

Trevor Morris Engines KF 2.5 V6. Torque Settings

Liner Clamp Plate Centre Bolts	16 lb-ft	
Sump 3/8" Nuts (in stages)	43/45 lb-ft	
Sump 5/16" Nuts (in stages)	14 lb-ft	
Sump M6 Nuts	70 lb-ins	
Intermediate Gear/Sprocket Bolts (M5)	90 lb-ins	
Intermediate Gear/Sprocket Bolts (M4)	60 lb-ins	
Intermediate Gear Centre Nuts (M7)	10 lb-ft	
Fixed Chain Guide Screws	70 lb-ins	
Adjustable Chain Guide Screws	70 lb-ins	
Crankshaft Gear Bolts	32 lb-ft	
Aux Drive Chain Adjuster Bolt (M8)	17 lb-ft	
Cam Chain Adjuster Centre Bolt (M6)	9/10 lb-ft	a.s.p.
Cam Chain Adjuster Plate Bolts (M8)	15 lb-ft	
Cam Sproket Screws	14/15 lb-ft	
Cyl Head Studs	20 lb-ft	
Cyl Head Nuts (inner 4)	15 lbs +65 +40 +40	
(outer 4)	10 lbs +65 +40 +40	In Sequence
Cam Cap Nuts	14 lb-ft	
Spark Plugs (With Graphogen)	8/9 lb-ft	
Trumpet Screws	20/24 lb-ins	

KF 2.5 V6**Limits & Clearances**

Item	Min	Max
Trust Washer Nip	zero - 004"	below
Con rod Max Twist		0025"
Con rod Max Bend		0025"
Main Brg Clr	0015"	0025"
Big end Brg Clr	0015"	002"
Crank End Float	006"	012"
Con rod End Float	006/012" new	018" run
Gudgeon Pin End Float	002"	012"
Squish Clr	022"	024"
Piston Ring (top) Gap	009"	014"
Piston Ring (oil) Gap	009"	028"
Sealing Ring Stand Off	006"	
Cyl Leakage (head fitted)		10%
Camshaft End Float	002"	006"
ChainTension (cam)	3.75mm	4.25mm
Chain Tension (aux drive)	3.75mm	4.25mm
Top Rubbing Strip Clr	006"	010"
Firing Order	1-2-3-4-5-6	