

## Trevor Morris Engines KF 2.5 V6. Torque Settings

Liner Clamp Plate Centre Bolts		21.5 Nm
Sump 3/8" Nuts (in stages)		59/61 Nm
Sump 5/16" Nuts (in stages)		19 Nm
Sump M6 Nuts		9 Nm
Big End Bolts (ARP 300-6702) Oil/Graph		0.165 / 0.178 mm Stretch
Intermediate Gear/Sprocket Bolts (M5)		10 Nm
Intermediate Gear/Sprocket Bolts (M4)		7 Nm
Intermediate Gear Centre Nuts (M7)		13.5 Nm
Fixed Chain Guide Screws		8 Nm
Adjustable Chain Guide Screws		8 Nm
Crankshaft Gear Bolts		44 Nm
Aux Drive Chain Adjuster Bolt (M8)		23 Nm
Cam Chain Adjuster Centre Bolt (M6)		13 Nm a.s.p.
Cam Chain Adjuster Plate Bolts (M8)		21 Nm
Cam Sproket Screws		19/20 Nm
Cyl Head Studs		27 Nm
Cyl Head Nuts (inner 4)	21 Nm +65 +40 +40	
(outer 4)	14 Nm +65 +40 +40	In Sequence
Cam Cap Nuts		19 Nm
Spark Plugs (With Graphogen)		11/12 Nm
Trumpet Screws		2.5 Nm
Crankshaft rear drive hub (flywheel)		72/74 Nm

**KF 2.5 V6****Limits & Clearances**

<b>Item</b>	<b>Min</b>	<b>Max</b>
Trust Washer Nip	zero	- 0.1 below
Con rod Max Twist		.065
Con rod Max Bend		.065
Main Brg Clr	.038	.0635
Big end Brg Clr	.038	.051
Crank End Float	.153	.30
Con rod End Float	.153/.30 new	.457 run
Gudgeon Pin End Float	.051	.30
Squish Clr	.56	.61
Piston Ring (top) Gap	.24	.39
Piston Ring (oil) Gap	.24	.71
Sealing Ring Stand Off	.153	
Cyl Leakage (head fitted)		10%
Camshaft End Float	.051	.153
ChainTension (cam)	3.75mm	4.25mm
Chain Tension (aux drive)	3.75mm	4.25mm
Top Rubbing Strip Clr	.153	.26
Firing Order	1-2-3-4-5-6	

ASP Anti Scuffing Paste

Oil on all threads & under head, unless otherwise specified.