

Land Rover Series IIA 1961-1971 Workshop Manual



Fig. A-13—Assembled piston and connecting rod

Cylinder bores and walls, to refill Operation A-194

1. Remove the cooling ring grommets at the crankcase end of cylinder block bores, and the lower cooling rings, with Mueser M54 Compressor, then fit a ring to the upper and lower grommets of each bore.

A small hole is drilled through the side of the block into the middle grommet to provide an indicator of coolant leakage past the ring.



Fig. A-15—Checking cylinder bore diameter

2. Place the bore into their respective bores in block and scribe the marks made while the measuring.
3. Clamp each bore in turn in the master die, record and tighten the recording bolts to 45 lbf-ft (61 mkg) torque. Mount a dial test indicator and check that the outer edge of the cylinder bore is true to .002 to .004 in. (0.025 to 0.1 mm) along the cylinder bore axis line. See Fig. A-17. 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. (0.025 mm) and .004 in. (0.10 mm) thick.

Pistons and rings, to refill Operation A-195

1. When fitting pistons, the clearance in bore must be checked by an micrometer with the dimensions laid down in the Data Section. In the absence of specially accurate measuring instruments, a long feeler, .004 in. (0.1024 mm) thick, may be inserted in the lowest part of the bore bore, as illustrated in Fig. A-17, and the piston located across diameter and the gageless gap in line with the centre line of cylinder block. The piston should become a light fit when the feeler is slid across the bore.
2. Check the piston ring gaps in the lower bores, using an oil piston as illustrated in Fig. A-14, to keep the rings square in the bore.



Fig. A-14—Checking piston clearance
A—Feeler gauge B—Piston C—Lower piston

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

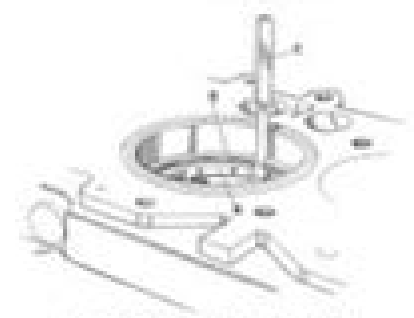


Fig. A-16—Checking piston ring gap
A—Feeler gauge B—Piston ring C—Piston gauge

It will be seen that provision is made for the fitting of two oil scraper rings. The second grommet 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 end face. The number also indicates the weights to which it must be fitted.
- Assemble the connecting rods, low dust bearings, with corresponding caps together.

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Richard Hall



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