



Designation: D6837 – 08

Standard Test Method for Measurement of Effects of Automotive Engine Oils on Fuel Economy of Passenger Cars and Light-Duty Trucks in Sequence VIB Spark Ignition Engine^{1, 2}

This standard is issued under the fixed designation D6837; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

INTRODUCTION

The test method described in this standard can be used by any properly equipped laboratory, without outside assistance. However, the ASTM Test Monitoring Center (TMC)³ provides reference oils and assessment of the test results obtained on those oils by the laboratory (see [Annex A1](#)). By this means, the laboratory will know whether their use of the test method gives results statistically similar to those obtained by other laboratories. Furthermore, various agencies require that a laboratory utilize the TMC services in seeking qualification of oils against specifications. For example, the American Petroleum Institute (API) imposes such a requirement, in connection with several U.S. Army engine lubricating oil specifications.

Accordingly, this test method is written for use by laboratories, which utilize the TMC services. Laboratories that choose not to use those services may simply ignore those portions of the test method that refer to the TMC.

This test method may be modified by means of Information Letters issued by the TMC. In addition, the TMC may issue supplementary memoranda related to the test method. Users of this test method shall contact the TMC, Attention: Administrator, to obtain the most recent of these.

1. Scope

1.1 This test method covers an engine test procedure for the measurement of the effects of automotive engine oils on the fuel economy of passenger cars and light-duty 3856 kg (8500 lb) or less gross vehicle weight trucks. The tests are conducted using a specified 4.6-L spark-ignition engine on a dynamometer test stand. It applies to multiviscosity grade oils used in these applications.

1.2 This test method also provides for the running of an abbreviated length test that is referred to as the VIBSJ. The procedure for VIBSJ is identical to the Sequence VIB with the

exception of the items specifically listed in [Annex A13](#). The procedure modifications listed in [Annex A13](#) refer to the corresponding section of the Sequence VIB test method.

1.3 The unit values stated in this test method shall be regarded as the standard. Values given in parentheses are provided for information purposes only. SI units are considered the primary units for this test method. The only exception is where there is no direct SI equivalent such as screw threads, national pipe threads/diameters, tubing size, and so forth.

1.4 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

1.5 This test method is arranged as follows:

Subject	Section
Introduction	
Scope	1
Referenced Documents	2
Terminology	3
Summary of Test Method	4
Significance and Use	5
Apparatus	6
General	6.1
Test Engine Configuration	6.2
Laboratory Ambient Conditions	6.3
Engine Speed and Load Control	6.4

¹ This test method is under the jurisdiction of ASTM Committee D02 on Petroleum Products and Lubricants and is the direct responsibility of Subcommittee D02.B0.01 on Passenger Car Engine Oils.

Current edition approved May 1, 2008. Published May 2008. Originally approved in 2002. Last previous edition approved in 2006 as D6837-06. DOI: 10.1520/D6837-08.

² The multi-cylinder engine test sequences were originally developed in 1956 by an ASTM Committee D02 group. Subsequently, the procedures were published in an ASTM special technical publication. The Sequence VIB was published as Research Report D02-1469 dated April 8, 1999.

³ ASTM Test Monitoring Center, 6555 Penn Avenue, Pittsburgh, PA 15206-4489. For other information, refer to Research Report D02-1469, Sequence VIB Test Development. This research report and this test method are supplemented by Information Letters and Memoranda issued by the ASTM TMC. This edition incorporates revisions in all Information Letters through No. 07-1.

Subject	Section	Subject	Section
Dynamometer	6.4.1	Fuel Injection System	9.3.17
Dynamometer Load	6.4.2	Intake Air System	9.3.18
Engine Cooling System	6.5	Engine Management System (Spark and Fuel Control)	9.3.19
External Oil System	6.6	Accessory Drive Units	9.3.20
Fuel System	6.7	Exhaust Manifolds	9.3.21
Fuel Flow Measurement	6.7.2	Engine Flywheel and Guards	9.3.22
Fuel Temperature and Pressure Control to the Fuel Flowmeter	6.7.3	Lifting of Assembled Engines	9.3.23
Fuel Temperature and Pressure Control to Engine Fuel Rail	6.7.4	Engine Mounts	9.3.24
Fuel Supply Pumps	6.7.5	Calibration	10
Fuel Filtering	6.7.6	Stand/Engine Calibration	10.1
Engine Intake Air Supply	6.8	Procedure	10.1.1
Intake Air Humidity	6.8.1	Reporting of Reference Results	10.1.2
Intake Air Filtration	6.8.2	Analysis of Reference/Calibration Oils	10.1.3
Intake Air Pressure Relief	6.8.3	Instrument Calibration	10.2
Temperature Measurement	6.9	Engine Load Measurement System	10.2.1
Thermocouple Location	6.9.5	Fuel Flow Measurement System	10.2.2
AFR Determination	6.10	Coolant Flow Measurement System	10.2.3
Exhaust and Exhaust Back Pressure Systems	6.11	Thermocouple and Temperature Measurement System	10.2.4
Exhaust Manifolds	6.11.1	Humidity Measurement System	10.2.5
Laboratory Exhaust System	6.11.2	Other Instrumentation	10.2.6
Exhaust Back Pressure	6.11.3	Test Procedure	11
Pressure Measurement and Pressure Sensor Locations	6.12	Preparation for Initial Start-up of New Engine	11.1
Engine Oil	6.12.2	External Oil System	11.1.1
Fuel to Fuel Flowmeter	6.12.3	Flush Effectiveness Demonstration	11.1.2
Fuel to Engine Fuel Rail	6.12.4	Preparation for Oil Charge	11.1.3
Exhaust Back Pressure	6.12.5	Oil Charge for Coolant Flush	11.1.4
Intake Air	6.12.6	Engine Coolant Charge for Coolant Flush	11.1.5
Intake Manifold Vacuum/Absolute Pressure	6.12.7	Initial Engine Start-up	11.2
Coolant Flow Differential Pressure	6.12.8	Coolant Flush	11.3
Crankcase Pressure	6.12.9	New Engine Break-In	11.4
Engine Hardware and Related Apparatus	6.13	Oil Charge for Break-In	11.4.2
Test Engine Configuration	6.13.1	Break-In Operating Conditions	11.4.3
ECM/EEC (Engine Control) Module	6.13.2	Routine Test Operation	11.5
Thermostat/Orifice Plate	6.13.3	Start-Up and Shutdown Procedures	11.5.8
Intake Manifold	6.13.4	Flying Flush Oil Exchange Procedures	11.5.9
Flywheel	6.13.5	Test Operating Stages	11.5.10
Wiring Harnesses	6.13.6	Stabilization to Stage Conditions	11.5.11
EGR Block-Off Plate	6.13.7	Stabilized BSFC Measurement Cycle	11.5.12
Oil Pan	6.13.8	Data Logging	11.5.13
Oil Pump Screen and Pickup Tube	6.13.9	BC Oil Flush Procedure for BC Oil Before Test Oil	11.5.14
Idle Speed Control Solenoid (ISC) Block-Off Plate	6.13.10	BSFC Measurement of BC Oil Before Test Oil	11.5.15
Engine Water Pump	6.13.11	Test Oil Flush Procedure	11.5.16
Thermostat Housing	6.13.12	Test Oil Aging	11.5.17
Oil Filter Adapter	6.13.13	BSFC Measurement of Aged (Phase I) Test Oil	11.5.18
Fuel Rail	6.13.14	Aging Phase II	11.5.19
Miscellaneous Apparatus Related to Engine Operation	6.14	BSFC Measurement of Aged (Phase II) Test Oil	11.5.21
Timing Light	6.14.1	BC Oil Flush Procedure for BC Oil After Test Oil	11.5.22
Reagents and Materials	7	BSFC Measurement for BC Oil After Test Oil	11.5.23
Engine Oil	7.1	General Test Data Logging Forms	11.5.24
Test Fuel	7.2	Diagnostic Review Procedures	11.5.25
Engine Coolant	7.3	Determination of Test Results	12
Cleaning Materials	7.4	FEI1 and FEI2 Calculations	12.1
Preparation of Apparatus	8	Final Test Report	13
Test Stand Preparation	8.2	Validity Statement	13.1
Engine Preparation	9	Report Format	13.2
Cleaning of Engine Parts	9.2	Precision and Bias	14
Engine Assembly Procedure	9.3	Precision	14.1
General Assembly Instructions	9.3.1	Validity	14.2
Bolt Torque Specifications	9.3.2	Test Stand Calibration Status	14.2.1
Sealing Compounds	9.3.3	Validity Interpretation of Deviant Operational Conditions	14.2.2
Harmonic Balancer	9.3.5	Bias	14.3
Oil Pan	9.3.6	Keywords	15
Intake Manifold	9.3.7	Annexes	
Camshaft Covers	9.3.8	Role of ASTM TMC	Annex A1
Thermostat	9.3.9	Detailed Specifications and Drawings of Apparatus	Annex A2
Thermostat Housing	9.3.10	Oil Heater Cerrobase Refill Procedure	Annex A3
Coolant Inlet	9.3.11	Engine Part Number Listing	Annex A4
Oil Filter Adapter	9.3.12	Flying Flush Checklists	Annex A5
Dipstick Tube	9.3.13	Safety Precautions	Annex A6
Water Pump	9.3.14	Report Format	Annex A7
Sensors, Switches, Valves, and Positioners	9.3.15	Statistical Equations for Mean and Standard Deviations	Annex A8
Ignition System	9.3.16		

Subject	Section
Oil Sump Full Level Determination Consumption Measurement Calibration Procedure	Annex A9
Fuel Injector Evaluation	Annex A10
Pre-test Maintenance Checklist	Annex A11
Blow-by Ventilation System Requirements	Annex A12
VIBSJ Abbreviated Length Test Requirements	Annex A13
Appendix Procurement of Test Materials	Appendix X1

