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< Product: GEN SET ENGINE
Model: 3056 GEN SET ENGINE 7AK
Configuration: 3056 Generator Set Engine 7AK00001-UP

Specifications

3054 and 3056 Industrial and Generator Set Engines

Media Number -SENR5541-08

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i01714474

Cylinder Head

SMCS - 1100

3054 Engine

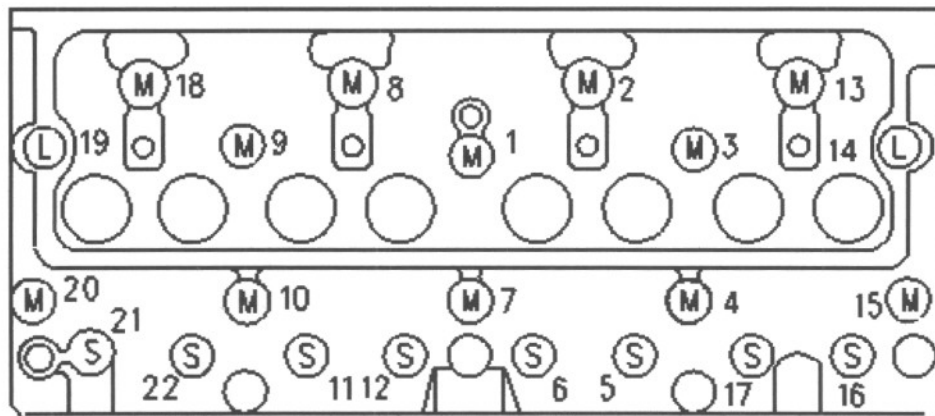


Illustration 1

g00882464

Use the following procedure in order to tighten the bolts for the cylinder head:

1. Put clean engine oil on the threads of the bolts. The bolts are tightened in the numerical sequence that is shown in Illustration 1.

Torque for bolts ... 110 N·m (80 lb ft)

2. Repeat the procedure in Step 1 to ensure that all of the bolts are tightened to the correct torque.

Torque for bolts ... 110 N·m (80 lb ft)

3. Use the numerical sequence that is shown in Illustration 1 to tighten the bolts for the additional torque-turn specification.
 - a. Tighten the short bolts (S) for an additional 150 degrees (2.5 flats).
 - b. Tighten the medium sized bolts (M) for an additional 180 degrees (3.0 flats).
 - c. Tighten the long bolts (L) for an additional 210 degrees (3.5 flats).

Cylinder head thickness ... 102.79 to 103.59 mm (4.047 to 4.078 inch)

Minimum permissible thickness after the cylinder head face has been resurfaced. ... 102.48 mm (4.035 inch)

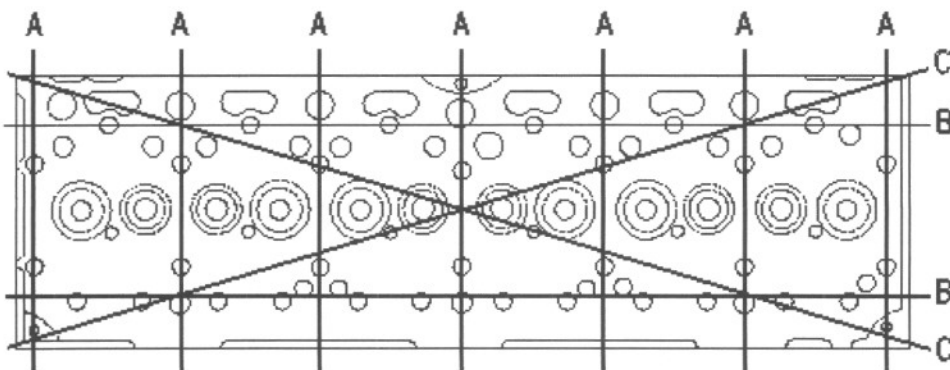


Illustration 2

g00295372

Maximum distortion of the cylinder head is given in the following table.

