Critical Dimensions – HD Compressors

Sizes 161, 162, 163, 172 and 173

Description		Part No.	Dimension (in.)	Tolerance	HD161	HD162	HD163	HDS162	HD172	HD173	HDL172	HDL173	HDS172
Crank Shaft	Connecting Rod Journal OD	792157	1.750	Min	X	X	X	X	X	X	X	X	X
	Lateral Movement	all	.0015 to .0030	Min - Max	X	X	X	X	X	X	X	X	X
Connecting Rod	Roller Bearing Bore (Wrist Pin End)	792301	1.124	Max	X	X	X	X	X	X	X	X	X
	Crank End Bore ID	792301	1.876	Max	X	X	X	X	X	X	X	X	X
Wrist Pin	OD	792014	0.8748	Min	X	X	X	X	X	X	X	X	X
Crosshead Assy	Wrist Pin Bore ID (Iron)	792029	0.875	Max	X								
		792406	0.875	Max			X			X		X	
		792429	0.875	Max		X			X		X		
		792501	0.875	Max				X					X
	Crosshead OD (Iron)	792029	3.430	Min	X								
		792406	3.430	Min			X			X		X	
		792429	3.430	Min		X			X		X		
		792501	3.430	Min				X					X
	Piston Rod OD	792029	0.749	Min	X								
		792406	0.749	Min			X			X		X	
		792429	0.749	Min		X			X		X		
		792501	0.749	Min				X					X
Crosshead Guide	ID	792091	3.437	Max	X								
		792455	3.437	Max		X	X	X	X	X	X	X	X
Cylinder	Bore (1st Stage)	792101	3.002	Max	X	X	X	X					
		792321	3.002	Max							X	X	
		792457	3.002	Max					X	X			X
	Bore (2nd Stage)	792321	1.752	Max							X	X	
		792457	1.752	Max					X	X			X
Deck Height	Piston to Head Clearance (Checked cold)	From IOM	.010 to .025	Min - Max	X								
			.015 to .030	Min - Max		X		X	X		X		X
			.025 to .040	Min - Max			X			X		X	

Critical Dimensions – HD Compressors

Sizes 322, 323, 342, 343, 361, 362, 363

	Description	Part No.	Dimension (in.)	Tolerance	HDL322	HDL323	HDL342	HDL343	HD361	HD362	HD363	HDL362	HDL363	HDS362
Crank Shaft	Connecting Rod Journal OD	793157	1.750	Min	X	X	X	X	X	X	X	X	X	X
	Lateral Movement	N/A	.0015 to .0030	Min - Max	X	X	X	X	X	X	X	X	X	X
Connecting Rod	Roller Bearing Bore (Wrist Pin End)	793009	1.001	Max	X	X	X			X		X		
		793309	1.312	Max				X	X		X		X	X
	Crank End Bore ID	793009	1.876	Max	X	X	X			X		X		
		793309	1.876	Max				X	X		X		X	X
Wrist Pin	OD	793307	0.9998	Min	X	X	X	X	X	X	X	X	X	X
Crosshead Assy	Wrist Pin Bore ID (Iron)	793301	1.000	Max					X					
		793302	1.000	Max	X		X			X		X		
		793303	1.000	Max		X		X			X		X	
		793501	1.000	Max										X
	Crosshead OD (Iron)	793301	3.993	Min					X					
		793302	3.993	Min	X		X			X		X		
		793303	3.993	Min		X		X			X		X	
		793501	3.993	Min										X
	Piston Rod OD	793301	0.749	Min					X					
		793302	0.749	Min	X		X			X		X		
		793303	0.749	Min		X		X			X		X	
		793501	0.749	Min										X
Crosshead Guide	ID	793091	4.002	Max					X					
		793455	4.002	Max	X	X	X	X		X	X	X	X	X
Cylinder	Bore	793045	4.003	Max					X	X	X			X
		793751	2.69	Max			X	X						
		793752	4.003	Max								X	X	
		793770	2.006	Max	X	X								
Deck Height	Piston to Head Clearance (Checked cold)	See IOM	.020 to .035	Min - Max					X					
			.025 to .040	Min - Max	X		X			X		X		X
			.050 to .065	Min - Max		X		X			X		X	