2. Referenced Documents

2.1 ASTM Standards:⁴

- D86** Test Method for Distillation of Petroleum Products at Atmospheric Pressure
- D235** Specification for Mineral Spirits (Petroleum Spirits) (Hydrocarbon Dry Cleaning Solvent)
- D240** Test Method for Heat of Combustion of Liquid Hydrocarbon Fuels by Bomb Calorimeter
- D287** Test Method for API Gravity of Crude Petroleum and Petroleum Products (Hydrometer Method)
- D323** Test Method for Vapor Pressure of Petroleum Products (Reid Method)
- D381** Test Method for Gum Content in Fuels by Jet Evaporation
- D445** Test Method for Kinematic Viscosity of Transparent and Opaque Liquids (and Calculation of Dynamic Viscosity)
- D525** Test Method for Oxidation Stability of Gasoline (Induction Period Method)
- D1319** Test Method for Hydrocarbon Types in Liquid Petroleum Products by Fluorescent Indicator Adsorption
- D2699** Test Method for Research Octane Number of Spark-Ignition Engine Fuel
- D3231** Test Method for Phosphorus in Gasoline
- D3237** Test Method for Lead in Gasoline by Atomic Absorption Spectroscopy
- D3338** Test Method for Estimation of Net Heat of Combustion of Aviation Fuels
- D4294** Test Method for Sulfur in Petroleum and Petroleum Products by Energy Dispersive X-ray Fluorescence Spectrometry
- D4485** Specification for Performance of Engine Oils
- D5302** Test Method for Evaluation of Automotive Engine Oils for Inhibition of Deposit Formation and Wear in a Spark-Ignition Internal Combustion Engine Fueled with Gasoline and Operated Under Low-Temperature, Light-Duty Conditions⁵
- D5533** Test Method for Evaluation of Automotive Engine Oils in the Sequence IIIIE, Spark-Ignition Engine⁵
- D5844** Test Method for Evaluation of Automotive Engine Oils for Inhibition of Rusting (Sequence IID)⁵
- D5862** Test Method for Evaluation of Engine Oils in Two-Stroke Cycle Turbo-Supercharged 6V92TA Diesel Engine

- D6202** Test Method for Automotive Engine Oils on the Fuel Economy of Passenger Cars and Light-Duty Trucks in the Sequence VIA Spark Ignition Engine
 - D6557** Test Method for Evaluation of Rust Preventive Characteristics of Automotive Engine Oils
 - E29** Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications
 - E191** Specification for Apparatus For Microdetermination of Carbon and Hydrogen in Organic and Organo-Metallic Compounds
 - IEEE/ASTM SI-10** Standard for Use of the International System of Units (SI): The Modern Metric System
- ### 2.2 SAE Standards:⁶
- J304** Engine Oil Tests
 - J1423** Classification of Energy-Conserving Engine Oil for Passenger Cars and Light-Duty Trucks
- ### 2.3 API Publication:⁷
- API 1509** Engine Oil Licensing and Certification System
- ### 2.4 ANSI Standard:⁸
- ANSI MC96.1-1975** Temperature Measurement – Thermocouples

3. Terminology

3.1 Definitions:

- 3.1.1 *air-fuel ratio, n*—in internal combustion engines, the mass ratio of air-to-fuel in the mixture being induced into the combustion chambers. **D5302**
- 3.1.2 *automotive, adj*—descriptive of equipment associated with self-propelled machinery, usually vehicles driven by internal combustion engines. **D4485**
- 3.1.3 *blowby, n*—in internal combustion engines, the combustion products and unburned air-and-fuel mixture that enter the crankcase. **D5302**
- 3.1.4 *BTDC, adj*—abbreviation for Before Top Dead Center, used with the degree symbol to indicate the angular position of the crankshaft relative to its position at the point of uppermost travel of the piston in the cylinder. **D5533**
- 3.1.5 *calibrate, v*—to determine the indication or output of a measuring device or a given engine with respect to a standard. **D5862**
- 3.1.6 *calibration oil, n*—an oil that is used to determine the indication or output of a measuring device or a given engine with respect to a standard. **D6202**
- 3.1.7 *engine oil, n*—a liquid that reduces friction or wear, or both, between the moving parts of an engine; removes heat, particularly from the underside of pistons; and serves as a combustion gas sealant for the piston rings. **D5862**
- 3.1.8 *lubricant, n*—any material interposed between two surfaces that reduces the friction or wear, or both, between them. **D5862**

⁴ For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For Annual Book of ASTM Standards volume information, refer to the standard's Document Summary page on the ASTM website.

⁵ Withdrawn. The last approved version of this historical standard is referenced on www.astm.org.

⁶ Available from Society of Automotive Engineers (SAE), 400 Commonwealth Dr., Warrendale, PA 15096-0001. This standard is not available separately. Either order the SAE Handbook Vol. 3, or the SAE Fuels and Lubricants Standards Manual HS-23.

⁷ Available from The American Petroleum Institute (API), 1220 L. St., NW, Washington, DC 20005.

⁸ Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036.

3.1.9 *non-reference oil, n*—any oil other than a reference oil, such as a research formulation, commercial oil, or candidate oil. **D5844**

3.1.10 *purchaser, n*—of an ASTM test, a person or organization that pays for the conduct of an ASTM test method on a specified product.

3.1.10.1 *Discussion*—The preferred term is purchaser. Deprecated terms that have been used are client, requester, sponsor, and customer. **D6202**

3.1.11 *reference oil, n*—an oil of known performance characteristics used as a basis for comparison. **D5844**

3.1.12 *test oil, n*—any oil subjected to evaluation in an established procedure. **D6557**

3.1.13 *test start, n*—introduction of test oil into the engine. **D5533**

3.2 *Definitions of Terms Specific to This Standard:*

3.2.1 *aged test oil, n*—an engine oil to be tested that has been previously subjected to use in a spark-ignited operating engine for a prescribed length of service under prescribed conditions.

3.2.2 *aging, n*—the subjecting of an engine oil to use in a spark-ignited operating engine for a prescribed length of service under prescribed conditions.

3.2.3 *break-in, v*—in internal combustion engines, the running of a new engine under prescribed conditions to help stabilize engine response and help remove initial friction characteristics associated with new engine parts.

3.2.4 *central parts distributor (CPD), n*—the manufacturer or supplier, or both, of many of the parts and fixtures used in this test method.

3.2.4.1 *Discussion*—Because of the need for availability, rigorous inspection, and control of many of the parts used in this test method, companies having the capabilities to provide the needed services have been selected as the official suppliers for the Sequence VIB test method. These companies work closely with the Test Procedure Developer and with the ASTM groups associated with the test method to help ensure that the critical engine parts used in this test method are available to the testing industry and function satisfactorily.

3.2.5 *flush, v*—to wash out with a rush of engine oil, during a prescribed mode of engine operation to minimize carryover effect from the previous oil and remove residues, before introducing a new test oil.

3.2.6 *flying flush, n*—in internal combustion engines, the washing out with a rush of engine oil, during a prescribed mode of engine operation to minimize carryover effect from the previously used oil and remove residues without stopping the engine after the previous test.

3.2.7 *fuel economy, n*—in internal combustion engines, the efficient use of gasoline.

3.2.7.1 *Discussion*—Determined by comparing the rate of fuel consumption of a test oil with that displayed by a base line reference oil.

3.2.8 *non-standard test, n*—a test conducted with operating conditions (that is, engine speeds, loads, temperatures, and so forth) outside the normal test operating conditions or with a fuel other than the specified test fuel or with non-specified hardware configuration.

3.2.9 *special parts distributor (SPD), n*—the manufacturer or supplier, or both, of specified parts and fixtures used in this test method.

3.2.10 *special test parts (STP), n*—parts that do not meet all the definitions of critical parts or non-production parts, but shall be obtained from the SPD.

4. Summary of Test Method

4.1 The 4.6-L internal combustion engine is installed on a dynamometer test stand equipped with the appropriate controls for speed, load, and various other operating parameters.

4.2 The test method consists of measuring the laboratory engine brake specific fuel consumption at five constant speed/load/temperature conditions for the baseline calibration oil, test oil, and a repeat of the baseline calibration oil. The approximate test length is 133 h.

4.3 Aged test oil is compared directly to fresh ASTM BC SAE 5W-30 (see X1.2) baseline calibration oil, which is run before and after the test oil. When changing from test oil to baseline calibration oil, an intermediate flush with a special flushing oil (BC Flush Oil or BCFHD) is required to minimize the possibility of a carryover effect from the previous oil.

4.4 Test results are expressed as a percent change in weighted fuel consumption (see Table 6) relative to the baseline calibration oil.

5. Significance and Use

5.1 *Test Method*—The data obtained from the use of this test method provide a comparative index of the fuel-saving capabilities of automotive engine oils under repeatable laboratory conditions. A baseline calibration oil (hereafter referred to as BC oil) has been established for this test to provide a standard against which all other oils can be compared. The BC oil is an SAE 5W-30 grade fully formulated lubricant. There is a direct correlation of Test Method D6837 (Sequence VIB) Fuel Economy Improvement (FEI) by percent with the fuel economy results obtained from vehicles representative of

TABLE 1 Sequence VIB Fuel Specification

	Test Method	
Octane, research min	D2699	96
Pb (organic), mg/L max	D3237	13.2 (0.05 g/U.S.gal)
Sensitivity, min		7.5
Distillation range		
IBP, °C	D86	23.9 to 35 (75 to 95°F)
10 % point, °C	D86	48.9 to 57.2 (120 to 135°F)
50 % point, °C	D86	93.3 to 110 (200 to 230°F)
90 % point, °C	D86	148.9 to 162.8 (300 to 325 °F)
E.P., °C (max)	D86	212.8 (415°F)
Sulfur, weight %, max	D4294	0.10
Phosphorous, mg/L, max	D3231	1.32 (0.005 g/U.S.gal)
RVP, kPa	D323	60.0 to 63.4 (8.7 to 9.2 psig)
Hydrocarbon composition		
Olefins, % max	D1319	10
Aromatics, % max	D1319	35
Saturates	D1319	Remainder
Existent gum, mg/100mL, max	D381	5.0
Oxidation stability, min	D525	500
Carbon weight fraction	E191	Report
Hydrogen/Carbon ratio, mol basis	E191	Report
Net heating value, Btu/lb	D240	Report
Net heating value, Btu/lb	D3338	Report
API gravity	D287	Report

