

## FUEL INJECTION PUMP

Firing order (injection sequence) ..... 1, 2, 7, 3, 4, 5, 6, 8  
 Injection timing before TC (top center) ..... 56°

Torque for the nuts that hold the fuel lines  
 (Use SP144 Fuel Line Socket) ..... 20 ± 5 ft. lb. (40 ± 7 Nm)

- (1) Bore in the rear bearing for the camshaft (new) .....  $2.3750 \pm .0005$  in. (60.325 ± 0.013 mm)  
 Diameter of rear bearing surface (journal) of the camshaft (new) .....  $2.3720 \pm .0005$  in. (60.248 ± 0.013 mm)  
 Maximum permissible clearance between the bearing and the camshaft bearing surface (journal) (worn) ..... .006 in. (0.15 mm)
- (2) Torque for screws that hold sleeve control levers ..... 24 ± 2 ft. lb. (12.8 ± 0.2 Nm)
- (3) Bore in the housing for the fuel control shaft (new) .....  $.3543 \pm .0005$  in. (8.999 ± 0.013 mm)  
 Diameter of sleeve control shaft (new) .....  $.3520 \pm .0003$  in. (8.966 ± 0.008 mm)  
 Maximum permissible clearance between the bore in the housing and the sleeve control shaft (worn) ..... .003 in. (0.07 mm)
- (4) End play for camshafts with sleeve installed (new) ..... .023 ± .018 in. (0.58 ± 0.46 mm)

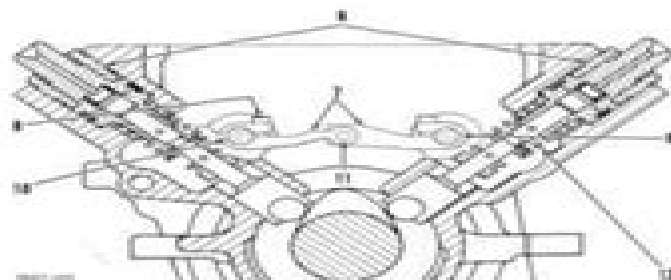
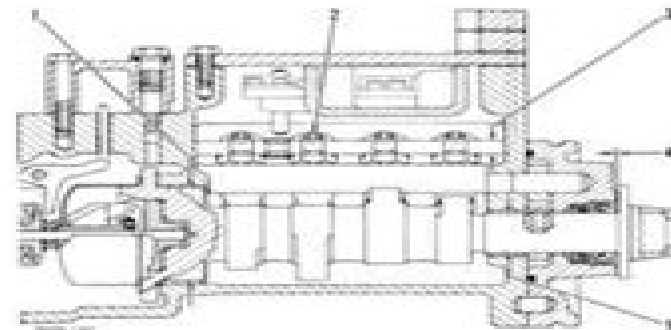
NOTE: When installing sleeve on end of camshaft, support the camshaft to prevent damage to parts inside of injection pump and governor housing.

- (5) Bore in the front bearing for the camshaft (new) .....  $1.0005 \pm .0005$  in. (25.413 ± 0.013 mm)  
 Diameter of front bearing surface (journal) of the camshaft (new) ..... .9990 ± .0005 in. (25.375 ± 0.013 mm)  
 Maximum permissible clearance between the bearing and the camshaft bearing surface (journal) (worn) ..... .004 in. (0.10 mm)
- (6) Torque for bushing ..... 70 ± 5 ft. lb. (35 ± 7 Nm)
- (7) Crossover levers.

NOTE: For adjustment of crossover levers, see 3208 DIESEL TRUCK ENGINE Service Manual.

- (8) Torque for screws that hold crossover levers ..... 24 ± 2 ft. lb. (12.8 ± 0.2 Nm)
- (9 and 10) Fuel control shafts.
- (11) Chisel pin linkage between crossover levers.

- (12) 4N4318 Spring for injection pump:  
 Length under test force ..... 1.348 in. (34.24 mm)  
 Test force ..... 12.5 ± 1.2 ft. lb. (55.5 ± 5.8 N)  
 Free length after test ..... 1.566 in. (39.78 mm)  
 Outside diameter ..... .728 ± .010 in. (18.49 ± 0.25 mm)



# 3208 Engine Manual Ford

**Lei Shi**

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