

Illustration 3  
Front face of the cylinder block

g01413748

The flatness of the top contact surface of the cylinder block must be within 0.05 mm (0.002 inch) for any 150 mm (5.9 inch) section of the surface.

(2) Torque for the bolt that holds the piston cooling jet ...  $30 \pm 7$  N·m ( $22 \pm 5$  lb·ft)

(3) Apply 6V-6640 Sealant to the outside diameter of the cup plug prior to installation into the cylinder block. Install the cup plug to the following depth. ...  $1.25 \pm 0.25$  mm ( $0.049 \pm 0.010$  inch)

Use the following procedure in order to install the main bearing cap bolts (4) :

1. The main bearing caps are numbered 1 through 7. Ensure that the main bearing caps are in the correct location. The part number on the main bearing cap must face to the right side and toward the front of the block. Orient the main bearing cap correctly in the cylinder block. If caps are oriented correctly, the tab slots that are in the block and in the main bearing caps will be adjacent.

# C12 Engine Manual

**LP Steffe**

A red circular graphic with a gradient, appearing as a stylized arrow or a partial circle, located to the right of the 'LP Steffe' text.

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## **Table of Contents C12 Engine Manual**

1. Understanding the eBook C12 Engine Manual
  - The Rise of Digital Reading C12 Engine Manual
  - Advantages of eBooks Over Traditional Books
2. Identifying C12 Engine Manual
  - Exploring Different Genres
  - Considering Fiction vs. Non-Fiction
  - Determining Your Reading Goals
3. Choosing the Right eBook Platform
  - Popular eBook Platforms
  - Features to Look for in an C12 Engine Manual
  - User-Friendly Interface
4. Exploring eBook Recommendations from C12 Engine Manual
  - Personalized Recommendations
  - C12 Engine Manual User Reviews and Ratings
  - C12 Engine Manual and Bestseller Lists
5. Accessing C12 Engine Manual Free and Paid eBooks
  - C12 Engine Manual Public Domain eBooks
  - C12 Engine Manual eBook Subscription Services
  - C12 Engine Manual Budget-Friendly Options

6. Navigating C12 Engine Manual eBook Formats
  - ePub, PDF, MOBI, and More
  - C12 Engine Manual Compatibility with Devices
  - C12 Engine Manual Enhanced eBook Features
7. Enhancing Your Reading Experience
  - Adjustable Fonts and Text Sizes of C12 Engine Manual
  - Highlighting and Note-Taking C12 Engine Manual
  - Interactive Elements C12 Engine Manual
8. Staying Engaged with C12 Engine Manual
  - Joining Online Reading Communities
  - Participating in Virtual Book Clubs
  - Following Authors and Publishers C12 Engine Manual
9. Balancing eBooks and Physical Books C12 Engine Manual
  - Benefits of a Digital Library
  - Creating a Diverse Reading Collection C12 Engine Manual
10. Overcoming Reading Challenges
  - Dealing with Digital Eye Strain
  - Minimizing Distractions
  - Managing Screen Time
11. Cultivating a Reading Routine C12 Engine Manual
  - Setting Reading Goals C12 Engine Manual
  - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of C12 Engine Manual
  - Fact-Checking eBook Content of C12 Engine Manual
  - Distinguishing Credible Sources
13. Promoting Lifelong Learning
  - Utilizing eBooks for Skill Development
  - Exploring Educational eBooks
14. Embracing eBook Trends
  - Integration of Multimedia Elements

- Interactive and Gamified eBooks

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