TABLE 2 Sequence VIB New Engine Cyclic Break-in^A

	Cycle	
	A	B
Time at Each Step, min	4	1
Time to Decel. to Step A, s		15 max
Time to Accel. to Step B, s	15 max	
Speed, r/min	1500	3500
Power, kW (hp)	7.5 (10.1)	20.9 (28)
Load, N-m (lbf-ft)	48.00 (35.4)	57.00 (42.04)
Oil Gallery, °C (°F)	105 (221)	105 (221)
Coolant In, °C (°F)	95 (203)	95 (203)
Coolant Flow, L/min (gal/min)	130 (34.3)	130 (34.3)
Intake Air Temperature and Humidity	Control Not Required	
Ignition Timing, °BTDC	Record	Not Specified
Exh. Back Press., kPa (in. Hg, abs)	104.0 (30.80)	Not Specified
AFR	Record	Not Specified
Fuel Pressure to Fuel Rail, kPa (psi)	205 to 310 (30 to 45)	205 to 310 (30 to 45)
Fuel Temperature to Fuel Rail, °C (°F)	20 (68)	20 (68)
Fuel Flow, kg/h (lb/h)	Not Specified	Not Specified
BSFC, kg/kW-h (lb/hp-h)	Not Specified	Not Specified

^A The time at each cycle and their acceleration and deceleration times shall be adhered to; target all other parameters as close as possible.

current production running under the current EPA testing cycles. The test procedure was not designed to give a precise estimate of the difference between two test oils without adequate replication. Rather, it was developed to compare a test oil to BC oil. Companion test methods used to evaluate engine oil performance for specification requirements are discussed in the latest revision of Specification **D4485**.

5.2 *Use*—The Sequence VIB test method is useful for engine oil fuel economy specification acceptance. It is used in specifications and classifications of engine lubricating oils, such as the following:

- 5.2.1 Specification **D4485**.
- 5.2.2 API Publication 1509.
- 5.2.3 SAE Classification **J304**.
- 5.2.4 SAE Classification **J1423**.

6. Apparatus

6.1 *General*—Standardize certain aspects of each test stand in terms of stand hardware. Examples of components that are specified are certain pumps, valves, heat exchangers, heaters, and piping nominal inside diameter (I.D.). Where specified, four classes or categories of stand hardware have been designated:

6.1.1 Prints for special parts are included in this procedure. When using these prints to fabricate special parts, use the dimensions specified for the various parts. Do not scale off the drawings or use them as a pattern. Use all equipment specified in the procedure. Substitution of equivalent equipment is allowed, but only after equivalency has been proven acceptable by the Sequence VIB Surveillance Panel.

6.2 *Test Engine Configuration*—The test engine is a specially built 1993 4.6-L Ford V-8 engine⁹ designed for use with an Automatic Overdrive Electronic (AODE) transmission (see **X1.3** for procurement of this engine). Mount the engine on the test stand so that the flywheel friction face is $3.6 \pm 0.5^\circ$ from the vertical with the front of the engine higher than the rear. The U-joint angles shall not be greater than 2.0° in the vertical plane and 0.0° in the horizontal.

6.3 *Laboratory Ambient Conditions*—Do not permit air from fans or ventilation systems to blow directly on the engine. The ambient laboratory atmosphere shall be relatively free of dirt, dust, or other contaminants as required by good laboratory standards.

6.4 *Engine Speed and Load Control*—The dynamometer speed and load control systems shall be capable of maintaining the limits specified in **Tables 2-4**. A typical closed-loop control system maintains speed by engine throttle control and load by dynamometer control. Since these speed and load tolerances require sensitive and precise control, give particular attention to achieving and maintaining accurate calibration of the related instrument systems.

6.4.1 *Dynamometer*—Use a Midwest or Eaton 37 kW (50-hp) Model 758 dry gap dynamometer (see **X1.4**). Replacing an engine dynamometer during a reference or non-reference test is not acceptable. If a dynamometer needs to be replaced during a test, abort the test. Calibrate the new dynamometer and related instrumentation before starting a new test.

6.4.2 *Dynamometer Load*:

6.4.2.1 *Dynamometer Load Cell*—Measure the dynamometer load by a 0 to 45 kg (0 to 100 lb) load cell. The dyno load cell is required to have the following features:

(1) Good temperature stability:

Zero $\leq 0.001\%$ FSO (Full Scale Output) per °C (0.002 % FSO per °F), and

Span $\leq 0.001\%$ FSO per °C (0.002 % FSO per °F).

(2) Nonlinearity $\leq 0.05\%$ FSO.

(3) Temperature compensation over range expected in laboratory (10 to 49°C) (50 to 115°F). A Lebow Model 3397 load cell (see **X1.5**) has been found suitable for this application.

6.4.2.2 *Dynamometer Load Cell Damper*—Do not use a load cell damper.

6.4.2.3 *Dynamometer Load Cell Temperature Control*—Control the load cell temperature. Enclose the dynamometer load cell to protect it from the variability of laboratory ambient temperatures. Maintain air in the enclosure within the operating temperature range specified by the load cell manufacturer within a variability of no more than $\pm 6^\circ\text{C}$ ($\pm 10.8^\circ\text{F}$). Control temperature by a means that does not cause uneven temperatures on the body of the load cell.

⁹ A specially built 1993 4.6L Ford V-8 internal combustion engine is a product of Ford Motor Co., Dearborn, MI 48121. It is available as Part No. R2G-800-XB (AOD-E) from AER, 1605 Surveyor Blvd., P.O. Box 979, Carrollton, TX 75011-0979.

TABLE 3 Sequence VIB Test Operating Conditions^A

Parameter	Stage 1	Stage 2	Stage 3	Stage 4	Stage 5
Speed, r/min ^B	1500	800	800	1500	1500
	±2	±2	±2	±2	±2
Load, Nm ^B	98.00	26.00	26.00	98.00	98.00
	±0.07	±0.07	±0.07	±0.07	±0.07
Nominal, Power kW	15.39	2.18	2.18	15.39	15.39
Gallery, °C ^B	125 ± 1	105 ± 1	70 ± 1	70 ± 1	45 ± 1
Coolant, °C ^B	105 ± 1	95 ± 1	60 ± 1	60 ± 1	45 ± 1
Stabilization Time, min ^C	60	60	60	60	60
All Stages					
Temperatures, °C					
Oil Circulation		Record			
Coolant Out		Record			
Intake Air ^B		27 ± 2			
Fuel-to-Flowmeter ^D		20 to 32 (delta from the max stage average reading shall be ≤4)			
Fuel-to-Fuel Rail ^B		20 ± 2			
Delta Load Cell ^D		Delta from the max stage average shall be ≤6			
Oil Heater		205 max			
Pressures					
Intake Air, kPa		0.05 ± 0.02			
Fuel-to-Flowmeter, kPa		100 min			
Fuel-to-Fuel Rail, kPa		205 to 310			
Intake Manifold, kPa abs.		Record			
Exhaust Back Pressure, kPa abs. ^B		104.00 ± 0.17			
Engine Oil, kPa		Record			
Crankcase, kPa		0.0 ± 0.25			
Flows					
Engine Coolant, L/min		130 ± 4			
Fuel Flow, kg/h ^B		Record			
Humidity, Intake Air, gr/kg of dry air		11.4 ± 0.8			
Air-to-Fuel Ratio ^B		14.00:1 to 15.00:1			
Air-to-Fuel Ratio ^D		Delta from max stage average reading shall be ≤0.50			
Ignition Timing		20° BTDC ± 2°			

^A Controlled parameters should be targeted for the middle of the specification range.

^B Critical measurement and control parameters.

^C Counted from the time the temperature set points are initially adjusted to the specific levels.

^D Difference between the maximum stage average reading of the entire test and the individual stage average readings.

6.4.2.4 *Dynamometer Connection to Engine*—Use U-joints for the dynamometer-to-engine connection (see 6.2).

6.5 *Engine Cooling System*—An external engine cooling system, as shown in Figs. A2.1-A2.5, is required to maintain the specified jacket coolant temperature and flow rate during the test. An alternative cooling system is shown in Fig. A2.3. The systems shall have the following features:

6.5.1 Pressurize the coolant system at the top of the reservoir. Control the system pressure to 69 ± 13.8 kPa (10 ± 2 psi). Install a pressure cap (PC-1 in Figs. A2.1-A2.3) (see X1.6) capable of maintaining system pressure within the above requirements.

6.5.2 The pumping system shall be capable of producing 130 ± 4 L/min (34.3 ± 1.1 gal/min). A Goulds G&L centrifugal pump (P-1 in Figs. A2.1-A2.3), Model NPE, Size 1ST, mechanical seal, with a 2-hp, 3450-r/min motor, is specified (see X1.7). Voltage and phase of the motor is optional.

6.5.3 The coolant system volume is not specified, however certain cooling system components are specified as shown in Figs. A2.1-A2.5. Adhere to the nominal I.D. of the line sizes as shown in Figs. A2.2-A2.5.

6.5.4 The specified heat exchanger (HX-1 in Figs. A2.1-A2.3) is an ITT Standard brazed plate model 320-20, Part No. 5-686-06-020-001 or ITT Bell and Gossett brazed plate model

BP-75H-20, Part No. 5-686-06-020-001 (see X1.8). Parallel or counterflow through the heat exchanger is permitted.

6.5.4.1 Approved replacement heat exchangers are: ITT Bell and Gossett brazed plate Model BP-420-20, Part No. 5-686-06-020-005 and ITT Bell and Gossett brazed plate Model BP-422-20, Part No. 5-686-06-020-007.

6.5.4.2 The specified heat exchanger for the alternative cooling system (see Fig. A2.3) is an ITT shell and tube Model BGF 5-030-06-048-001.

6.5.5 An orifice plate (OP-1 in Figs. A2.1-A2.5) is specified. It is recommended that the orifice plate be sized to provide a pressure drop equal to that of heat exchanger HX-1 and install it in the bypass loop of the coolant system.

