"
Clearance between the stem of the valve and the guide	0.002" - 0.004"	0.0045" - 0.0065"