

12. Continue precautions against fragmentation for a few minutes, as the insert may shatter a short time after firing.
13. Pull in the new valve guide, using tool Part No. 262753.
14. Repeat items 1 to 4 inclusive.

#### Exhaust rocker shafts assembly

##### Operation A/48

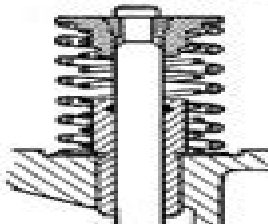
*Note.*—When fitting a replacement rocker or cam-follower, it is essential that the component be fitted with the special protective coating of grease still adhering.

1. Fit new bushes in the rockers and followers as necessary and drill through the 1/16 in. (1.58 mm) oil feed hole. The bush must be a light drive fit in the rocker or follower and a sliding fit on the shaft. Ream in position to .593 in. +.001 (15.081 mm + 0.025).
2. Replace shafts by inserting front shaft through the locating hole and assembling component parts in the following order: spring; R.H. rocker; washer; R.H. cam-follower; L.H. cam-follower; washer; L.H. rocker; spring.
3. Repeat for rear shaft, ensuring that, with both shafts in position, the oil feed holes in the rocker shafts are facing towards the cylinder block. The front of each shaft is marked 'F'.
4. Fit the plugs and fibre washer; for tappet adjustment see Operation A/54.

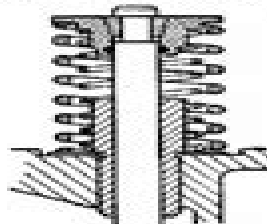
#### Inlet valves

##### Operation A/50

1. Cut the valve seats (in cylinder head) to  $30^\circ \pm 1$  only when necessary; normally they require cutting only at every second or third decarbonising operation.
2. Face the valves to  $30^\circ \pm 1$  and lap into their respective seats.
3. Wash each valve, seat, port and guide in paraffin.
4. Locate each valve into their respective guides and, using compressor Part No. 276102, fit the spring assembly, caps and split cones. A new 'O' ring seal must be fitted to each guide.



Later seal



Early seal

Fig. A-21

#### To fit new guides

5. Remove the guide with a drift, Part No. 263051.
6. Press in the new guide, and ream to .3448 in. — .0005 (8.757 mm — 0.012).
7. Repeat items 1-4, noting that the seat must be ground in the event of a new guide being fitted.

#### Cylinder head and rocker gear

##### Operation A/52

1. Smear the joint face of cylinder block and cylinder head gasket with engine oil, then fit the gasket and cylinder head to cylinder block.
2. Locate head and gasket with the securing bolts, fitting all bolts except those which also secure the rocker shaft pedestals, but do not tighten at this stage.
3. Insert the push-rods into their original position, through cylinder head and locate in the cam-followers.
4. Fit new bushes in the rockers as necessary. The bush must be a light drive fit in the rocker and a sliding fit on the shaft. Press a new bush in with its shoulder on the same side as the rocker pad; drill through the oil feed holes—7/64 in. (2.77 mm) to the push-rod and 1/16 in. (1.58 mm) in the top of the rocker. Ream in position to .005 in. + .001 (12.7 mm + 0.025).



Fig. A-22—  
Drilling oil feed holes

5. Fit the component parts to the rocker shafts in the following order:  
Rear bracket (located by set screw); spring; R.H. rocker; bracket; L.H. rocker; two brackets; spring; R.H. rocker; bracket; L.H. rocker; spring; front bracket.
6. Fit the rocker shaft to the cylinder head. When in position, the oil feed holes in the rocker shaft must face the push-rods. Tighten all the bolts down in the manner illustrated by Fig. A-23: 1/2 in. bolts to 50 lb./ft. (7 mKg); 3/8 in. bolts to 30 lb./ft. (4 mKg).

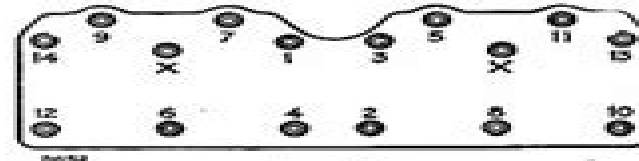


Fig. A-23—  
Order of tightening cylinder head bolts. Those marked X also secure the rocker shaft.

# Land Rover Series I Full Service Repair Manual 1948 1958

**Marco Cascella**



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