6.5.5.1 An orifice plate (OP-1) is not required when using the alternative cooling system (see Fig. A2.3).

6.5.6 An orifice plate (differential pressure) (FE-103 in Figs. A2.1-A2.5) is specified (see X1.9). This orifice plate is a Daniel Series No. 30 RT threaded orifice flange, 1½ NPT. Size this orifice plate to yield a pressure drop of 11.21 ± 0.50 kPa (45.0 ± 2.0 in. H₂O) at a flow rate of 130 L/min (34.3 gal/min). There shall be 10 diameters upstream and 5 diameters downstream of straight, smooth pipe with no reducers or increasers. Flange size shall be the same size as pipe size. Threaded, slip-on or weld neck styles can be used as long as a consistent pipe diameter is kept throughout the required lengths.

TABLE 4 Sequence VIB Test Operating Conditions^A Stage Flush and Stage Aging Hours SI Units

	Stage Flush	Aging Phase I	Aging Phase II
Speed, r/min	1500 ± 5	1500 ± 5	2250 ± 5
Load, Nm	98.00 ± 0.10	98.00 ± 0.10	98.00 ± 0.10
Temperatures, °C^B			
Oil Gallery	125 ± 2	125 ± 2	135 ± 2
Coolant In	105 ± 2	105 ± 2	105 ± 2
Oil Circulation	Record	Record	Record
Coolant Out	Record	Record	Record
Intake Air	27 ± 2	27 ± 2	27 ± 2
Fuel-to-Flowmeter ^C	20 to 32	20 to 32	20 to 32
Fuel-to-Rail	20 ± 2	20 ± 2	20 ± 2
Pressures			
Intake Air, kPa	0.05 ± .02	0.05 ± 0.02	0.05 ± 0.02
Fuel-to-Flowmeter, kPa	100 min	100 min	100 min
Fuel-to-Rail, kPa	205 to 310	205 to 310	205 to 310
Intake Manifold, kPa abs	Record	Record	Record
Exhaust Back, kPa abs	104.00 ± 0.20	104.00 ± 0.20	104.00 ± 0.20
Engine Oil, kPa	Record	Record	Record
Flows and Others			
Engine Coolant, L/min	130 ± 4	130 ± 4	130 ± 4
Fuel Flow, kg/h	Record	Record	Record
Humidity, Intake Air	Record	Record	Record
gr/kg, of dry air	11.4 ± 0.8	11.4 ± 0.8	11.4 ± 0.8
Air-to-Fuel Ratio	14.00:1 to 15.00:1	14.00:1 to 15.00:1	14.00:1 to 15.00:1
Ignition Timing, °BTDC	20 ± 2°	20 ± 2°	20 ± 2°
Crankcase, Pressure, kPa	N/A	0.0 ± 0.25	0.0 ± 0.25

^A Controlled parameters should be targeted for the middle of the specification range.

^B Counted from the time the temperature set points are initially adjusted to the specific levels.

^C ±3°C within this range.

6.5.7 A control valve (TCV-104 in Figs. A2.1-A2.4) is required for controlling the engine coolant flow rate through the heat exchanger, HX-1, and the heat exchanger bypass portion of the cooling system.

6.5.7.1 A Badger Meter Inc. Model No. 9003TCW36SV3AxxL36 (air-to-close), or Model No. 9003TCW36SV1AxxL36 (air-to-open) 3-way globe (divert), 2-in. valve is the specified valve (see X1.10).

6.5.7.2 A Badger Meter Inc. Model No. 9003TCW36SV3A29L36 (air-to-close), or Model No. 9003TCW36SV1A29L36 (air-to-open) are also acceptable if the trim package used with these valves has a CV of 16.0.

6.5.7.3 Install the valve in a manner so that loss of air pressure to the controller results in coolant flow through the heat exchanger rather than through the coolant bypass (fail safe). Air-to-open/air-to-close is optional.

6.5.7.4 Control valve (TCV104) is not required when using the alternative cooling system (see Fig. A2.3).

6.5.8 A control valve (FCV-103 in Figs. A2.1-A2.5) is required for controlling the coolant flow rate to 130.0 ± 4 L/min (35 ± 1 gal/min). A Badger Meter Inc. Model No. 9003GCW36SV3A29L36, 2-way globe, 2-in., air-to-close valve is the specified valve (see X1.10).

6.5.9 A Viatran model 274/374, Validyne model DP15, or Rosemount model 1151 differential pressure transducer (DPT-1 in Fig. A2.5) is required for reading the coolant flow rate at the orifice plate (FE-103 in Figs. A2.1-A2.3) (see X1.11).

6.5.10 Either replace the engine water pump with a water pump plate as shown in Fig. A2.6 or modify the pump by removing the impeller and welding a block off plate onto the front of the pump or tapping the front of the pump and screwing in a pipe plug. The water pump plate can be fabricated by the laboratory or procured as Part No. OHT6A-014-A (see X1.12).

6.5.11 A coolant reservoir, a coolant overflow container, and a sight glass are required as shown in Figs. A2.1-A2.3 and Fig. A2.5. The design or model of these items is optional.

6.5.12 A control valve (TCV-101 in Fig. A2.1 and Fig. A2.4) is required for controlling the process water flow rate through the heat exchanger HX-1. A Badger Meter Inc. Model 9001GCW36SV3Axxx36 (air-to-close) or Model 9001GCW36SV1Axxx36 (air-to-open), 2-way globe, 1-in. valve is the specified valve (see X1.10). The type of trim package that may be used with this valve is optional.

6.5.13 A 1½-in. NPT sight glass is required in the main coolant circuit (SG-1 in Figs. A2.1-A2.3, and Fig. A2.5). The make/model is optional.

6.5.14 Brass, copper, or stainless steel materials are recommended for hard plumbing in the coolant system.

6.5.15 The materials used for process water, hot water, chilled water, process air, engine coolant overflow, and engine coolant transducer tubing are at the discretion of the laboratory.

6.5.16 The system shall have provisions (for example, low point drains) for draining all of the flushing water prior to installing a new coolant mixture.

6.6 *External Oil System*—An external oil system as shown in Figs. A2.7 and A2.8 is required. Although all of the systems are interconnected in some manner, the overall external oil system is comprised of two separate circuits: (1) the flying flush system, which allows the oil to be changed while the engine is running, and (2) the circulation system for oil temperature control. The engine oil pan is considered a part of the external oil system. Minimize the external oil volume of all of the circuits as well as the length of connections and surfaces in contact with more than one oil in the flush system to enable more thorough flying flushes.

6.6.1 The flush system has a high capacity scavenge pump, which fills a 6.0-L (6.34-qt) dump reservoir while fresh oil is drawn into the engine. The dump reservoir float switch then resets certain solenoids and the engine refills to the level established by the float switch in the engine oil pan (which then closes the solenoid to the fresh oil reservoir).

6.6.2 The oil heat/cool loop uses a proportional controller to bypass the cooling heat exchanger. Control the temperature within narrow limits with minimal additional heat (and surface temperatures). The system can respond quickly to establish the four different oil gallery temperatures required in the procedure. Arrange the proportional three-way control valve to go to its mid-point during the flying flushes to avoid trapping oil, and there shall be some cooling during test oil aging so that no oil is trapped in the cooler.

6.6.3 Cuprous materials are not allowed in any of the oil system (excluding the oil scavenge discharge system) except as may be required by the use of mandatory equipment in this procedure.

TABLE 5 Test Schedule

		Estimated Elapsed Time, h ^A
BC Oil Test		
1.	Double flush to BC	1:30
2.	S60, BSFC/fuel flow × 6 at Stage 1 ^B	1:30
3.	S60, BSFC/fuel flow × 6 at Stage 2	1:30
4.	S60, BSFC/fuel flow × 6 at Stage 3	1:30
5.	S60, BSFC/fuel flow × 6 at Stage 4	1:30
6.	S60, BSFC/fuel flow × 6 at Stage 5	1:30
7.	Warm-up to Stage Flush	0:30
Subtotal		9:30
Test Oil Test		
1.	Double flush to test oil	1:00
2.	Age 16 h at Stage Age Phase I	16:00
3.	S60, BSFC/fuel flow × 6 at Stage 1	1:30
4.	S60, BSFC/fuel flow × 6 at Stage 2	1:30
5.	S60, BSFC/fuel flow × 6 at Stage 3	1:30
6.	S60, BSFC/fuel flow × 6 at Stage 4	1:30
7.	S60, BSFC/fuel flow × 6 at Stage 5	1:30
8.	Age 80 h at Stage Age Phase II	80:00
9.	S60, BSFC/fuel flow × 6 at Stage 1	1:30
10.	S60, BSFC/fuel flow × 6 at Stage 2	1:30
11.	S60, BSFC/fuel flow × 6 at Stage 3	1:30
12.	S60, BSFC/fuel flow × 6 at Stage 4	1:30
13.	S60, BSFC/fuel flow × 6 at Stage 5	1:30
14.	Warm-up to Stage Flush	0:30
Subtotal		112:30
BC Oil Test		
1.	Detergent flush to BC	3:30
2.	S60, BSFC/fuel flow × 6 at Stage 1	1:30
3.	S60, BSFC/fuel flow × 6 at Stage 2	1:30
4.	S60, BSFC/fuel flow × 6 at Stage 3	1:30
5.	S60, BSFC/fuel flow × 6 at Stage 4	1:30
6.	S60, BSFC/fuel flow × 6 at Stage 5	1:30
Subtotal		11:00
End of Test Shutdown		133:00
Overall Total		133:00

^A Adhere to stabilization times and times for the 6 replicate BSFC measurements. Warm-up and cool-down times included in flushing elapsed times are estimates.

^B Example: Stabilize 60 min followed by 6 replicate BSFC measurements at 5-min intervals (3 min for set-up, 2 min for time averaged BSFC with Stage 1 operating conditions).

6.6.4 The flying flush system (see Fig. A2.7) shall have the following features:

NOTE 1—The items shown in the clouded areas in Fig. A2.7 are not specifically required. However, a system that performs these functions is required.

6.6.4.1 A scavenge pump (P-3 in Figs. A2.7 and A2.8). A Viking Series 475, gear type, close-coupled pump, model H475M is specified (see X1.13). The pump shall have an 1140 to 1150-r/min electric motor drive with a minimum of 0.75 hp. Voltage and phase are optional.