Critical Dimensions – HD Compressors

Sizes 372, 373

	Description	Part No.	Dimension (in.)	Tolerance	HD372	HD373	HDL372	HDL373	HDS372
Crank Shaft	Connecting Rod Journal OD	793157	1.750	Min	X	X	X	X	X
	Lateral Movement	N/A	.0015 to .0030	Min - Max	X	X	X	X	X
Connecting Rod	Roller Bearing Bore (Wrist Pin End)	793009	1.001	Max	X				
		793309	1.312	Max		X	X	X	X
	Crank End Bore ID	793009	1.876	Max	X				
		793309	1.876	Max		X	X	X	X
Wrist Pin	OD	793307	0.9998	Min	X	X	X	X	X
Crosshead Assy	Wrist Pin Bore ID (Iron)	793302	1.000	Max	X		X		
		793303	1.000	Max		X		X	
		793501	1.000	Max					X
	Crosshead OD (Iron)	793302	3.993	Min	X		X		
		793303	3.993	Min		X		X	
		793501	3.993	Min					X
	Piston Rod OD	793302	0.749	Min	X		X		
		793303	0.749	Min		X		X	
		793501	0.749	Min					X
Crosshead Guide	ID	793455	4.002	Max	X	X	X	X	X
Cylinder	Bore (1st Stage)	793601	4.629	Max	X	X			X
		793701	4.629	Max			X	X	
	Bore (2nd Stage)	793601	2.69	Max	X	X			X
		793701	2.69	Max			X	X	
Deck Height	Piston to Head Clearance (Checked cold)	See IOM	.025 to .040	Min - Max	X		X		X
			.050 to .065	Min - Max		X		X	

Critical Dimensions – HD Compressors

Sizes 602, 603, 642, 643

	Description	Part No.	Dimension (in.)	Tolerance	HD601	HD602	HD603	HDL602	HDL603	HDS602	HDL642	HDL643
Crank Shaft	Connecting Rod Journal OD	794708	2.749	Min	X	X	X	X	X	X	X	X
	Lateral Movement	all	.0015 to .0030	Min - Max	X	X	X	X	X	X	X	X
Connecting Rod	Roller Bearing Bore (Wrist Pin End)	794728	1.252	Max	X	X	X	X	X	X	X	X
	Crank End Bore ID	794728	2.899	Max	X	X	X	X	X	X	X	X
Wrist Pin	OD	794727	1.2498	Min	X	X	X	X	X	X	X	X
Crosshead Assy	Wrist Pin Bore ID (Iron)	794432	1.250	Max	X	X		X			X	
		794435	1.250	Max			X		X			X
		794523	1.250	Max						X		
	Crosshead OD (Iron)	794432	4.996	Min	X	X		X			X	
		794435	4.996	Min			X		X			X
		794523	4.996	Min						X		
	Piston Rod OD	794432	1.249	Min	X	X		X			X	
		794435	1.249	Min			X		X			X
		794523	1.249	Min						X		
Crosshead Guide	ID	794091	5.003	Max	X							
		794430	5.003	Max		X	X	X	X	X	X	X
Cylinder	Bore	794103	4.629	Max	X	X	X			X		
		794503	4.629	Max				X	X			
		794505	3.249	Max							X	X
Deck Height	Piston to Head Clearance (Checked cold)	see IOM	.020 to .035	Min - Max	X							
			.030 to .045	Min - Max		X		X		X	X	
			.060 to .075	Min - Max			X		X			X

Critical Dimensions – HD Compressors

Sizes 612, 613, 942

	Description	Part No.	Dimension (in.)	Tolerance	HD612	HD613	HDL612	HDL613	HDS612	HD942	HDL942	HDS942
Crank Shaft	Connecting Rod Journal OD	794708	2.749	Min	X	X	X	X	X	X	X	X
	Lateral Movement	all	.0015 to .0030	Min - Max	X	X	X	X	X	X	X	X
Connecting Rod	Roller Bearing Bore (Wrist Pin End)	794728	1.252	Max	X	X	X	X	X	X	X	X
	Crank End Bore ID	794728	2.899	Max	X	X	X	X	X	X	X	X
Wrist Pin	OD	794727	1.2498	Min	X	X	X	X	X	X	X	X
Crosshead Assy	Wrist Pin Bore ID (Iron)	794432	1.250	Max	X		X					
		794435	1.250	Max		X		X				
		794523	1.250	Max					X			
		794723	1.250	Max						X	X	
		794785	1.250	Max								X
	Crosshead OD (Iron)	794432	4.996	Min	X		X					
		794435	4.996	Min		X		X				
		794523	4.996	Min					X			
		794723	4.996	Min						X	X	
		794785	4.996	Min								X
	Piston Rod OD	794432	1.249	Min	X		X					
		794435	1.249	Min		X		X				
		794523	1.249	Min					X			
		794723	1.249	Min						X	X	
		794785	1.249	Min								X
Crosshead Guide	ID	794430	5.003	Max	X	X	X	X	X	X	X	X
Cylinder	Bore (1st Stage)	794601	6.006	Max	X	X			X			
		794701	6.006	Max			X	X				
		794703	4.629	Max							X	
		794704	4.629	Max						X		X
	Bore (2nd Stage)	794601	3.253	Max	X	X			X			
		794701	3.253	Max			X	X				
Deck Height	Piston to Head Clearance (Checked cold)	see IOM	.030 to .045	Min - Max	X		X		X			
			.050 to .065	Min - Max		X		X				
	Upper Piston	see IOM	.035 to .050	Min - Max						X	X	X
	Lower Piston Clearance	see IOM	.003 to .005	Min - Max						X	X	X

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