



Torque and Rebuild Specifications for International Harvester® D414 Engines.



Cylinder Liner Protrusion
 Main Bearing Cap Bolt
 Connecting Rod Cap Bolt
 Piston Protrusion
 Crankshaft End Play
 Cylinder Head Bolts

SEQUENCE "A"

20	12	4	5	13	21	
24	16	8	1	9	17	25
23	15	7	2	10	18	26
19	11	3	6	14	22	

FRONT

INTAKE SIDE

SEQUENCE "B"

21	22	23	24	25	26	
14	15	16	17	18	19	20
7	8	9	10	11	12	13
1	2	3	4	5	6	

FRONT

INTAKE SIDE

Valve Clearance (set cold)

ESN ->126953
 ESN 123954->

w/ #1 @ TDC Comp Adjust
 w/ #1 @ TDC Exhaust Adjust

.002" - .005"
 115 ft. lbs.
 60 ft. lbs., 130 ft. lbs.
 .008" - .025"
 .006" - .012"

110 ft. lbs.
 Sequence A
 155 ft. lbs.
 Sequence A

165 ft. lbs.
 Sequence B

Re-torque and check
 valve lash after one
 hour of operation.

1 .020" E .025"
 1 .025" E .025"
 #11E, #21, #3E, #4I, #5E
 #2E, #3I, #4E, #5E, #6IE

For further assistance, please contact Reliance Customer Service: (800) 776-3113