6.6.4.2 A reservoir with a minimum capacity of 19 L (5 gal). It is recommended that the system include three reservoirs (one for BC calibration oil, one for BCFHD flush oil, and one for test oil).

6.6.4.3 An oil stirrer in each oil reservoir.

6.6.4.4 An oil heating system (with appropriate controls) for each oil reservoir with the capability of heating the oil in the reservoir to 107 ± 2.8°C (224.6 ± 5°F).

6.6.4.5 A dump reservoir (see Figs. A2.7-A2.9) with a minimum 6-L (6.34-qt) capacity.

6.6.4.6 A dump reservoir float switch is required. (FLS-136 in Figs. A2.7-A2.9) The make and model is optional. A Gems Series ALS79999, Catalog No. A79999, 20 VA, high temperature float switch has been found suitable for this application (see X1.14).

6.6.4.7 Adhere to the nominal I.D. line sizes shown in Fig. A2.8.

6.6.5 The circulation system for oil temperature control shall have the following features:

6.6.5.1 A total volume, including oil volume in the oil pan to the full mark, shall be 6.0 L (6.34 qt). See 6.6.5.16.

6.6.5.2 An engine oil pan float switch (FLS-152 in Fig. A2.7, Fig. A2.10, and Fig. A2.16) is required. A Gems Series ALS79999, Catalog No. A79999, 20 VA, high temperature float switch is specified (see X1.14).

6.6.5.3 A positive displacement oil circulation pump (P-4 in Fig. A2.7) is required. A Viking Series 4125, Model G4125, no relief valve, base-mounted is specified (see X1.15). The pump shall have a V-belt or direct drive 1140 to 1150-r/min electric drive motor with a minimum of 0.56 Kw (0.75 hp). Voltage and phase are optional.

NOTE 2—The explosion proof requirement for the motor is left to the discretion of the laboratory.

NOTE 3—Either V-belt drive or direct-coupled drive may be used. If V-belt drive is used, use a 1:1 pulley ratio so that the final speed of the pump is a nominal 1150 r/min.

6.6.5.4 Solenoid valves (FCV-150A, FCV-150C, FCV-150D, and FCV-150E, in Figs. A2.7 and A2.8) are required (see X1.16).

(1) FCV-150F and its related lines/piping are optional.

TABLE 6 Calculation of Test Results

NOTE 1—For Stage 1, steps 1 through 6, round and record the 5-min BSFC measurements to 4 decimal places using ASTM rounding.

NOTE 2—Average the BSFC measurements of the six steps to 5 decimal places using ASTM rounding. Units for BSFC are kg/kW-h.

NOTE 3—Multiply the average by the shown nominal power and time factor for Stage 1 and record the answer to 6 decimal places. The unit for this number is kg of fuel consumed.

NOTE 4—Perform calculation steps 1, 2, and 3 for the remaining test stages (2 to 5) using the respective nominal power and time factors.

NOTE 5—Total the mass fuel consumption values for all 5 stages.

NOTE 6—Complete the total fuel consumed calculation detailed in Steps 1 to 5 above for the BC Before Test Oil, Test Oil Phase I, Test Oil Phase II, and BC After Test Oil.

NOTE 7—Compute the test oil fuel economy improvement (FEI) as follows:

$$\% \text{ FEI Test Oil Phase I} = \left\{ \left[(\text{BC Before} \times 80\%) + (\text{BC After} \times 20\%) - \text{Test Oil} \right] \div \left[(\text{BC Before} \times 80\%) + (\text{BC After} \times 20\%) \right] \right\} \times 100$$

$$\% \text{ FEI Test Oil Phase II} = \left\{ \left[(\text{BC Before} \times 10\%) + (\text{BC After} \times 90\%) - \text{Test Oil} \right] \div \left[(\text{BC Before} \times 10\%) + (\text{BC After} \times 90\%) \right] \right\} \times 100$$

NOTE 8—Adjust the FEI result(s) on non-reference oil tests for the stand/engine severity in accordance with [Annex A7](#).

Test Stage	Nominal Speed, r/min	Nominal Power, kW	Time Wt. Factor, h
1	1500	15.39	0.0802
2	800	2.18	0.0787
3	800	2.18	0.0848
4	1500	15.39	0.0864
5	1500	15.39	0.0699

TABLE 7 Calculation of BSFC

1W = 1N·m/s
1kW = 1000 N·m/s
1kW = 60 000 N·m/min
1kW = $2\pi T N/60\,000$
1kW = $T N/9549.3$
Example:
Speed = 800 r/min
Torque = 19.18 lbf·ft = 26.004 N·m
hp = $T N/5252 = (800 \times 19.18)/5252 = 2.92$
kW = $T N/9549.3 = (800 \times 26.004)/9549.3 = 2.1785052$
2.1785052 kw/746 = 2.92 hp
In SI Units:
BSFC = (fuel flow, kg/h)/(9549.3)/(speed, r/min)(Torque, N·m)
In Inch-Pound Units:
BSFC = (fuel flow, lb/h)/(5252)/(speed, r/min)(Torque, lbf·ft)

(2) FCV-150A is a Burkert Type 251 piston-operated valve used with a Type 312 solenoid valve (or a Burkert Type 2000 piston-operated valve used with a Type 311 or 330 solenoid valve) for actuation of air supply to the piston valve, solenoid valve direct-coupled to piston valve, normally closed, explosion proof (left to the discretion of the laboratory), and watertight, $\frac{3}{4}$ in., 2-way, stainless steel.

(3) FCV-150C is a Burkert Type 251 piston-operated valve used with a Type 312 solenoid valve (or a Burkert Type 2000 piston-operated valve used with a Type 311 or 330 solenoid

valve) for actuation of air supply to the piston valve, solenoid valve direct-coupled to the piston valve, normally open, explosion proof (left to the discretion of the laboratory) and watertight, $\frac{1}{2}$ in., 2-way, stainless steel.

(4) FCV-150D, FCV-150E, and FCV-150F are Burkert Type 251 piston-operated valves used with a Type 312 solenoid valve (or a Burkert Type 2000 piston-operated valve used with a Type 311 or 330 solenoid valve) for actuation of air supply to the piston valve, solenoid valve direct-coupled to the piston valve, normally closed, explosion proof (left to the discretion of the laboratory), and watertight, $\frac{1}{2}$ in., 2-way, stainless steel.

(5) Use only one type of Burkert piston and solenoid valve on a test stand.

6.6.5.5 Control valve (TCV-144 in [Figs. A2.7 and A2.8](#)) is required. The specified valve is a Badger Meter Inc. Model No. 1002TBN36SVOSALN36, 3-way globe (divert), $\frac{1}{2}$ -in., air to open valve (see [X1.17](#)).

6.6.5.6 Control valve (TCV-145 in [Figs. A2.7 and A2.8](#)) is optional (see [X1.17](#)).

6.6.5.7 A heat exchanger (HX-6 in [Figs. A2.7 and A2.8](#)) is required for oil cooling. The specified heat exchanger is an ITT model 310-20 or a ITT Bell & Gossett, model BP-25-20 (Part No. 5-686-04-020-001), brazed plate (see [X1.18](#)).

NOTE 4—The ITT Standard and ITT Bell and Gossett heat exchangers have been standardized under one model and part number. The new replacement is Model BP410-20, Part No. 5-686-04-020-002.

6.6.5.8 An electric heater (EH-5 in [Figs. A2.7 and A2.8](#)) is required for oil heating. The specified heater is a heating element inserted in the liquid Cerrobase inside a Labeco oil heater housing (see [X1.19](#)). Any 3000 W heater element may be used within the Labeco housing. There are two recommended heating elements: (1) a three element with Incoloy sheath, Chromolox Part No. GIC-MTT-330XX, 230 V, single phase, and (2) Wiegand Industries/Chromolox, Emerson Electric Model MTS-230A, Part No. 156-019136-014, 240 V single phase.

(1) It is specified that a thermocouple be installed in the external oil heater so that the temperature can be monitored. Install this thermocouple into the top of the heater into the Cerrobase (see [Fig. A2.14](#)) to an insertion depth of 244.48 ± 3.18 mm (9.625 ± 0.125 in.). Do not exceed the maximum temperature of 205°C (401°F).

(2) The procedure for replacing a heating element is detailed in [Annex A3](#).

6.6.5.9 Install two oil filters (FIL-2 in [Figs. A2.7 and A2.8](#)) in the external oil system. The filters specified are Oberg or Racor model LFS-55 with an Oberg or Racor 28-mm stainless steel screen, Part No. LFS 5528 (see [X1.20](#)).

(1) An alternative oil filter model LFS-62 with an Oberg or Racor 28-mm stainless steel screen, Part No. LFS 5528 (see [X1.20](#)), may be used.

(2) Both oil filters in the test stand shall have the same model number.

(3) Locate one filter anywhere in the external oil system after the oil circulation pump, and locate the other between the engine oil pump and where the oil enters the engine oil gallery.

(4) When replacing the test stand's oil filters to the alternative model LFE-62, do so immediately prior to a calibration test.

6.6.5.10 Adhere to the nominal piping I.D. sizing shown in [Fig. A2.8](#).

6.6.5.11 Use modified oil filter adapter assembly, Part No. OHT6A-007-1 (see [X1.21](#)), as shown in [Fig. A2.15](#).

6.6.5.12 Engine oil plumbing shall be stainless steel tubing or piping or flexible hose suitable for use with oils at the temperatures specified. Where flexible hose is used in the external oil system, excluding the line to the dump tank, use either Aeroquip No. 8 (Part No. 2807-8) or Aeroquip No. 10 (Part No. 2807-10) (see [X1.22](#)).

6.6.5.13 Insulation of plumbing for the external oil circulation system is mandatory. Insulation material selection is optional but shall have a maximum thermal conductivity of 0.0398 W/(m·K) at a mean temperature of 32.2°C (0.276 Btu-in./h-ft²·°F at a mean temperature of 90°F).

