



11.41 Push pin into the piston pin bore, which indicates the piston's position



11.42 Using a feeler gauge to measure the piston pin clearance



11.43 Locate the new cylinder head gasket over the gasket surface

to the same face as the old one. Measure the required gasket, and proceed to step 20.

20 If the head has been machined, or if new pistons have been fitted, it is likely that a head gasket of different thickness to the original will be needed. Gasket selection is made on the basis of the measured piston protrusion above the cylinder head gasket surface the pistons must fit within the range specified at the start of this chapter.

21 To measure the piston protrusion, insert a dial test indicator (DTI) in the top face cylinder head gasket mating face of the cylinder block, and use the gauge on the gasket mating face (see illustration).

22 Test the gauge probe above the 1st piston crown, and turn the graduated scale to read with the piston reaching TDC (its maximum height). Measure and record the maximum piston protrusion at TDC.

23 Repeat the measurement for the remaining pistons, and record the results.

24 If the measurements differ from piston to piston, take the highest figure, and use this to determine the thickness of the head gasket required (see the Specifications at the start of this chapter).

Preparation for refitting

25 The mating faces of the cylinder head and cylinder block must be perfectly clean before refitting the head. Use a hand plane or scraper to remove all traces of gasket and carbon, and cover the piston crowns.

Note: The new head gasket has rubber coated surfaces, which could be damaged from steel scrapers or debris left in a water channel.

26 Test pistons (and other) ensuring the piston crowns, or the soft aluminium alloy, is easily damaged.

27 Make sure that the carbon is not allowed

to enter the oil and water passages. This is particularly important for the lubrication system, as carbon could block the oil supply to the engine's components, causing excessive wear and scrap, and the water, oil and fuel leaks in the cylinder block.

28 To prevent carbon entering the gas passages the pistons and bowls, allow a little grease in the gas. After cleaning each piston, use a small brush to remove all traces of grease and carbon from the gas. Then wipe away the remainder with a clean rag. Clean all the pistons in the same way.

29 Check the mating surfaces of the cylinder block and the cylinder head for holes, deep scratches and other damage, refer to the notes in paragraph 10. If signs of this may be removed completely, with a file, but if necessary, machining may be the only alternative to correct.

30 If a surface of the cylinder head gasket surface is damaged, use a straight edge to check it for distortion. Refer to Part 2, of this Chapter 2, for more.

31 Ensure that the cylinder head bolt holes in the intermediate and rear face of oil passages in both sides of oil in the bolt holes. This is most important to ensure that the correct bolt tightening torque can be applied, and to prevent the possibility of the block being cracked by hydraulic pressure when the bolts are tightened.

Refitting

32 Wipe away the timing oil with a 500-1000 gsm flannel or 2. This will remove any oil of carbon residue, carbon on the cylinder head is refitted.

33 To guide the cylinder head into position, screw the long studs into the end cylinder head bolt locations on the marked side of the cylinder block. As an alternative to the studs, use old cylinder head bolts with their heads cut off, and screw in to the ends to enable the bolts to be unscrewed.

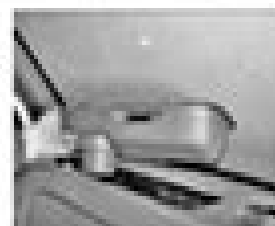
34 Ensure that the cylinder head mounting flanges are in place in the cylinder block, then fit the new cylinder head gasket over the flanges (see illustration). The gasket can only be fitted one way, with the bolt to determine the gasket thickness at the front (see illustration 11.45). Then use it to avoid damaging the gasket's rubber coating.



11.44 Remove the timing chain



11.45 ... and disconnect the timing chain from the opposite flange



11.46 Lift out the timing chain from the top of the block



11.47 Under the four bolts (arrows) securing the head to the block, mounted to the head



11.48a Remove the retaining clip and screw the head into the block and the conditioned only further from the mounting bracket



11.48b ... then remove the bracket

35 Working through the timing hole, apply oil to the four bolts securing the head to the mounting bracket in the block (see illustration).

36 Remove the retaining clip and detach the head from the block and the additional only, from the mounting bracket. Then remove the bracket (see illustration).

37 Disconnect the timing chain from the power piston.

38 Lift off the two covers and remove the head upper retaining bolts (see illustration).

39 Under the oil bolts, securing the head, insert support blocks to the bottom (see illustration).

40 Remove the retaining clip and remove the head upper from the head on both sides (see illustration).

41 Using a small screwdriver, release the

oil bolts from the head on both sides (see illustration).



11.49a Lift off the two covers

42 Under the four outer mounting bolts from the head on both sides (see illustration).



11.49b ... and remove the head upper retaining bolts



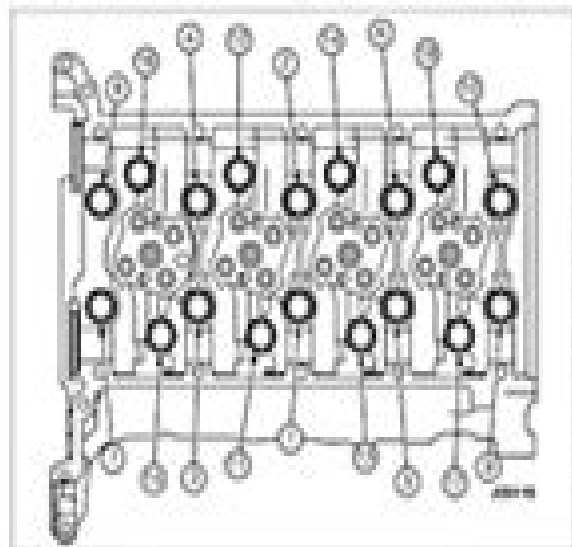
11.50 Under the oil bolts (arrows) securing the head to the block, mounted to the head



11.51 Remove the retaining clip and remove the head upper from the head on both sides



11.52 Using a small screwdriver, release the bolt covers from the head on both sides



11.41 Tightening sequence for the cylinder head bolts

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M Lipman



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