

Land Rover Series IIA 1961-1971 Workshop Manual



Fig. A-3—Layout of components, to this point

Cylinder bores and walls, to refit

Operation A,196

1. Remove the sealing ring grooves in the crankcase end of cylinder block bores, and the bore sealing rings, with Shimor M54 Compressor, then fit a ring in the upper and lower grooves of each bore.

A small hole is drilled through the ring, then the outside groove is used to check for evidence of instant leakage past the ring.



Fig. A-10—Checking cylinder bore extension

2. Press the bores into their respective bores to test and align the marks made while disassembling.
3. Clamp each bore in turn in the manner described and tighten the securing bolts to 95 lbf ft (12.8 Nm) torque. Mount a dial test indicator and check that the outer edge of the cylinder bore is from .002 to .004 in. (.0508 to 0.1016 mm) above the cylinder head joint face. See Fig. A-10. Adjust if necessary by increasing bore and adding a suitable shim washer under the flange. Clamp and re-check bore as described above. Shim washers are available .002 in. (0.0508 mm) and .004 in. (0.1016 mm) thick.

Pistons and rings, to refit Operation A,198

1. When fitting pistons, the clearance in bore hole should be as follows: with the dimensions laid down in the Data Section. In the absence of exactly accurate measuring instruments, a long feeler, .004 in. (0.1016 mm) thick, may be inserted in the lower side of the lower bore, as illustrated in Fig. A-15, and the piston forced across diameter and the feeler pin in line with the centre line of cylinder block. The piston should become a tight fit when the feeler is about under the bore.
2. Check the piston ring gaps in the lower bores, using an old piston as shown in Fig. A-14, to keep the rings square in the bore.



Fig. A-14—Checking piston clearance

A—Piston gauge B—Piston C—Lower bore

3. The second and third compression rings are forced edge and must be fitted with the side marked "T" uppermost; the top chrome-plated compression and the oil scraper ring has a square friction edge and may be fitted either way. Fit the piston rings and check the clearance in ring grooves. See Data Section.

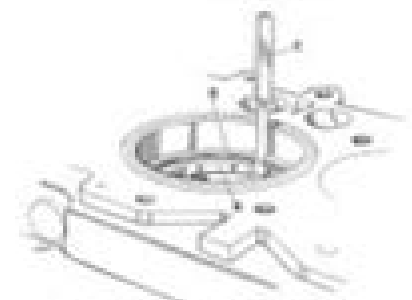


Fig. A-15—Checking piston ring and

A—Scrap piston B—Scrap ring C—Piston gauge

It will be seen that provision is made for the fitting of two oil scraper rings. The second groove is for service purposes only.

Connecting rod checks Operation A,200

1. Check that the connecting rods and caps have not been filed, in the following manner.
2. Select the correct cap for each connecting rod, as dictated by the number stamped near the joint face. The number also indicates the mark to which it must be fitted.

Assemble the connecting rods, low dust bearings, with corresponding marks together.

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Table of Contents Land Rover Series Iia Workshop Manual

1. Understanding the eBook Land Rover Series Iia Workshop Manual
 - The Rise of Digital Reading Land Rover Series Iia Workshop Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying Land Rover Series Iia Workshop Manual
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Land Rover Series Iia Workshop Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from Land Rover Series Iia Workshop Manual
 - Personalized Recommendations
 - Land Rover Series Iia Workshop Manual User Reviews and Ratings
 - Land Rover Series Iia Workshop Manual and Bestseller Lists
5. Accessing Land Rover Series Iia Workshop Manual Free and Paid eBooks
 - Land Rover Series Iia Workshop Manual Public Domain eBooks
 - Land Rover Series Iia Workshop Manual eBook Subscription Services
 - Land Rover Series Iia Workshop Manual Budget-Friendly Options

6. Navigating Land Rover Series Iia Workshop Manual eBook Formats
 - ePub, PDF, MOBI, and More
 - Land Rover Series Iia Workshop Manual Compatibility with Devices
 - Land Rover Series Iia Workshop Manual Enhanced eBook Features
7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Land Rover Series Iia Workshop Manual
 - Highlighting and Note-Taking Land Rover Series Iia Workshop Manual
 - Interactive Elements Land Rover Series Iia Workshop Manual
8. Staying Engaged with Land Rover Series Iia Workshop Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Land Rover Series Iia Workshop Manual
9. Balancing eBooks and Physical Books Land Rover Series Iia Workshop Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Land Rover Series Iia Workshop Manual
10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
11. Cultivating a Reading Routine Land Rover Series Iia Workshop Manual
 - Setting Reading Goals Land Rover Series Iia Workshop Manual
 - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of Land Rover Series Iia Workshop Manual
 - Fact-Checking eBook Content of Land Rover Series Iia Workshop Manual
 - Distinguishing Credible Sources
13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
14. Embracing eBook Trends
 - Integration of Multimedia Elements

- Interactive and Gamified eBooks

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