6.6.5.14 *Engine Oil Pan*—Oil pan (Ford Part No. F1AZ-6675-A or F2AZ-6675-A) is required. A modified oil pan may be fabricated by the laboratory or procured as Part No. OHT6A-006-1 (see [X1.23](#)). Remove all stock baffles from the pan. An oil pan baffle as shown in [Fig. A2.12](#) is required and installed as shown in [Figs. A2.10 and A2.11](#). These two figures also show the oil pan connections for connecting to the external oil system. Installation of viewing windows are optional as shown in [Figs. A2.10 and A2.11](#). Install a float switch (FLS-152 in [Fig. A2.7](#) and [Fig. A2.16](#), Gems Series ALS79999, Catalog No. 79999) (see [X1.14](#)) in the oil pan. The float switch may be mounted from the pan bottom as shown in [Fig. A2.10](#) or from an adjustable rod through the dipstick hole.

(1) *Oil Pan Baffle*—[Figs. A2.10 and A2.11](#) illustrate a side view of the oil pan and the position of the baffle on the left inside wall of the pan. Bend the ears on each end of the baffle about 45° toward the wall of the pan. Fit the top edge of the baffle tight against the wall and incline downward toward the front of the engine approximately 23°, with respect to the pan rail. When the baffle is tack-welded in this position the opening at the bottom of the baffle will divert the incoming stream of oil downward and a little toward the back of the pan.

6.6.5.15 *Oil Pump Screen and Pickup Tube*:

(1) Cut off the steel engine oil pick up tube immediately above the oil screen and weld a 15 to 18 cm (6 to 7 in.) long straight stainless steel tube of the same inside and outside diameters as the original tube to the end so it will project down through the fitting in the bottom of the pan. The pick up tube can be modified by the laboratory or procured as Part No. OHT6A-008-1 (see [X1.23](#)). Make the fitting in the bottom of the pan from a Swagelok SS-1210-1-8, ¾-in. compression by ½-in. NPT fitting. Cut the NPT end off and weld remaining part to the underside outside bottom of the oil pan. There will then be an inside shoulder in the fitting to drill out for the ¾-in. outside diameter (O.D.) tube to pass through (see [Figs. A2.10 and A2.11](#)).

(2) Use the double nylon ferrules (Part No. T-1213-1 and T-1214-1) to seal against the steel tube rather than metal ones to avoid crimping the wall of the tube (which can make it difficult to reseal after removing the oil pan).

(3) After the oil pan is installed on the engine and the use of a compression fitting is arranged to connect the tube to an external oil hose, the suction tube may be shortened if necessary.

6.6.5.16 *Engine Oil Level Control*—Install a sight glass tube, as shown in [Fig. A2.24](#), as a provision for monitoring the oil level and determining oil consumption. See [Annex A9](#) for instructions on oil consumption measurement/calibration.

6.7 *Fuel System*—A typical fuel delivery system incorporating all of the required features is shown in [Fig. A2.17](#). The fuel system shall include provisions for measuring and controlling fuel temperature and pressure into the fuel flow measuring equipment and into the engine fuel rail.

6.7.1 There shall be a minimum of 10 cm (3.9 in.) of flexible line at the inlet and outlet of the fuel flowmeter (rubber/synthetic suitable for use with gasoline). Compression fittings are allowed for connecting the flexible lines to the fuel flowmeter. Fuel supply lines from the fuel flow measurement equipment to the engine fuel rail shall be stainless steel tubing or piping or any flexible hose suitable for use with gasoline. The fuel return line from the engine shall have a minimum I.D. of 6.35 mm (0.25 in.).

6.7.2 *Fuel Flow Measurement*—Fuel flow rate measurement is critical and is measured throughout the test. A Micro Motion Model D-6 mass flow meter with an RFT9712 Smart Family or RFT9739 transmitter or a Model CMF010 mass flow meter with an RFT9739 transmitter is specified. Series 1700 and 2700 transmitters have also been found to be acceptable in this application (see [X1.24](#)). The Micro Motion sensor may be mounted in a vertical or a horizontal position.

6.7.2.1 Fuel flow measurement is coordinated to allow a meaningful calculation of brake specific fuel consumption in kg/kW-h (lb/hp-h). Specifically, speed, load, fuel flow, and AFR are time-averaged over the same 100 to 120-s interval. The use of frequency output from the fuel flowmeter is recommended to avoid electrical noise affecting analog signal output.

6.7.3 *Fuel Temperature and Pressure Control to the Fuel Flow Meter*—Maintain fuel temperature and pressure to the fuel flowmeter at the values specified in [Tables 2-4](#). Precise fuel pressure control without fluctuation or aeration is mandatory for test precision. The fuel pressure regulator PRG 116 shall have a safety pressure relief, or a pressure relief valve, PRV 113, parallel to PRG 116 for safety purposes.

6.7.4 *Fuel Temperature and Pressure Control to Engine Fuel Rail*—Maintain fuel temperature and pressure to the engine fuel rail at the values specified in [Tables 2-4](#). Precise fuel temperature and precise fuel pressure control without fluctuation or aeration is mandatory for test precision.

6.7.5 *Fuel Supply Pumps*—The test method of providing fuel to the fuel flowmeter is at the laboratory's discretion as long as the requirements for fuel pressure and temperature are met. For providing fuel from the fuel flowmeter to the engine fuel rail, use a car type fuel pump, Ford Part No. E7TF-9C407 or E7TC-9C407. The minimum fuel pressure is 205 kPa (30 psig) and the maximum is 310 kPa (45 psig). Purchase this part from the CPD (see [X1.38](#)).

6.7.6 *Fuel Filtering*—Filtering of the fuel supplied to the test stand is required in order to minimize fuel injector difficulties.

6.8 *Engine Intake Air Supply*—Suitable apparatus is required to deliver approximately 4.0 m³/min (140 ft³/min) of air to the engine intake air filter. The intake air supply system shall be capable of controlling moisture content, dry bulb temperature, and inlet air pressure as specified in **Tables 3 and 4**, which is 11.4 ± 0.8 g/kg of dry air (79.8 ± 5.6 grains/lb of dry air), 27 ± 2°C (80.8 ± 3.6°F), and 0.05 ± 0.02 kPa (0.2 ± 0.1 in. H₂O). The specified engine intake air system components are considered part of the laboratory intake air system and are shown in **Fig. A2.18** and in the 1993 Ford Service manual, p. 03-12-2.^{10,11}

6.8.1 *Intake Air Humidity*—Measure humidity with the laboratory’s primary humidity system. Correct each reading for non-standard barometric conditions, using the following equation:

$$\text{Humidity (corrected), grains/lb} = 4354 \times (P_{\text{sat}}/(P_{\text{bar}} - P_{\text{sat}})) \quad (1)$$

where:

P_{sat} = saturation pressure, in. Hg, and

P_{bar} = barometric pressure, in. Hg.

SI Units (Modernized Metric System):

$$\text{Humidity (corrected), g/Kg} = 621.98 \times (P_{\text{sat}}/(P_{\text{bar}} - P_{\text{sat}})) \quad (2)$$

where:

P_{sat} = saturation pressure, mm Hg, and

P_{bar} = barometric pressure, mm Hg.

6.8.2 *Intake Air Filtration*—The air supply system shall provide either water-washed or filtered air to the duct. Any filtration apparatus utilized shall have sufficient flow capacity to permit control of the air pressure at the engine.

6.8.3 *Intake Air Pressure Relief*—The intake air system shall have a pressure relief device located upstream of the engine intake air filter snorkel. The design of the relief device is not specified.

6.9 *Temperature Measurement*—The test requires the accurate measurement of oil, coolant, and fuel temperatures, and care must be taken to ensure temperature measurement accuracy. Follow the guidelines outlined by the research report.¹²

6.9.1 Check all temperature devices for accuracy at the temperature levels at which they are to be used. This is particularly true of the thermocouples used in the oil gallery, the coolant in, the inlet air, and the fuel to fuel rail. Iron-Constantine (Type J) thermocouples are recommended for temperature measurement, but either Type J or Type K (Chromel-Alumel) thermocouples may be used.

6.9.2 All thermocouples (excluding the oil heater thermocouple) shall be premium grade, sheathed types with premium

wire. Use thermocouples of 3.2 mm (1/8 in.) diameter. Thermocouple lengths are not specified, but in all cases shall be long enough to allow thermocouple tip insertion to be in mid-stream of the medium being measured. The thermocouples shall not have greater than 5 cm (2 in.) of thermocouple sheath exposed to laboratory ambient.

6.9.3 Some sources of thermocouples that have been found suitable for this application are: Leeds and Northrup, Conax, Omega, Revere, and Thermo Sensor. In any case, match thermocouples, wires, and extension wires to perform in accordance with the special limits of error as defined by ANSI in publication MC96.1-1975.

6.9.4 System quality shall be adequate to permit calibration to ±0.56°C (1°F) for individual thermocouples.

6.9.5 *Thermocouple Location*—All thermocouple tips shall be located in the center of the stream of the medium being measured unless otherwise specified.

6.9.5.1 *Oil Inlet (Gallery)*—Insert the thermocouple into the modified oil filter adapter plate so that the thermocouple tip is flush with the face of the adapter and located in the center of the stream of flow as shown in **Fig. A2.15** (that is, remove the O-ring from the adapter, place the adapter face on a flat surface, and insert the thermocouple into the adapter until the thermocouple tip is flush with the flat surface, and lock thermocouple into place).

6.9.5.2 *Oil Circulation*—Locate the oil circulation thermocouple in the tee in the rear of the oil pan where the oil from the external heat/cool circuit returns oil to the pan. The tip of the thermocouple shall be at the junction of the side opening in the tee with respect to the through passage in the tee.

6.9.5.3 *Engine Coolant In*—Locate the thermocouple tip in the center of the stream of flow and within 15 cm (5.9 in.) of the housing inlet.

6.9.5.4 *Engine Coolant Out*—Locate the thermocouple tip in the center of the stream of flow and in the coolant return neck within 8 cm (3.15 in.) of the housing outlet.

6.9.5.5 *Intake Air*—Locate the thermocouple in the Ford air cleaner assembly on the clean side of the filter as shown in **Fig. A2.18**.

6.9.5.6 *Fuel to Fuel Flowmeter*—Locate the thermocouple within 10 to 50 cm (3.9 to 19.7 in.) line length upstream of the fuel flow meter inlet.

