

Land Rover Series IIA 1961-1971 Workshop Manual



Fig. A-1—Layout of components, by size, prior

Cylinder bores and walls, to refit

Operation A,196

1. Remove the mating ring grooves in the crankcase end of cylinder block bores, and the bore mating 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 hole is drilled through the bore to avoid oil leakage past the ring.



Fig. A-10—Checking cylinder bore extension

2. Press the piston into the bore, ensuring the piston is seated and the mating hole is aligned.
3. Clamp each bore in turn in the manner described and tighten the securing bolts to 95 lbf ft (12.8 N.m). Measure a dial test indicator and check that the outer edge of the cylinder bore is from .002 to .004 in (0.050 to 0.10 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 (0.05 mm) and .004 in (0.10 mm) thick.

Pistons and rings, to refit Operation A,198

1. When fitting pistons, the clearance in bore hole should be in accordance with the dimensions laid down in the Data Section. In the absence of suitable accurate measuring instruments, a long feeler, .004 in (0.10 mm) wide thick, may be inserted in the lower side of the lower bore, as illustrated in Fig. A-11, and the piston moved across the bore 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 bore, using an old piston as shown in Fig. A-14, to keep the rings square in the bore.



Fig. A-11—Checking piston clearance

A—Piston gauge B—Feeler C—Lower piston

3. The second and third compression rings are fitted 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.

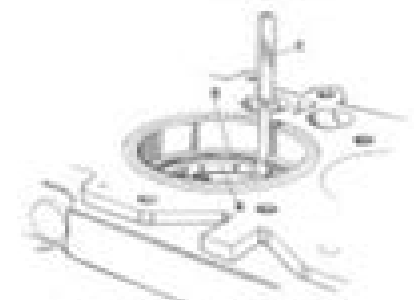


Fig. A-14—Checking piston ring and

A—Feeler gauge B—Feeler ring C—Feeler 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 fitted, in the following manner.
2. Select the correct cap for each connecting rod, as detailed by the number stamped near the joint face. The number also indicates the weight to which it must be fitted.

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

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