

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	
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	
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 612 and 613

Description		Part No.	Dimension (in.)	Tolerance	HD612	HD613	HDL612	HDL613	HDS612
Crank Shaft	Connecting Rod Journal OD	794708	2.749	Min	X	X	X	X	X
	Lateral Movement	all	.0015 to .0030	Min - Max	X	X	X	X	X
Connecting Rod	Roller Bearing Bore (Wrist Pin End)	794728	1.252	Max	X	X	X	X	X
	Crank End Bore ID	794728	2.899	Max	X	X	X	X	X
Wrist Pin	OD	794727	1.2498	Min	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
	Crosshead OD (Iron)	794432	4.996	Min	X		X		
		794435	4.996	Min		X		X	
		794523	4.996	Min					X
	Piston Rod OD	794432	1.249	Min	X		X		
		794435	1.249	Min		X		X	
		794523	1.249	Min					X
Crosshead Guide	ID	794430	5.003	Max	X	X	X	X	
Cylinder	Bore (1st Stage)	794601	6.006	Max	X	X			X
		794701	6.006	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	