6.9.5.7 *Fuel to Engine Fuel Rail*—Insert the thermocouple into the center of a tee or cross fitting and locate it a minimum of 15 cm (5.9 in.) downstream of the fuel pump and within 15 cm (5.9 in.) line length of the fuel rail inlet.

6.9.5.8 *Load Cell*—Locate the thermocouple within the load cell enclosure.

6.10 *AFR Determination*—Determine engine air-fuel ratio (AFR) by an AFR analyzer. Analysis equipment shall be capable of near continuous operation for 30-min periods.

6.10.1 The AFR analyzer shall meet the following specifications:

Measurement Range	AFR: 10.00 to 30.00 with H/C = 1.85, O/C = 0.00
Accuracy	±0.1 AFR when 14.7 AFR with H/C = 1.85, O/C = 0.000

¹⁰ If you are aware of alternative suppliers, please provide this information to ASTM International Headquarters. Your comments will receive careful consideration at a meeting of the responsible technical committee,¹ which you may attend.

¹¹ The sole source of supply of the apparatus known to the committee at this time is HELM, Inc., 14310 Hamilton Avenue, Highland Park, MI 48203.

¹² Supporting data have been filed at ASTM International Headquarters and may be obtained by requesting Research Report D02-1218.

Temperature of exhaust gas used by sensor: -7 to 900°C. A Horiba model MEXA 110 analyzer has been found suitable for this application (see [X1.25](#)).

6.10.2 The specified location of the analyzer sensing element in the exhaust system is shown in [Fig. A2.19](#).

6.11 *Exhaust and Exhaust Back Pressure Systems*:

6.11.1 *Exhaust Manifolds*—Use production cast iron exhaust manifolds, Ford Part No. F1AZ-9430 or F1AE-9430 (Casting No. RF F1AE-9430-BB) for right hand and Part No. F1AZ-9431 or F1AE-9431 (Casting No. RF F1AE-9431-BB) for left hand.

6.11.2 *Laboratory Exhaust System*—The exhaust system specified is shown in [Fig. A2.19](#). Components can be radially oriented to ease installation, but install all components in the order shown. The design of the system downstream from the location shown in [Fig. A2.19](#) is at the discretion of the laboratory.

6.11.3 *Exhaust Back Pressure*—The exhaust system shall have the capability for controlling exhaust back pressure to the pressures specified in [Tables 2-4](#). The specified exhaust back pressure probe is shown in [Fig. A2.20](#), and the specified exhaust back pressure probe location in the exhaust system is shown in [Fig. A2.19](#).

6.12 *Pressure Measurement and Pressure Sensor Locations*—Pressure measurement systems for this test method are specified in general terms of overall accuracy and resolution with explicit pressure tap locations specified. Pressure devices (such as electronic transducers) shall follow the guidelines outlined by the research report.¹²

6.12.1 Connecting tubing between the pressure tap locations and the final pressure sensors should incorporate condensation traps as directed by good engineering judgement. This precaution is particularly important when low air pressures (as in this test method) are transmitted by way of lines that pass through low-lying trenches between the test stand and the instrument console. Pressure sensors should be mounted at the same elevation as the pressure taps.

6.12.2 *Engine Oil*—Locate the pressure tap for the engine oil pressure at the oil filter adapter. Accuracy of 1 % with 6.9 kPa (1 psi) resolution is required.

6.12.3 *Fuel to Fuel Flowmeter*—Locate the pressure tap within 5 m from the fuel inlet of the fuel flow meter. Accuracy of 3.5 kPa (0.5 psi) is required.

6.12.4 *Fuel to Engine Fuel Rail*—Locate the pressure tap a minimum of 15 cm (5.9 in.) from the outlet of the car type fuel pump and within 15 cm (5.9 in.) line length of the inlet to the fuel rail. Accuracy of 3.5 kPa (0.5 psi) is required.

6.12.5 *Exhaust Back Pressure*—Locate the exhaust back pressure probe as shown in [Fig. A2.19](#). The sensor shall be accurate to within 2 % of full scale with resolution of 25 Pa (0.1 in. H₂O).

6.12.6 *Intake Air*—Measure the intake air pressure at the location shown in [Fig. A2.18](#). Sensor/readout accuracy required is 2 % of full scale with resolution of 5.0 Pa (0.02 in. H₂O).

6.12.7 *Intake Manifold Vacuum/Absolute Pressure*—Measure the intake manifold vacuum/absolute pressure at the

throttle body adapter. A sensor having accuracy within 1 % of full scale and with 0.68 kPa (0.1 in. Hg) resolution is required.

6.12.8 *Coolant Flow Differential Pressure*—See [6.5.9](#).

6.12.9 *Crankcase Pressure*—Locate the crankcase pressure tap as detailed in [Annex A12](#) and [Fig. A2.22](#).

6.13 *Engine Hardware and Related Apparatus*—This section describes engine-related apparatus requiring special purchase, assembly, fabrication, or modification. Part numbers not otherwise identified are Ford service part numbers.

6.13.1 *Test Engine Configuration*—The test engine is a 1993 4.6-L Ford V-8 engine equipped with fuel injection. Purchase the engine as a test ready unit (for procurement, see [X1.3](#)). The engine may not be disassembled and shall be used in an as-received condition. Only external engine dress items are to be installed by the laboratory.

6.13.2 *ECM/EEC (Engine Control) Module*—Use a special modified ECM/EEC IV, Part No. OHT6A-002-1 engine control module, Ford part name SMO-100 (see [X1.26](#)). This module controls ignition and fuel supply functions.

6.13.3 *Thermostat/Orifice Plate*—Use an orifice plate as shown in [Fig. A2.21](#) in place of the thermostat. The orifice plate can be fabricated by the laboratory or procured as Part No. OHT6A-004-1 (see [X1.27](#)).

6.13.4 *Intake Manifold*—Modify the intake manifold, Part No. F1AZ-9424-C, F1AE-9424, or F1AE-9425. Plug the intake manifold coolant bypass passage (port under the orifice plate).

6.13.5 *Flywheel*—A manual flywheel, Part No. F6ZZ-6375-AB, is required. Modify the flywheel according to laboratory practice to allow for connection to the test stand driveshaft. Purchase this part from the CPD (see [X1.38](#)).

6.13.6 *Wiring Harnesses*—Two wiring harnesses are used. One is a fuel injector sub-harness and the other is an engine ECM/EEC wiring harness. The fuel injector sub-harness is to be one of the following part numbers: F3VB-12522, F3VB-12A522, F3AB-12A522, F2AZ-9D930-A, F3AZ-12A522, or F3BL-12A522. These harnesses are available from the CPD (see [X1.38](#)) and are similar to that shown in the 1993 Ford service manual, Figure K16182-A, p. 18-01-21. Disconnect items 11, 14, 21, and 23 shown in Figure K16182-A from the harness. The other wiring harness is a special dyno engine wiring harness, Part No. OHT6A-001-1 (see [X1.28](#)) and is used to connect the car-type harness to the ECM/EEC.

NOTE 5—A full size version of the schematic may be obtained from the TMC; see [X1.2](#).

6.13.7 *EGR Block-Off Plate*—Remove the EGR valve and replace with a block-off plate, which is to be fabricated by the laboratory. Cut off the EGR tube near the exhaust manifold, crimp and weld shut or plug.

6.13.8 *Oil Pan*—Use oil pan, Part No. F1AZ-6675-A or F2AZ-6675-A. Modify the oil pan as detailed in [6.6.5.14](#) and [Figs. A2.10-A2.13](#).

6.13.9 *Oil Pump Screen and Pickup Tube*—Use oil pump screen and pickup tube, Part No. F2AZ-6622. Remove the oil pump screen and modify the pickup tube as detailed in [6.6.5.15](#).

6.13.10 *Idle Speed Control Solenoid (ISC) Block-Off Plate*—Remove the idle speed control solenoid (idle air bypass valve) and replace with a block-off plate, which is to be fabricated by the laboratory.

6.13.11 *Engine Water Pump*—Modify or replace as detailed in 6.5.10.

6.13.12 *Thermostat Housing*—Use thermostat housing, Part No. F1VY-8592-A or F1AE-8594. Modify for engine coolant out thermocouple installation (see 6.9.5.4) or procure as Part No. OHT6A-010-1 (see X1.29).

6.13.13 *Oil Filter Adapter*—Use oil filter adapter, Part No. F1AZ-6881, F1AE-6881, or F1AE-6884. Modify for engine coolant in thermocouple installation (see 6.9.5.3) or procure as Part No. OHT6A-009-1 (see X1.30).

6.13.14 *Fuel Rail*—Use fuel rail, Part No. F2AZ-9F792-A or F2AE-9F792. Purchase this part from the CPD (see X1.38). Modify the fuel rail inlet and outlet connections for connection to the laboratory fuel supply system.

6.14 *Miscellaneous Apparatus Related to Engine Operation:*

6.14.1 *Timing Light*—Use an inductive pickup-type timing light during the test. (**Warning**—Some types of timing lights will read out double the actual ignition timing when used on this engine.)

7. Reagents and Materials

7.1 Engine Oil:

7.1.1 ASTM Baseline Calibration Oil (BC) (see X1.2) is used for new engine break-in and as a primary calibration oil for evaluation of test oils. It is an SAE 5W-30 grade. Approximately 38 L (10 gal) of BC oil are required for each test.

7.1.2 ASTM BC Flush Oil (BCFHD) (see X1.2) is a special flushing oil (BC oil with increased solubility) that is used when changing oil after a test oil has been in the engine. Approximately 6 L (6.34 qt) of Flush Oil are required for each test.

7.2 *Test Fuel*—Use only Haltermann (see X1.37) HF 003 fuel.^{10,13} Specification for HF 003 fuel is contained in Table 1. (**Warning**—Danger! Extremely flammable. Vapors harmful if inhaled. Vapors may cause flash fire (see A6.2.2.1).)

7.2.1 Make certain that all tanks used for storage are clean before they are filled with test fuel.

7.2.2 *Laboratory Fuel Sampling and Analysis*—The need for this action and analytical methods to be used are under study by ASTM D02.B0.01. Upon determination, an Information Letter will be published by the Test Monitoring Center.

