

**Valve springs - vehicle, M50 and M50T engines**

Fitted length	34.7 mm (1.37 in)
Load at fitted length	150 N (34.0 lbf) to 20.0 kgf
Number of active coils	4.5
Number of damper coils	0
Direction of coils	Left hand
Identification colour	Orange

**Valve springs - 500 and M50 engines**

Fitted length	34.7 mm (1.37 in)
Load at fitted length	142/137 N (32/30 lbf) 14.5/13.0 kgf
Number of active coils	5.2
Number of damper coils	0
Direction of coils	Left hand
Identification colour	White

**Pistons and skirts****Materials:**

- Vehicle, M50 and M50T engines
- 500 and M50 engines

Steel  
Cast iron

Outside diameter of skirt 31.725/31.745 mm (1.2490/1.2480 in)

Clearance of skirt in cylinder head 0.050/0.055 mm (0.0020/0.0020 in)

Thickness of skirt head 0.55/0.50 mm (0.2165/0.212 in)

**Skirt length:**

- Vehicle, M50 and M50T engines
- 500 and M50 engines

25.7/26.3 mm (1.01/1.04 in)  
25.7/26.3 mm (1.01/1.04 in)

Skirt thickness Range of 45 gms; from 2.080 mm (0.080 in) to 2.400 mm (0.094 in) in grades of 0.025 mm (0.001 in)

**Camshaft**

Diameter of front and rear journals

47.860/47.875 mm (1.8853/1.8880 in)

Diameter of centre journal

47.860/47.875 mm (1.8853/1.8880 in)

Clearance of journals in bores:

- Front and rear
- Centre

0.040/0.004 mm (0.0017/0.0001 in)  
0.040/0.000 mm (0.0017/0.0000 in)

Diameter for pulley hub

36.58/36.61 mm (1.440/1.441 in)

Cam lift - vehicle, M50 and M50T engines:

- Intake and exhaust

9.344/9.724 mm (0.3717/0.3828 in)

Cam lift - 500 and M50 engines:

- Intake (camshaft part number 1, 141DP11)
- Intake (camshaft part number 1, 141DP02)
- Exhaust

9.344/9.004 mm (0.3680/0.3543 in)  
9.344/9.324 mm (0.3681/0.3632 in)  
9.344/9.524 mm (0.3679/0.3750 in)

End float

0.11/0.27 mm (0.004/0.011 in)

Maximum permissible end float in service

0.50 mm (0.020 in)

Width of recess for thrust washer

0.05/0.12 mm (0.002/0.004 in)

**Camshaft thrust washer**

Type

1 907 weather fitted in camshaft cover

Thickness

0.80/0.85 mm (0.031/0.034 in)

Transition fit of thrust washer in camshaft cover recess

± 0.05 mm (± 0.002 in)

# Perkins M80t Manual

**John Harold Haynes, P. B. Ward**



**Perkins M80t Manual:**

*Workshop Manual for (Perkins) 6.372, 6.3542, T6.354, Ind. & Ag. and 6.354 Diesel Engines* Perkins Engines Limited,1976  
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