Table 1

Dimension	Maximum Permissible Distortion
Width "A"	

	0.08 mm (0.003 inch)
Length "B"	0.15 mm (0.006 inch)
Diagonal "C"	0.15 mm (0.006 inch)

3056 Engine

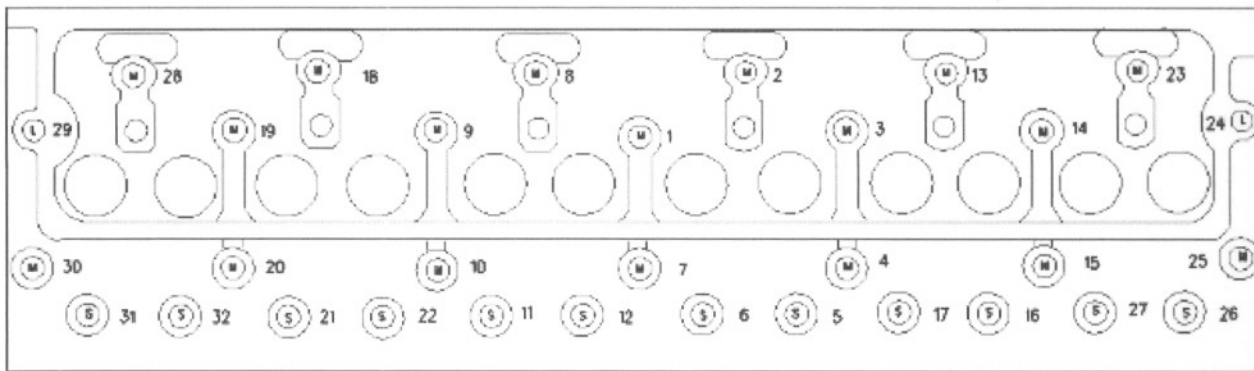


Illustration 3

g00876966

Use the following procedure in order to tighten the bolts for the cylinder head:

1. Put clean engine oil on the threads of the bolts. The bolts are tightened in the numerical sequence that is shown in Illustration 3.

Torque for bolts ... 110 N·m (80 lb ft)

2. Repeat the procedure in Step 1 to ensure that all of the bolts are tightened to the correct torque.

Torque for bolts ... 110 N·m (80 lb ft)

3. Use the numerical sequence that is shown in Illustration 3 to tighten the bolts for the additional torque-turn specification.

- a. Tighten the short bolts (S) for an additional 150 degrees (2.5 flats).

- b. Tighten the medium sized bolts (M) for an additional 180 degrees (3.0 flats).

- c. Tighten the long bolts (L) for an additional 210 degrees (3.5 flats).

Cylinder head thickness ... 102.79 to 103.59 mm (4.047 to 4.078 inch)

Minimum permissible thickness after the cylinder head face has been resurfaced. ... 102.48 mm (4.035 inch)

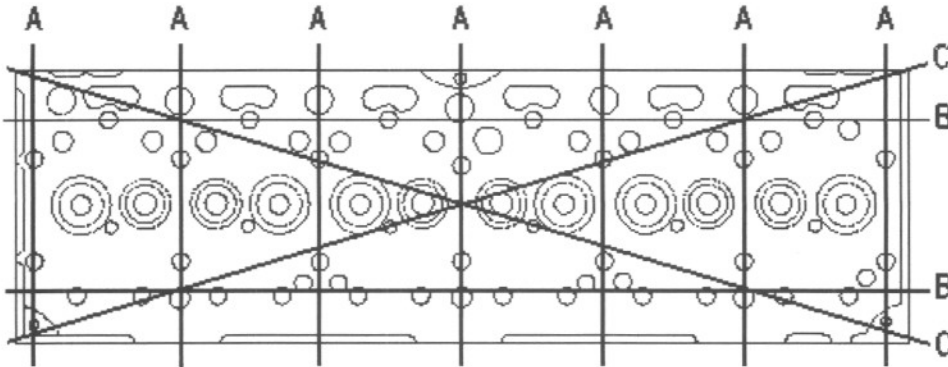


Illustration 4

g00295372

Maximum distortion of the cylinder head is given in the following table.

Table 2

Dimension	Maximum Permissible Distortion
Width "A"	0.13 mm (0.005 inch)
Length "B"	0.25 mm (0.010 inch)
Diagonal "C"	0.25 mm (0.010 inch)