7.2.3 *Fuel Batch Usage/Documentation*—A complete test sequence shall be run on a single batch of test fuel. If a new batch of test fuel is introduced to the laboratory fuel supply system, it shall be done between finite tests. Document the fuel batch designation in the test report. In cases where the run tank contains more than one fuel batch, document the most recent fuel batch in the report.

7.3 *Engine Coolant*—The engine coolant shall be 50/50 volume % commercial additized ethylene glycol coolant/water. Water shall be deionized, demineralized, or distilled.

7.4 *Cleaning Materials:*

7.4.1 *Organic Solvent Penmul L460*—See X1.32. (**Warning**—Harmful vapor. Store at moderate temperature (see A6.2.2.2).)

7.4.2 *Solvent*—Use only mineral spirits meeting the requirements of Specification D235, Type II, Class C for Aromatic Content (0-2% vol), Flash Point (142°F/61°C, min) and Color (not darker than +25 on Saybolt Scale or 25 on Pt-Co Scale). (**Warning**—Combustible. Health hazard.) Obtain a Certificate of Analysis for each batch of solvent from the supplier.

7.4.3 *Engine Cooling System Cleanser*—Consists of the following (see X1.34): (**Warning**—Toxic substance. Avoid contact with eyes, skin, and clothing (see A6.2.2.4).)

7.4.3.1 *Oxalic Acid Dihydrate Tech.* (**Warning**—Toxic substance. Avoid contact with eyes, skin, and clothing (see A6.2.2.5).)

7.4.3.2 *Alkylated Naphthalene, Sodium Salt*—Petro Dispersant 425 (soap).

7.4.3.3 *Soda Ash Light*—Neutralization.

8. Preparation of Apparatus

8.1 This section assumes that the engine test stand facilities and hardware as described in Section 6 are in place. Emphasis is on the recurring preparations needed in the routine conduct of the test.

8.2 *Test Stand Preparation:*

8.2.1 *Instrumentation Preparation*—Perform the calibration of the temperature measuring system, the dynamometer load measuring system, the fuel flow measuring system, and the pressure measuring system (see 10.2 for additional details concerning instrumentation calibration) in a manner consistent with good laboratory practices and record it for future reference.

8.2.2 *External Oil System Cleaning*—Clean the entire external oil system using cleaning solvent (see 7.4.1) each time a newly built engine is installed.

8.2.3 *Exhaust Back Pressure Probe Renewal*—The exhaust back pressure probe can be used until it becomes cracked, brittle, or deformed. Clean the outer surface of the probe and clear all port holes. Check the probe for possible internal obstruction and reinstall the probe in the exhaust pipe. Stainless steel probes are generally serviceable for several tests; mild steel probes tend to become brittle after fewer tests.

8.2.4 *AFR Sensor Renewal*—Inspect AFR sensor (see 10.2 for AFR system calibration requirements).

8.2.5 *Hose Replacement*—Inspect all hoses and replace any that are deteriorated. Check for internal wall separations, which would cause flow restriction.

9. Engine Preparation

9.1 Purchase the engine as a test ready unit (for procurement, see X1.3). The engine will not be disassembled and shall be used in an as-received condition. The only exceptions are external engine dress items are to be installed by the laboratory

¹³ The sole source of supply of the apparatus known to the committee at this time is Haltermann Products, 1201 South Sheldon Road, P.O. Box 429, Channelview, TX 77530-0426.

and the valve stem seals can be replaced when necessary. Utilize Ford service parts for a 1993 model year engine or Sequence VIB parts.

9.2 *Cleaning of Engine Parts:*

9.2.1 *Cleaning*—Soak any parts to be cleaned in degreasing solvent until clean (see [X1.33](#)).

9.2.2 *Rinsing*—Wash the parts thoroughly with hot water.

9.3 *Engine Assembly Procedure:*

9.3.1 *General Assembly Instructions*—Assemble the external engine dress components according to the detailed description in the 1993 Ford Service Manual. However, in cases of disparity, the explicit instructions contained in this test method take precedence over the service manual. Additional information is available in the Ford 543 Engine Assembly Manual, 1999 Edition.¹⁴

9.3.2 *Bolt Torque Specifications*—When installing the engine components, use a calibrated torque wrench to obtain the values specified. Specifications are shown in the 1993 Ford Service Manual. These specifications are for clean and lightly lubricated threads only. Dirty or dry threads produce friction, which prevents accurate measurements of the actual torque. It is important that these specifications be observed. Over tightening can damage threads, which may prevent attainment of the proper torque and may require replacement of the damaged part.

9.3.3 *Sealing Compounds*—Sealing compounds are not specified. Use engineering judgement governing the use of sealing compounds. Do not use sealers in tape form (loose shreds of tape can circulate in the engine oil and plug critical orifices).

NOTE 6—Silicone-based sealers may raise the indicated Si content of used oil.

9.3.4 New parts required for each new engine (see [X1.3](#)) are listed in [Annex A4](#).

9.3.5 *Harmonic Balancer*—The balancer, Part No. F1AZ-6316-A, is included on the engine by the engine supplier.

9.3.6 *Oil Pan*—Install the oil pan, Part No. F1AZ-6675-A or F2AZ-6675-A, modified as detailed in [6.6.5.14](#) and as shown in [Figs. A2.10-A2.13](#). Use gasket, Part No. F1AZ-6710-A. Torque the bolts in the sequence shown in 1993 Ford Service Manual, Figure A14940-B, p. 03-01-39.

9.3.7 *Intake Manifold*—Install intake manifold, Part No. F1AZ-9424-C, F1AE-9424, or F1AE-9425. Modify the intake manifold as detailed in [6.13.4](#). Purchase this part from the CPD (see [X1.38](#)). Use gaskets, Part No. F1AZ-9461-A. Torque the bolts in the sequence shown in 1993 Ford Service Manual, Figure A14812-A, p. 03-01-32.

9.3.8 *Camshaft Covers*—Camshaft covers are, right hand, Part No. F1AZ-6582-A; left hand, Part No. F1AZ-6582-B. Use gaskets, right hand, Part No. F1AZ-6584-A; left hand, Part No. F1AZ-6584-B. These are included on the engine by the engine supplier.

9.3.9 *Thermostat*—Remove the thermostat and replace with a thermostat orifice plate as shown in [Fig. A2.21](#) (see [X1.27](#)). See [6.13.3](#).

9.3.10 *Thermostat Housing*—Install a modified thermostat housing (see [6.13.12](#)), Part No. F1VY-8592-A, F1AE-8594, or OHT 6A-01010-1 (see [X1.12](#)). Use gasket, Part No. F1VY-8255-A.

9.3.11 *Coolant Inlet*—Modify the coolant inlet connection, which is cast as a part of the oil filter adapter (see [9.3.12](#) and [6.13.13](#)).

9.3.12 *Oil Filter Adapter*—The oil filter adapter is Part No. F1AZ-6881, F1AE-6881, or F1AE-6884 and is included on the engine by the engine supplier. Modify the adapter (see [6.13.13](#)). Use gasket, Part No. F1AZ-6840-A.

9.3.13 *Dipstick Tube*—Dipstick tube, Part No. F1AZ-6754-A is included on the engine by the engine supplier.

9.3.14 *Water Pump*—Install a modified water pump or a water pump plate (see [6.5.10](#) and [Fig. A2.6](#)).

9.3.15 *Sensors, Switches, Valves, and Positioners:*

9.3.15.1 *Oil Pressure Switch and Oil Pressure Sensor*—Install oil pressure switch, Part No. E9SZ-9278-A. The oil pressure sensor may be removed and the location plugged.

9.3.15.2 *Camshaft Positioner Sensor (CMP)*—Camshaft position sensor, Part No. F1AZ-6B288-A, is included on the engine by the engine supplier.

9.3.15.3 *Crankshaft Position Sensor (CKP)*—Crankshaft position sensor, Part No. F1AZ-6C315-A, is included on the engine by the engine supplier.

9.3.15.4 *Water Temperature Indicator Sender Unit*—Install water temperature indicator sender unit, Part No. F1SZ-10884-A or F1SF-10884.

9.3.15.5 *Idle Speed Control Solenoid (ISC)*—Idle air control valve (idle air bypass valve) is not used; replace with a block-off plate (see [6.13.10](#)).

9.3.15.6 *EGR Valve*—The EGR valve is not used. Replace with a block-off plate (see [6.13.7](#)).

9.3.15.7 *EGR Valve Positioner Sensor (EVP)*—EGR valve position sensor is not used.

9.3.15.8 *EGR Vacuum Regulator Sensor (EVR)*—EGR vacuum regulator sensor is not used. Plug the vacuum lines that would normally be connected to this sensor.

9.3.15.9 *Throttle Position Sensor (TP)*—Install throttle position sensor, Part No. F2AZ-9B989-A or FZAF-9B989. Purchase this part from the CPD (see [X1.38](#)).

9.3.15.10 *Engine Coolant Temperature Sensor (ECT)*—Install engine coolant temperature sensor, Part No. F2AZ-12A648-A or F2AF-12A648. Purchase this part from the CPD (see [X1.38](#)).

9.3.15.11 *Heated Exhaust Gas Oxygen Sensors (HEGO)*—Use heated exhaust gas oxygen sensors, Part No. F0TZ-9F472, F0SZ-9F472-A, F1SZ-9F472-A, or XL3Z-9F472. Make sure that the HEGO's are correctly connected. The left side (cylinders 5-8) sensor harness has a red with black stripe wire coming from the bottom right pin of the connector when looking at the plug from the front. The right side sensor (cylinders 1-4) has a gray with light blue striped wire in this position. Purchase this part from the CPD (see [X1.38](#)).

9.3.15.12 *PCV*—Remove the PCV valve and vent all PCV points of connection to the crankcase pressure control system as detailed in [Annex A12](#) and [Fig. A2.22](#) (see [6.12.9](#)). Plug all associated vacuum lines.

¹⁴ Available from the ASTM Test Monitoring Center Web Page at <http://www.astmtmc.cmu.edu/>