

K10031 OVERHAUL PROGRAMME — DIMENSIONAL INSPECTION RECORD

Cylinder Head — Valve Guide Inside Diameter Measurement Record

Cummins KTA38-D(M1) | Engine Serial Number 33180272 | Limits per Cummins Service Manual

LEFT BANK — cylinders 1L to 6L

Vessel / project	K10031 (IMO 8525111), Koole Contractors	Engine serial number	33180272
Component	Valve guides, left bank — 6 heads, 24 guides	Date of measurement	
Instrument / serial no.		Calibration cert. / expiry	
Measured by			

1. Wear limit — inspect for reuse

Dimension	MIN mm	MAX mm	MIN in	MAX in	Reference
Valve guide inside diameter — installed	12.600	12.667	0.496	0.499	As per Cummins Service Manual

2. Readings as recorded — valve guide inside diameter, in mm

Valve position / station		Cylinder number											
		1L	2L	3L	4L	5L	6L						
IN-1	T												
	M												
	B												
IN-2	T												
	M												
	B												
EX-1	T												
	M												
	B												
EX-2	T												
	M												
	B												
Guides to replace mark the position		IN	EX	IN	EX	IN	EX	IN	EX	IN	EX	IN	EX
No. 1													
No. 2													

Number from the front of each head and paint-mark that edge on removal. T / M / B = 13 mm from top, mid-length, 13 mm from bottom. Record as measured, without rounding, on a cleaned and dried head.

3. Assessment

Range recorded	
Against wear limit (12.667 max)	
End-wear rule applied (13 mm from either end)	
Conclusion	

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RIGHT BANK — cylinders 1R to 6R

Vessel / project	K10031 (IMO 8525111), Koole Contractors	Engine serial number	33180272
Component	Valve guides, right bank — 6 heads, 24 guides	Date of measurement	
Instrument / serial no.		Calibration cert. / expiry	
Measured by			

1. Wear limit — inspect for reuse

Dimension	MIN mm	MAX mm	MIN in	MAX in	Reference
Valve guide inside diameter — installed	12.600	12.667	0.496	0.499	As per Cummins Service Manual

2. Readings as recorded — valve guide inside diameter, in mm

Valve position / station		Cylinder number											
		1R	2R	3R	4R	5R	6R						
IN-1	T												
	M												
	B												
IN-2	T												
	M												
	B												
EX-1	T												
	M												
	B												
EX-2	T												
	M												
	B												
Guides to replace mark the position		IN	EX	IN	EX	IN	EX	IN	EX	IN	EX	IN	EX
No. 1													
No. 2													

Number from the front of each head and paint-mark that edge on removal. T / M / B = 13 mm from top, mid-length, 13 mm from bottom. Record as measured, without rounding, on a cleaned and dried head.

3. Assessment

Range recorded	
Against wear limit (12.667 max)	
End-wear rule applied (13 mm from either end)	
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